

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 AND CAUTIONS. USE THIS 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. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.**

## 1. SAFETY INSTRUCTIONS

### 1.1. ELECTRICAL SAFETY. **WARNING! It is the user's responsibility to read, understand and comply with the following:**

You must check all electrical equipment and appliances to ensure they are safe before using. You must inspect power supply leads, plugs and all electrical connections for wear and damage. You must ensure the risk of electric shock is minimised by the installation of appropriate safety devices. An RCCB (Residual Current Breaker) should be incorporated in the main distribution board. We also recommend that an RCD (Residual Current Device) is used with all electrical products. It is particularly important to use an RCD with portable products that are plugged into an electrical supply not protected by an RCCB. If in doubt consult a qualified electrician. You may obtain a Residual Current Device by contacting your Sealey dealer. **You must** also read and understand the following instructions concerning electrical safety.

1.1.1. The **Electricity At Work Act 1989** requires all portable electrical appliances, if used on business premises, to be tested by a qualified electrician, using a Portable Appliance Tester (PAT), at least once a year.

1.1.2. The **Health & Safety at Work Act 1974** makes owners of electrical appliances responsible for the safe condition of the appliance and the safety of the appliance operator. **If in any doubt about electrical safety, contact a qualified electrician.**

1.1.3. Ensure the insulation on all cables and the product itself is safe before connecting to the mains power supply. See 1.1.1. & 1.1.2. above and use a Portable Appliance Tester (PAT).

1.1.4. Ensure that cables are always protected against short circuit and overload.

1.1.5. Regularly inspect power supply, leads, plugs for wear and damage and all electrical connections to ensure that none is loose.

1.1.6. **Important:** Ensure the voltage marked on the product is the same as the electrical power supply to be used and check that plugs are fitted with the correct capacity fuse. A 13 amp plug may require a fuse smaller than 13 amps for certain products, see fuse rating at right.

1.1.7. **DO NOT** pull or carry the powered appliance by its power supply lead.

1.1.8. **DO NOT** pull power plugs from sockets by the power cable.

1.1.9. **DO NOT** use worn or damaged leads, plugs or connections. Immediately replace or have repaired by a qualified electrician. A U.K. 3 pin plug with ASTA/BS approval is fitted. In case of damage, cut off and fit a new plug according to the following instructions (discard old plug safely).

(UK only - see diagram at right). **Ensure the unit is correctly earthed via a three-pin plug.**

a) **Connect the GREEN/YELLOW earth wire to the earth terminal 'E'.**

b) **Connect the BROWN live wire to live terminal 'L'.**

c) **Connect the BLUE neutral wire to the neutral terminal 'N'.**

b) **After wiring, check that there are no bare wires, that all wires have been correctly connected, that cable outer insulation extends beyond the cable restraint and that the restraint is tight.**

Double insulated products are fitted with live (BROWN) and neutral (BLUE) wires only. Double insulated products are always marked with this symbol . **To re-wire, connect the brown & blue wires as indicated above. DO NOT connect the brown or blue to the earth terminal.**

1.1.10. Some products require more than a 13 amp electrical supply. In such a case, **NO** plug will be fitted. **You must** contact a qualified electrician to ensure a 30 amp fused supply is available. We recommend you discuss the installation of an industrial round pin plug and socket with your electrician.

1.1.11. **Cable extension reels.** When a cable extension reel is used it should be fully unwound before connection. A cable reel with an RCD fitted is recommended since any product which is plugged into the cable reel will be protected. The section of the cores of the cable is important. We suggest 1.5mm<sup>2</sup> section as a minimum but to be absolutely sure that the capacity of the cable reel is suitable for this product and for others that may be used in the other output sockets, we recommend the use of 2.5mm<sup>2</sup> section cable.

### 1.2 GENERAL SAFETY

**WARNING!** Disconnect the saw from the mains power before changing saw blades and accessories, servicing or performing maintenance.

Mount the saw to a secure surface such as the stand supplied or a workbench. Keep area clean and tidy and free from unrelated materials and ensure there is adequate lighting.

Maintain the saw in good condition (use authorised service agent only).

Replace or repair damaged parts. *Use recommended parts only. Unauthorised parts may be dangerous and will invalidate the warranty.*

Keep the machine clean and the blade sharp for best and safest performance. Check moving parts alignment regularly.

Before each use check saw blade condition. If worn or damaged replace immediately.

Place the blade guard to within 1/8" of the material being cut.

**WARNING!** Keep all safety guards and holding screws in place, tight and in good working order.

Check regularly for damaged parts. A guard or any other part that is damaged should be repaired or replaced before the saw is next used. The safety guard is a mandatory fitting.

Remove adjusting keys and wrenches from the saw before turning it on.

Wear approved safety eye protection, ear defenders, safety gloves and, if dust is generated, respiratory protection.

Remove ill fitting clothing. Remove ties, watches, rings, and other loose jewellery, and contain long hair.

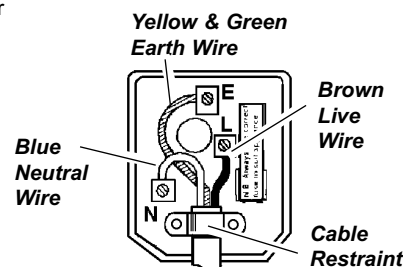
Maintain correct balance and footing. Ensure the floor is not slippery and wear non-slip shoes.

Keep children and unauthorised persons away from the working area.

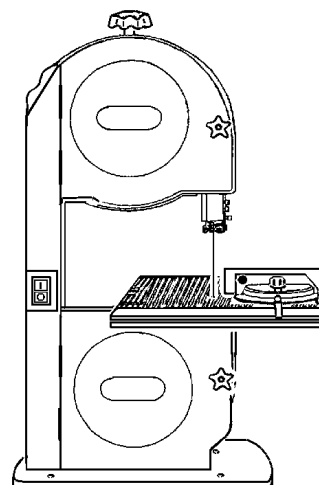
Secure unstable work piece with a clamp, vice or other adequate holding device.

Avoid unintentional starting.

Keep hands and fingers at a safe distance from the saw blade, especially at the end of a cut. Guide the work with a piece of wood or push rod rather than your fingers when cutting small pieces.



**FUSE RATING**  
THIS PRODUCT MUST BE FITTED  
WITH A  
**13 AMP FUSE**



## 1.2 GENERAL SAFETY Continued

- ✓ Disconnect the saw from the power supply before removing wood chips or dust.
- ✓ Use a workpiece support when sawing material which extends beyond the saw table.
- x **DO NOT** operate the machine if damaged.
- x **DO NOT** operate the machine if any parts are missing as this may cause failure and/or personal injury.
- x **DO NOT** use saw blades which are damaged or deformed. Use only Sealey blades and spare parts. Non-standard blades can be dangerous.
- x **DO NOT** get the saw wet or use in damp or wet locations or areas where there is condensation.
- x **DO NOT** expose the saw housing to flame or high temperature.
- x **DO NOT** allow untrained persons to operate the saw.
- x **DO NOT** use saw where there are flammable liquids, solids or gases such as paint solvents and including waste wipers or cleaning rags etc.
- x **DO NOT** leave the saw operating unattended.
- x **DO NOT** operate the saw if either of the blade covers is open or if the blade guard is not fitted.
- x **DO NOT** operate the saw when you are tired or under the influence of alcohol, drugs or intoxicating medication.
- x **DO NOT** use the saw for a task it is not designed to perform.
- ✓ When not in use switch off the saw and unplug from the mains power.

## 2. DESCRIPTION & SPECIFICATION

The SM64 2-speed bandsaw is designed for cutting wood, plastic and thin sheet metal and is equipped with a tilt table, fence, mitre gauge and stand.

Throat Depth . . . . .305mm  
 Max. Cutting Height . . . . .135mm  
 Cutting Speeds . . . . .370 & 780m/min  
 Blade Length . . . . .2234mm  
 Motor Power . . . . .1.1kW  
 Power Supply . . . . .230V.AC. - 1ph

Table Size . . . . .495 x 390 mm  
 Table Adjustment . . . . .0 to 45°  
 Dust Extraction Port . . . . .Ø70mm  
 Weight . . . . .65kg

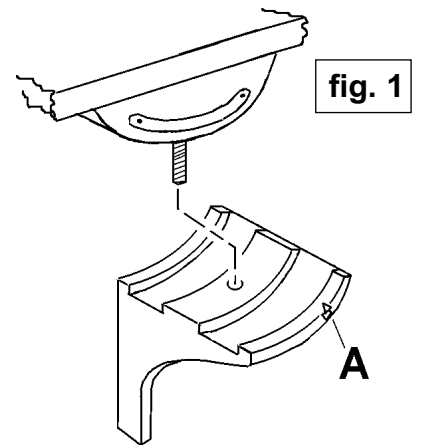
## 3. ASSEMBLY

Unpack the product and check contents for damage. Should there be any damaged or missing parts contact your supplier immediately.

Package content: Bandsaw, Table, Fence, Mitre Gauge, Knob (table lock), Hex. Wrench x 2, Stand components (12 legs/rails, nuts, bolts, washers)

### 3.1. Saw Assembly

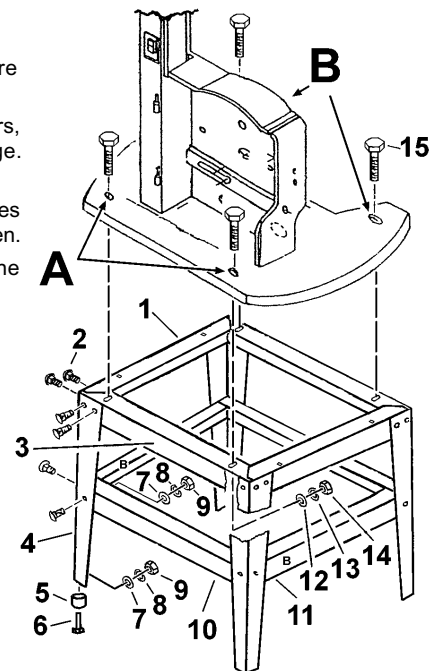
- 3.1.1. Loosen the four knobs (fig.3.A) beneath the table and remove the table side guide (fig.3.B). Remove the aligning pin (fig.3.C) from the table edge.
- 3.1.2. Place the table onto the saw frame, sliding the saw blade through the slot in the table and engaging the clamp bolt in the hole in the table bracket (see fig.1).
- 3.1.3. Screw the lock knob (fig.3.D) onto the bolt and tighten to retain table.
- 3.1.4. Re-fit the table aligning pin and the side guide.
- 3.1.5. Using a set square, position table at right angles to the blade and then adjust pointer (fig.1.A) to align with 0° on table scale.
- 3.1.6. **Important!** Bolt saw to the stand provided (see 3.2) or to a firm, stable work surface capable of supporting the saw and any workpiece. **DO NOT** attempt to use the saw as a free-standing unit as it may topple over during use and cause damage and/or personal injury.
- 3.1.7. Connect extraction port (fig.3.E) to dust extractor system (if available).



### 3.2. Stand Assembly (fig. 2)

- 3.2.1. Select the two pairs of upper rails (1 & 3). The upper rails are identified by two square mounting holes at each end.
- 3.2.2. Take one of the shorter upper rails (1) and attach a leg (4) to each end using bolts, washers, lock washers and nuts (2, 7, 8 & 9) to form an inverted 'U'. Do not tighten at this stage. Repeat for the second rail.
- 3.2.3. Join the two inverted 'U's with the two longer upper rails (3). Note that the horizontal flanges of the longer rails go under those of the shorter rails. Use fixings as above and do not tighten.
- 3.2.4. Fit the lower rails (one square mounting hole at each end). The horizontal flanges of the shorter rails (11 - stamped 'B') go under those of the longer rails (10).
- 3.2.5. Tighten all fittings.
- 3.2.6. Fit a rubber foot (5) to each leg, using bolts, washers, lock washers and nuts (6, 7, 8 & 9).
- 3.2.7. Attach the saw to the stand using bolts, washers, lock washers and nuts (15, 12, 13 & 14).

**Note:** The pair of holes 'A' in the saw base are spaced differently from the pair 'B'. The rails (3) are pierced to suit and therefore the saw will only fit the stand in one position.



## 4. ADJUSTMENTS

**WARNING! ENSURE THE BANDSAW IS DISCONNECTED FROM THE MAINS POWER SUPPLY BEFORE ATTEMPTING ANY ADJUSTMENTS.**

### 4.1. Changing the blade

- 4.1.1. Turn the two blade cover knobs (fig.3.F) anticlockwise to open the upper and lower covers.
- 4.1.2. Loosen upper blade guide lock (fig.3.G) and fully lower guide. Tighten lock.
- 4.1.3. Undo the three blade guard mounting screws (fig.3.A) and remove the guard.
- 4.1.4. Remove the table side guard and the aligning pin (see 3.1.1.).
- 4.1.5. Turn the blade tension knob (fig.3.H) anticlockwise to slacken the blade and then carefully remove the blade.
- 4.1.6. Install the new saw blade. Be sure the teeth are pointing down and to the front.

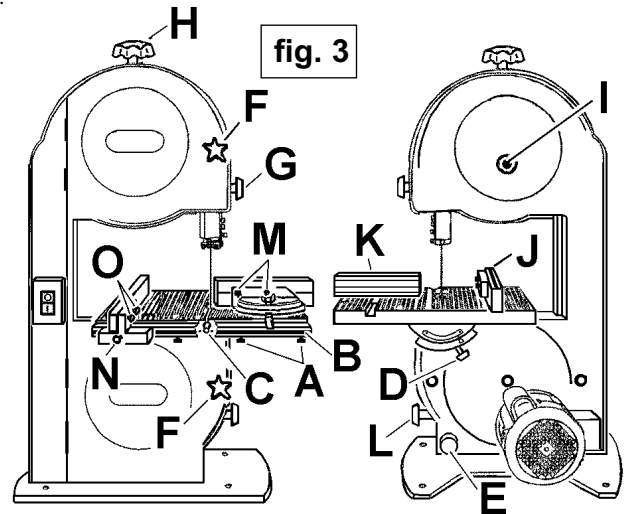
- 4.1.7. Adjust new blade to the correct tension (see 4.2.) and check, and adjust if necessary, tracking (see 4.3.) and blade guide adjustment (see 4.5.).
- 4.1.8. Reinstall the blade guard, the table aligning pin and the side guide.
- 4.1.9. Close both blade covers and tighten retaining knobs.

**4.2. Adjusting blade tension**

- 4.2.1. Open blade covers and ensure that blade is centred on both wheel rims.
- 4.2.2. Turn the blade tension knob (fig.3.H) - clockwise to tighten, anticlockwise to slacken - to adjust the blade tension. Correct tension is reached when the blade gives slightly to firm finger pressure at mid-span. Do not over-tighten.
- 4.2.3. Close both blade covers and tighten retaining knobs.

**4.3. Adjusting blade tracking**

- 4.3.1. Open blade covers and carefully rotate upper wheel clockwise, by hand, to determine whether blade is tracking correctly - on the centre of each wheel rim.
- 4.3.2. If adjustment is needed, turn the tracking knob (fig.3.I) whilst continuing to turning the upper blade wheel. Note the effect on the tracking and adjust tracking knob until tracking is correct.
- 4.3.3. Close both blade covers and tighten retaining knobs.

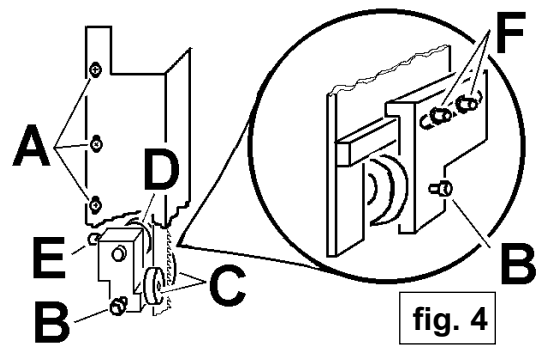


**4.4. Upper blade guide position**

- 4.4.1. The upper blade guide should always be adjusted to about 3mm (1/8") above the workpiece. To adjust, loosen the adjusting knob (fig.3.G) and move the assembly to the required position. Tighten adjusting knob.

**4.5. Upper and lower blade guide adjustment**

- 4.5.1. Remove the upper blade guard from the upper blade guide by undoing screws (fig.4.A).
- 4.5.2. Loosen clamp screws (fig.4.B) on upper and lower guides (fig.5.A). Rotate shafts of upper guide bearings (fig.4.C) so that bearings do not touch blade and pull lower guides (fig.5.B) away from the blade.
- 4.5.3. The upper blade support bearing (fig.4.D) prevents the saw blade from being pushed too far back when cutting. It should be adjusted to 0.75mm (1/32") behind the blade by loosening the screws (fig.4.F), positioning the bearing and then tightening the screws.
- 4.5.4. Loosen screw (fig.4.E) and adjust support bearing (fig.4.D) so that centre of bearing race is in line with blade.
- 4.5.5. Adjust the upper guide bearings (fig.4.C) so that each is just clear of the side of the blade and the bearing edges are just behind the roots of the blade teeth. Tighten the clamp screws (fig.4.B).
- 4.5.6. Adjust the lower guide bearings (fig.5.B) so that each is just clear of the side of the blade. Tighten the clamp screws (fig.5.A).
- 4.5.7. Loosen screws (fig.5.C) and move the guide bracket in or out until the front edges of the guides are just behind the teeth roots. Tighten screws.
- 4.5.8. Adjust the lower blade support bearing to 0.75mm (1/32") behind the blade by loosening screw (fig.7.D). When adjustment is correct retighten screw.



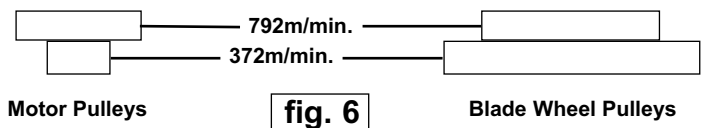
- Notes:
- a) Always check and adjust both upper and lower guides at the same time.
  - b) Always carry out these checks/adjustments every time the blade is changed.
  - c) The blade will be damaged if the teeth contact the guides/guide bearings.

**4.6. Drive belt**

- 4.6.1. Open lower blade cover and check belt tension. Belt should have approx. 5mm mid-span deflection under finger pressure.
- 4.6.2. To adjust belt tension turn tension knob (fig.3.L).

**4.7. Blade speed**

- 4.7.1. Open lower blade cover and remove all belt tension by turning tension knob (fig.3.L).
- 4.7.2. Move belt to the required pair of pulleys. See fig.6.
- 4.7.3. Tension belt (see 4.6.) and close cover.

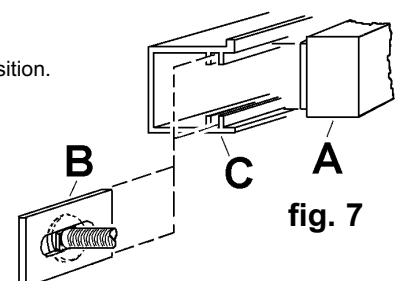


**4.8. Mitre gauge**

- 4.8.1. The mitre gauge (fig.3.K), which locates in either of the two table slots, is adjustable through 60° in either direction. Loosen the central locking knob, adjust and then tighten locking knob. The two knobs (fig.3.M) allow the mitre fence to be adjusted with respect to the angle plate.

**4.9. Fence**

- 4.9.1. The fence (fig.3.J) is mounted on the table side guide (fig.3.B). Fig.7 shows the relationship between the fence mount (A), the clamp plate (B) and the side guide (C).
- 4.9.2. To reposition, or remove, fence loosen lock knob (fig.3.N). Retighten when fence is in new position.
- 4.9.3. Loosen knobs (fig.3.O) to reposition fence with respect to the fence mount. Retighten.



## 5. OPERATING INSTRUCTIONS

### 5.1. Cross cutting

To cut wood at right angles to the grain. This type of cut can be made freehand but using the mitre guide ensures accurate results. The guide can also be adjusted to a 45° angle to produce mitre cuts, or compound mitre cuts with the table tilted. Ensure the work is held firmly against the table and against the face of the mitre guide.

**WARNING!** Keep your fingers away from the blade, particularly at the end of the cut.

### 5.2. Freehand

When freehand cutting, select the widest blade suitable for cutting the smallest radius in the work you have planned (see below). Always feed the work slowly to follow your saw line. Ensure you do not drag the work off-line forcing the blade sideways or twisting it. It may be helpful to make an initial rough cut about 5mm away from the line. For difficult curves which may be too tight for the blade, make relief cuts on the face of the curve so that the waste wood will fall away as the final radius is cut.

Blade width	Minimum cutting radius
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1/8"	5mm
1/4"	16mm
3/8"	35mm

### 5.3. Blade and blade speed selection

5.3.1. The hardness of the workpiece determines the blade speed required. Soft materials (light wood) - high speed, hard materials (metals) - low speed.

5.3.2. There should be at least three saw teeth in contact with the workpiece at any one time during cutting. Therefore the thinner the workpiece the higher the blade tpi required.

### 5.4. Bevel cutting

When bevel cutting with the table tilted always have the workpiece guide (fence or mitre) on the lower part of the table.

### 5.5. Workpiece stability

Any workpiece which does not have a flat surface which will ensure stability on the saw table **must be** held in a suitable device which will prevent rotation.

## 6. MAINTENANCE

**WARNING!** ENSURE THE MACHINE IS DISCONNECTED FROM THE MAINS POWER SUPPLY BEFORE CARRYING OUT ANY MAINTENANCE.

### 6.1. Changing tyres

Eventually the tyres on the bandsaw wheels will wear due to the constant contact with the blade teeth.

Lift the edge of the tyre with a small screwdriver and the tyre can be worked off the wheel easily. It is recommended that both tyres be changed at the same time.

### 6.2. Blade guides

Blade guides should be inspected regularly for wear or chipping. When replacing guides, replace all guides at the same time, both upper and lower.

### 6.3. Table insert

The insert should be inspected regularly and replaced if wear or damage is found.

### 6.4. Bearings

All bearings used in the construction of the bandsaw and motor are sealed and lubricated for life.

### 6.5. Cleaning

Remove dust and chips from the inside of the bandsaw frequently. Open the front covers and use a brush or vacuum cleaner. At the end of every work session, clean sawdust away from the motor vents.

## 7. DECLARATION OF CONFORMITY

**Declaration of Conformity** We, the sole importer into the UK, declare that the product listed here is in conformity with the following standards and directives.

**305mm 2-Speed Bandsaw  
Model SM64**

73/23/EEC Low Voltage Directive  
98/37/EC Machinery  
89/336/EEC EMC Directive  
93/68/EEC CE Marking Directive.



The construction file for this product is held by the Manufacturer and may be inspected, by a national authority, upon request to Jack Sealey Ltd.

Signed by Mark Sweetman

Date 12th May 2000

For Jack Sealey Ltd. Sole importer into the UK of Sealey Quality Machinery.

**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 product.

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

**INFORMATION:** For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name and address, including postcode.



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