

BS-24SA-DM

SCIE À RUBAN À MÉTAL
METAL BAND SAW
METALLBANDSÄGE



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INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However, if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Setup and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any modifications.



Note: This symbol refers to useful information throughout the manual.



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**

Follow recommended precautions and safe operating practices.



UNDERSTAND SIGNAL WORDS

A signal word – **DANGER, WARNING, or CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

DANGER: Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

DANGER

WARNING: Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

WARNING

CAUTION: Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

CAUTION

NOTICE: Indicates a situation which, if not avoided, could result in property damage.

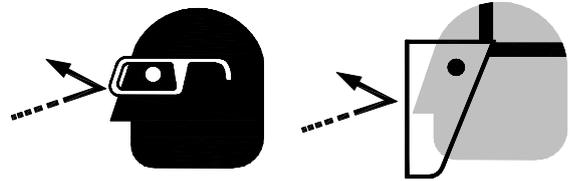
NOTICE

SAVE THESE INSTRUCTIONS.

Refer to them often and use them to instruct others.

PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



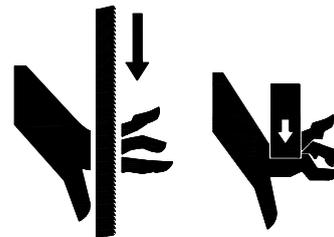
HIGH VOLTAGE

USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT assume the power to be off. **FOLLOW PROPER LOCKOUT PROCEDURES.**



BEWARE OF CUT AND PINCH POINTS

Moving saw blade may result in loss of fingers or limb. **DO NOT** operate with guard removed. **Follow lockout/tagout procedures before servicing.**



EMERGENCY STOP BUTTON

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button. Twist the emergency stop button clockwise (cw) to reset. Note: Resetting the E-Stop will not start the machine.



SAFETY PRECAUTIONS

Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard will not make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility

WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

Dear Valued Customer:

- All Baileigh machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

PLEASE ENJOY YOUR BAILEIGH MACHINE!PLEASE ENJOY IT SAFELY!

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 machines rated capacity.
9. **Use the right tool for the job. DO NOT** 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 appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
12. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
13. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
14. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
16. **Blade adjustments and maintenance.** Always keep blades sharp and properly adjusted for optimum performance.
17. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
18. **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.
19. **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.
20. **DO NOT** touch live electrical components or parts.
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!**
25. **DO NOT** bypass or defeat any safety interlock systems.
26. Keep visitors a safe distance from the work area.

TECHNICAL SPECIFICATIONS

Stock Number	BS-24SA-DM-3PH
Round (90°)	18.1" (460mm)
Round (45°)	17.5" (445mm)
Round (60°)	11.6" (295mm)
Square (90°)	18.1 x 18.1" (460 x 460mm)
Square (45°)	17.5" x 17.5" (445 x 445mm)
Square (60°)	11.6" x 11.6" (295 x 295mm)
Rectangular (90°)	17.3" x 23.6" (440 x 600mm)
Blade Size (H x W x L)	1.6" X .051" x 209.84" (41 x 1.3 x 5330mm)
Blade Speed (fpm)	98-298 Carbide Roller
Blade Guide	Carbide / Roller
Miter Angle	0 - 60° (L & R)
Miter Adjustment	Dual Miter Swivel Head
Descent Control	Pressure Assist. Hydraulic
Return	Hydraulic
Drive	Belt / Pulley
Power Supply	415V, 3Ph, 50hz
Blade Motor	3.7kW/5HP, 50Hz, 400V, 7.8A, 3 Ph, 4P, 1730RPM
Hydraulic Motor	0.75kW/1HP, 50Hz, 400V, 3 Ph, 4P, 2.0A
Coolant Motor	1/6HP, 400V, 50Hz, 3Ph, 2P, 0.24A
Hydraulic Capacity	8.1gal (31L)
Coolant Capacity	18.75gal (71L)
Shipping Dimensions (L x W x H)	112" x 45" x 74" (2830 x 1140 x 1860mm)
Shipping Weight	3,234 lbs. (1470 kgs.)

TECHNICAL SUPPORT

Our technical support department can be reached at **+44(0)24 7661 9267** and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at:

+44 (0)24 7661 9267 or sales-uk@toolfrance.com



Note: The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.



Note: The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.

UNPACKING AND CHECKING CONTENTS

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

WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.
If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

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.

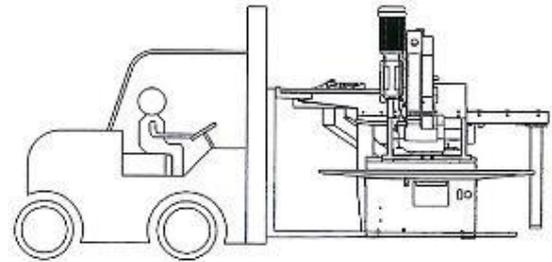


TRANSPORTING AND LIFTING

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 fork lift 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.



INSTALLATION

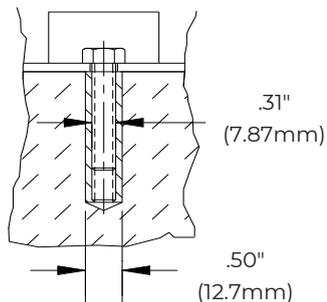
IMPORTANT:

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, work tables, 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.

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.



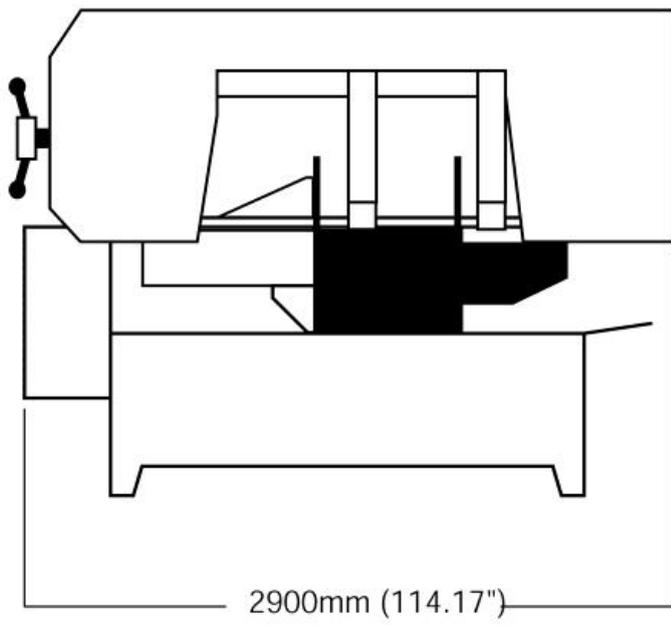
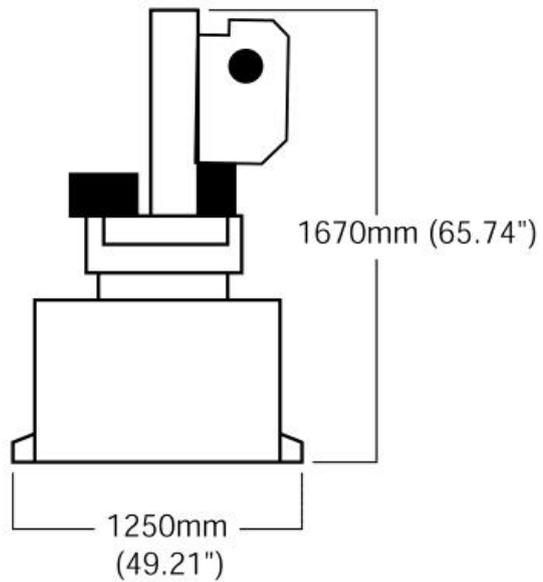
Tank Filling

The hydraulic oil is the primary medium for transmitting pressure and also must lubricate the running parts of the pump.

After installation of the machine and before machine startup, bring the oil level up to 90% of capacity. Verify that any cylinder rams are in the retracted position to prevent overfilling of the tank. Recheck the oil level after the first few hours of operation and again after the first full week of operation.

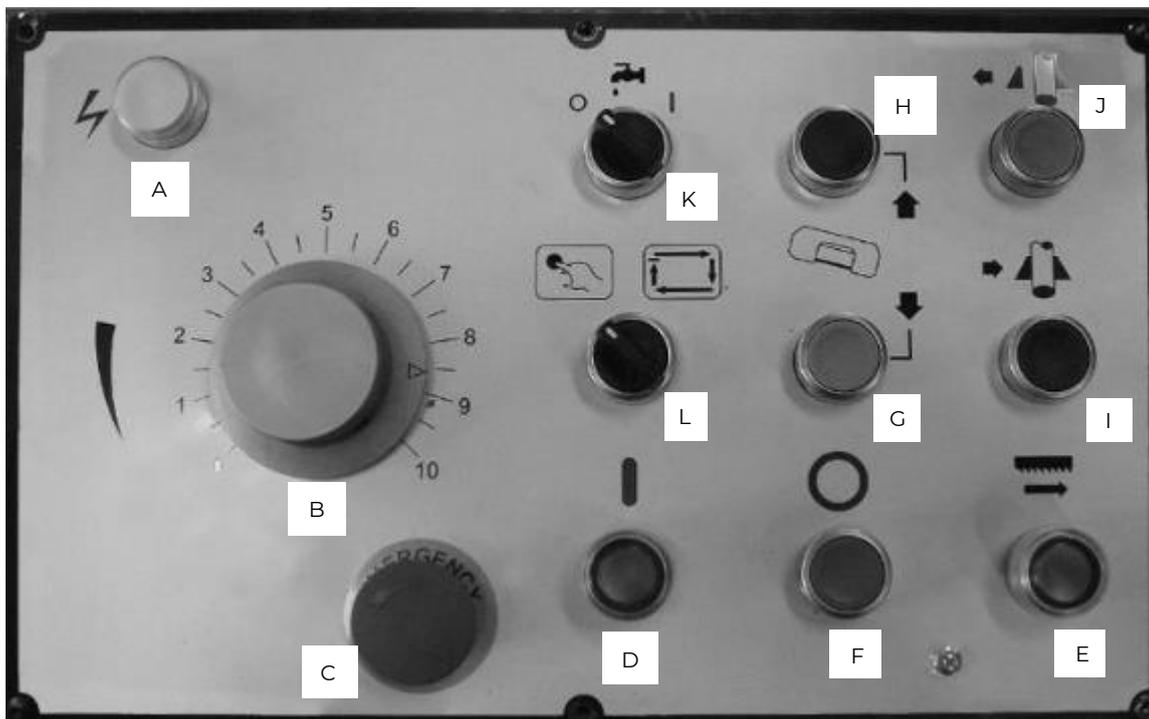
A shortage of hydraulic oil can cause hydraulic system breakdown and damage to major mechanical parts due to overheating.

OVERALL DIMENSIONS



GETTING TO KNOW YOUR MACHINE

Control Panel



A	Main Power Indicator Light – Indicates that main power is active.
B	Hydraulic Flow Control Valve: Turn clockwise to increase bow down rate, counter-clockwise to decrease the cutting rate.
C	Emergency Stop Button – Press to stop all machine functions.
D	Hydraulic Start Switch – Activates hydraulic power.
E	Start Blade – Press to start cutting cycle; blade start and the saw bow descends. NOTE: Before blade starting, press vise close button to clamp work piece well.
F	Stop Cutting - Press to stop cutting cycle.
G	Bow Down Button - Press to descend the saw bow.
H	Bow Up Button – Press to raise the saw bow.
I	Vise Close Button – Press to close the vise.
J	Vise open Button – Press to open the vise.
K	Coolant start switch – Turn right to activate or turn left to stop coolant flow.
L	Manual/Auto mode Switch–selects either automatic or manual operation mode.

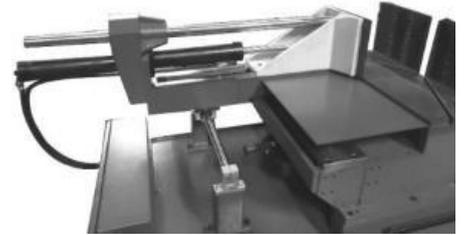
Saw Bow

Machine parts are consisting of drive members (gear motor, variable speed motor, and flywheels), Tightening and guide (blade tightening slide, blade guide blocks) of tool.



Vise System

A hydraulic vise is used for clamping work material. Each of the vises has a miter slot, which is good for the right or left side's angle cutting to 60°.



Base

The base is the structure supporting the saw bow (the bow pivot point and respective blocking system), the vises, and containing chip tray and coolant system.



Chip Tray

Removable chip tray for capture of chips and debris.



Blade Broken Micro Switch

This machine is equipped with automatic power shut-off safety device to prevent any further damage when a blade has been broken or loses tension. When the blade tension handle is turned, the adjustment bolt presses the plunger on the switch actuates micro switch.

To keep the micro switch in proper contact with the blade's tension, an adjustment of the actuator bolt may be required.

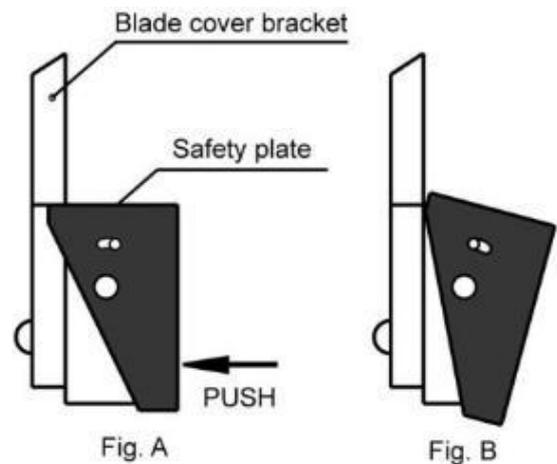


Open Blade Cover Safety Device

When blade cover is open, power will be removed from the system operation controls.

To close the blade cover:

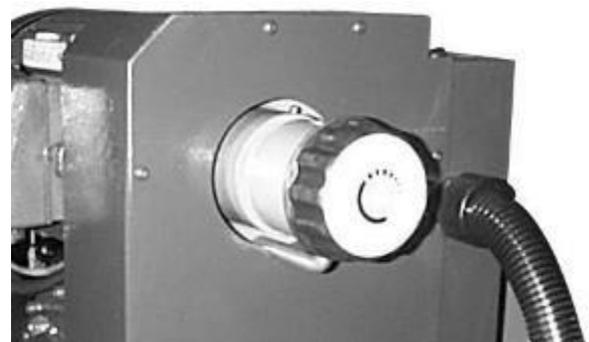
- Use one hand on the cover handle to hold the blade cover.
- Use the other hand to push in the safety plate (Fig. A), so the bracket will release (Fig. B).
- Lower the cover down slowly and carefully.



Speed Change Dial

The speed change dial adjusts the variable speed transmission in blade speed. Change only while blade is moving.

This machine has a variable speed transmission using a variable pulley - system. The speed is changed by rotating the speed changer dial to adjust the width of the pulley discs. When compressed, the pulley discs cause the belt to ride the outer edge of pulley discs and changing the speed. The speed must be changed while belt is moving.



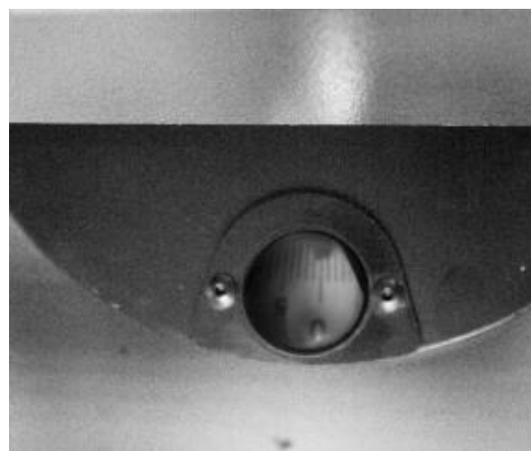
Chip Brush

This model has a powered chip brush driven by an axle transfer from the drive motor. The chip brush is designed to clean the blade thus prolonging the life of the blade.



Blade Angle Scale

The scale indicates the cutting angle of the blade. The scale has preset stops at every 15°.



Attached Coolant Device

An attached coolant device that is screwed on the front vise jaw for supply enough coolant to the cutting material. This device can be unscrewed and move to the rear vise jaw for easy both side miter cutting.



Saw Bow Upper /Lower Limit Switches

The saw bow travel is controlled by the up and down limit switches.

The up-limit switch stops the bow at the position in which it contacts the orange contact paddle. The paddle is adjustable to for easy adjustment to stop the bow up position as soon as the blade is clear of the material. This shortens the cut cycle.

Bow Height Adjusting Plate

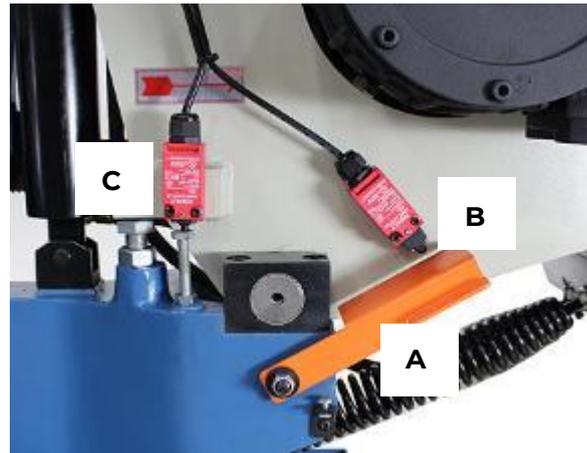
The adjusting plate (A) can be adjusted up or down by hand as needed to increase or decrease the height that the bow raises between cutting cycles.



Note: Tighten the pivot nut if the plate will not hold position.

Set the height so that the teeth of the blade are at least 0.5" - 0.75" (13 - 20mm) above the work material at the top of the stroke.

This will provide clearance for the material to advance while also reducing operation cycle time.



Bow Down Limit Switch

The bow down limit switch (C) stops the descent of the saw bow at the bottom of the cut.

The down limit switch contacts a bolt head and is set at the factory to provide a stop point at the bottom of the cut once the blade has cut through the material.

Once the down limit switch is activated, the blade will stop, and the bow will raise until it is stopped by the up-limit switch.

The material may be advanced, and the next cut will begin.

Guide Post

The guide posts are the two posts that suspend down from a rail, and straddle the blade with carbide and roller bearings to support and guide the blade through the cut.

The back side (right as shown) guide post is stationary and does not move.

The front side (left as shown) is repositioned to allow for varying material sizes. It is to be set as close to the material as possible without interfering with the blade, vise or material.



Filler Cover

The filler cover is located at the front of the saw table. The filler cover should be removed whenever the saw is cutting at an angle and when the vise is to be moved to the front side of the blade.

Remove the filler cover by pulling on the handle and lifting up and off when the tabs have unlocked from the main table.



Miter Angle Lock Lever

The pivot platform is the structure that holds the saw bow and rotates horizontally for miter cutting up to 60° to the right and 60° to the left. Pull the lever to the right to release and turn bow to the desired angle. Once the bow is at the desired angle, push the lever to the left to lock the position.

IMPORTANT: When the bow is in the 90° or angled from 1° to 60° to the right, the vise must be positioned to the left side of the saw bow.

The vise must be positioned to the right of the saw bow when cutting angles from 1° to 60° to the left. Failure to follow this guideline will damage the vise and possibly other saw components.



Vise System

The vise is a hydraulic system that allows it to be clamp manually and automatically. The operator can open the vise quickly and easily after the cut to remove and / or advance the material. The vise may be shifted from the left (normal) side of the bow to the right side of the bow when cutting left angles.



IMPORTANT: When the bow is in the 90° or angled from 1° to 60° to the right, the vise must be positioned to the left side of the saw bow.

The vise must be positioned to the right of the saw bow when cutting angles from 1° to 60° to the left. Failure to follow this guideline will damage the vise and possibly other saw components.

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.

The mounting hardware (bolts and washers) used to assembly the accessories to the saw are installed into the mounting location holes for shipping. Remove and retain the fasteners from the mounting locations and then secure the accessory item to the saw with these fasteners.

Installing the Rear Coolant Return Tray

- The rear coolant-return tray must be installed after the machine is set in place. Install the coolant return trays first.

Installing Three Channeled L-Bracket

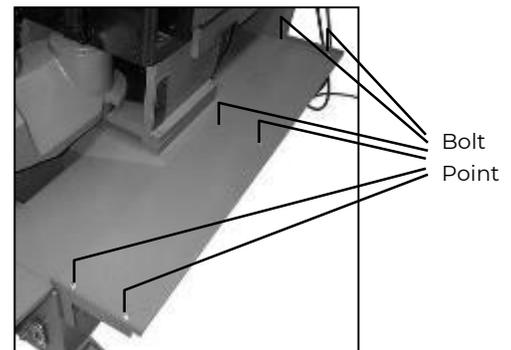
- Install three channeled L-bracket to the back of the machine stand.
- Attaching the brackets requires 6 hex head bolt, 6 spring washers, 6 washers, and 6 nuts.
- Place a spring washer and washer on each hex head bolt.
- Face the long side of the bracket up.
- Align the holes of short side of the bracket to the machine panel's holes.
- Place the 2 hex head bolts and their washers through each bracket and machine panel.
- Use a nut on the inside of the machine stand to secure each hex head bolt.



Note: Short bracket on the left side

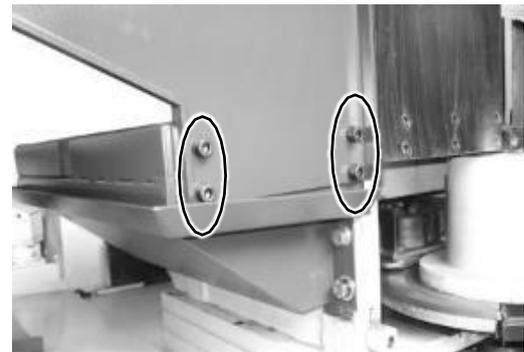
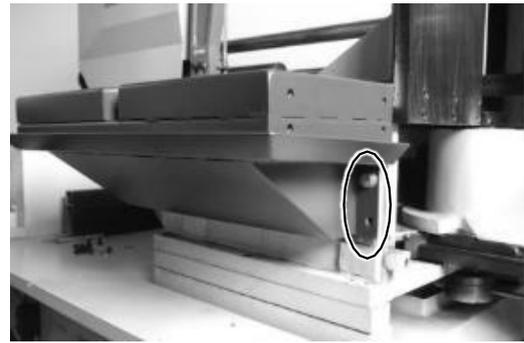
Securing the Rear Tray

- Attaching the trays requires 6 hex head bolt, 6 spring washers, 6 washers, and 6 nuts.
- Arrange the tray rims to facing up and away from the machine.
- Place the rear return tray onto brackets at the back of the machine.
- Align the holes of the rear tray and the six- channeled L-brackets.
- Place 6 hex head bolts through the holes of the trays and brackets.
- Secure each hex head bolts with a washer, spring washer, and hex nut.

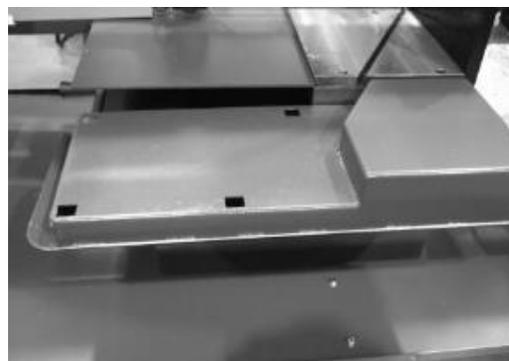
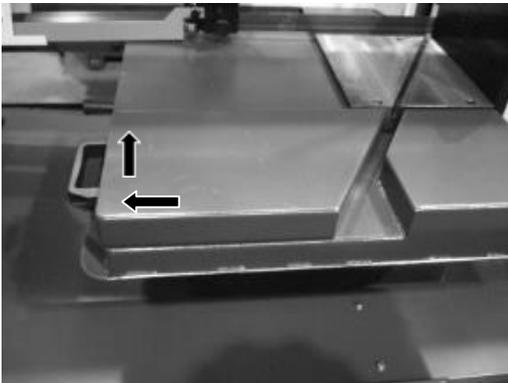


Install the Outlet Tray, Length Stop Device and Mobile Coolant Trays

- Install the outlet tray and stop bar on to the machine after setting up the machine already as below steps:
- Assemble the outlet tray on to the machine by screw in the four screws on each side as shown.
- Tighten the four screws after making sure the top of outlet surface is level with the main table.
- Install stop device on to the outlet tray at the right side by tighten four screws.



- When miter cutting, the movable cover on the left side (outfeed side) can be removed by pull handle forward and up as indicated by the arrow direction to remove it from being cut.



- There are four slots on the cover base after removing the mobile cover for this way miter cutting.
- Install the mobile cover to the four slots and push it to the right side to secure it.
- They are two mobile coolant trays can be moved and used in miter cutting on front and rear side to prevent coolant spray on to the floor.



Mobile Coolant

ELECTRICAL

WARNING: Baileigh Industrial Holdings LLC is not responsible for any damage caused by wiring up to an alternative 3-phase power source other than direct 3-phase. If you are using an alternate power source, consult a certified electrician or contact Baileigh Industrial Holdings LLC prior to energizing the machine.

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.

Power Specifications

Your machine is wired for 415 volts, 50hz 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 $\pm 1\%$.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with an amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machines. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

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

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with 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.

Power cord connection:

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

Rotation Check

5. Once hooked up, turn on the power supply and start and then stop the coolant pump watching that the shaft rotates as indicated.
6. If not, cut the power to the machine. Swap the position of any two of the three power wires; but DO NOT change the position of the green grounding wire!



BEFORE EACH USE

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

Whenever Saw is Running

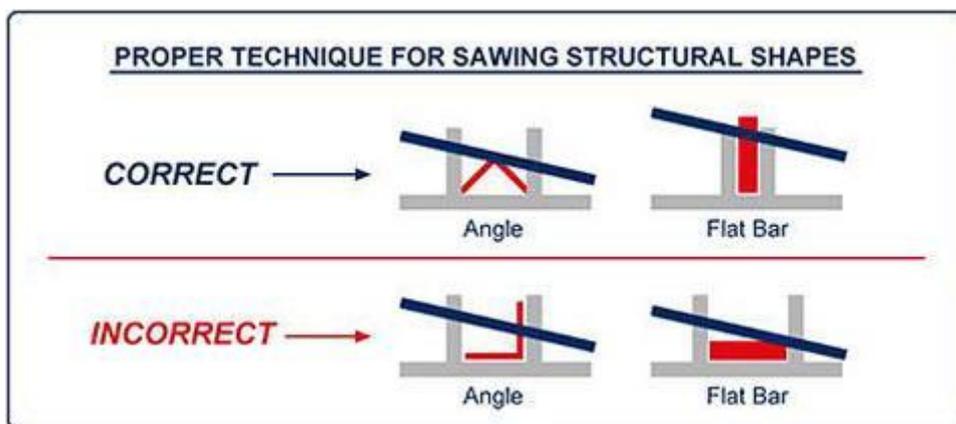
- Never confine the piece being cut out.
- Never hold it, clamp it, touch it, or use length stops against it. It must be free to move sideways. If confined, it could get wedged against the blade and thrown violently.
- Avoid awkward hand positions where a sudden slip could cause a hand to move into the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

Breaking in a Band Saw Blade

Sharp cutting edges with extremely small edge radii are required for high cutting capacity. To achieve the optimal tool life we recommend breaking-in the blade accordingly.

The correct cutting speed is determined by the material being cut and its dimensions. It is very important that the new blade is first used with only 50% of the determined feed rate. This will avoid micro-breakages of the blade because of too large chip thicknesses. New band saw blades may tend toward vibrations and vibration sounds.

In this case a slight reduction of the cutting speed is helpful. With small workpiece dimensions approximately 300cm² of the material should be cut for breaking-in. If large work piece dimensions are to be cut we recommend a breaking-in period of about 15 minutes. After breaking-in you may slowly increase the feed rate up to the determined value.

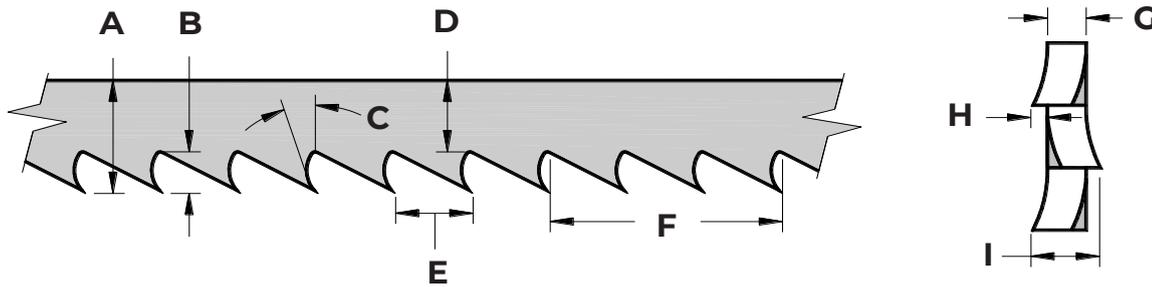


Metal Chip Indicators

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

Blade Terminology



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.

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.

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.

Blade structure

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

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.



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

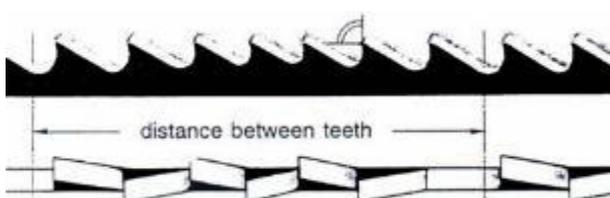
POSITIVE RAKE TOOTH: $9^\circ - 10^\circ$ positive rake and constant pitch.



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).

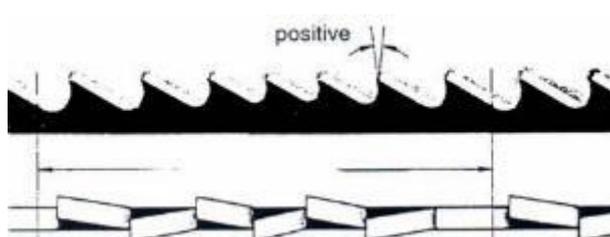
COMBO TOOTH: pitch varies between teeth and consequently varying teeth size and varying gullet depths.

Pitch varies between teeth, which ensures a smoother, quieter cut and longer blade life owing to the lack of vibration.



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

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



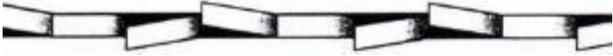
This type of blade is the most suitable for the cutting of section bars and large and thick pipes as well as for the cutting of solid bars at maximum machine capacity. Available pitches: 3-4/4-6.

SETS

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



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



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.



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.



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.



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

BLADE CARE

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

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

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

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.

Blade Selection Reference Table

Cutting Material	Round Tube	Angle and H or I Beam	Solid Round or Square	Solid Round or Rectangle	Solid Round or Rectangle	Solid Round or Rectangle
	<3mm	>5mm	>50mm	>100mm	>150mm	>300mm
Sawblade	<0.12"	>0.2"	>2"	>4"	<6"	<8"
(HSS)14T	▲					
(HSS)6/10T		▲				
(HSS)5/8T			▲			
(HSS)4/6T			▲	▲		
(HSS)3/4T				▲		
(HSS)2/3T					▲	▲
(HSS)1/2T						▲
(HCS)10T	▲					
(HCS)8T		▲				
(HCS)6T			▲			
(HCS)4T				▲		
(HCS)2T					▲	▲

HSS - HIGH SPEED STEEL

HCS = HIGH CARBON STEEL

- Never use a blade finer than required to obtain a satisfactory surface finish or satisfactory flatness. (Too many teeth engaged in the work piece will prevent attainment of a satisfactory sawing rate; frequently cause premature blade wear; frequently produce "dished" cuts or the cuts are neither square nor parallel.)
- The table is not expected to be correct for all cases. It is intended as a general guide to good sawing practices. Your blade supplier or qualified engineers should be your most reliable source for correct information on operational details of saw blades and their use.



Note:

- When cutting a thin walled pipe, angle steel, and I-beam steel, use a blade with 10T/in.
- When cutting pipe with a wall 1/2" or more in thickness, use a blade with 8-12T/in or 6-10T/in.
- When cutting angle steel, I-beam, or solid bar; cut the thinnest cross section of the material first. There must be at least three teeth cutting the material at all times.

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	14	14	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	6-10tpi	6-10tpi	5-8tpi	5-8tpi	5-8tpi	5-8tpi
0.118	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	6-10tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
0.157	14	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	6-10tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
0.197	14	10-14tpi	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	6-10tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
0.236	14	10-14tpi	10-14tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	8-12tpi	6-10tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
0.315	14	10-14tpi	8-12tpi	8-12tpi	8-12tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi	6-10tpi
0.394		8-12tpi	6-10tpi	6-10tpi	6-10tpi	5-8tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
0.472		8-12tpi	6-10tpi	6-10tpi	6-10tpi	5-8tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
0.591		8-12tpi	6-10tpi	5-8tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
0.787			6-10tpi	5-8tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
1.181				4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi	4-6tpi
2						3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi	3-4tpi
3							2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi
4								2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi
6									2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi	2-3tpi
7.873										1.4-2tpi							
9.842											1.4-2tpi						
11.81												1.4-2tpi	1.4-2tpi	1.4-2tpi	1.4-2tpi	1.4-2tpi	1.4-2tpi
13.778													1.4-2tpi	1.4-2tpi	1.4-2tpi	1.4-2tpi	1.4-2tpi
15.747														1-1.4tpi	1-1.4tpi	1-1.4tpi	1-1.4tpi
17.716																	
19.685																	

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).

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.)

Selecting Proper Blade Speed

Use the following chart for reference

CUTTING SPEEDS FOR VARIOUS MATERIALS		
MATERIALS	BLADE SPEED (FPM)	COOLANT REQUIRED
Free Cutting Steel 1100 & 1200 Series Low & Medium Carbon 1008- 1045	78	YES
1046 – 1095	41,60	YES
Alloy Steels	41,60	
Tool Steels	28,41	
Pipe & Structures	41,60	
Nickel Base Alloys	28,41	
Cooper Base Alloys	28,41	
Stainless Steels 430F, 416, 420F, 303	41,60 41,60	YES
Cast Iron	41, 60	NO OIL BLADE

- Blade speeds higher than recommended will quickly dull the blade. Blue chips are evidence of excessive blade speed.
- Lower than recommended speeds will not prolong blade life, and will require a reduced feed rate. Reduced speeds may be helpful in reducing vibration, and will increase blade life in that case.

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:

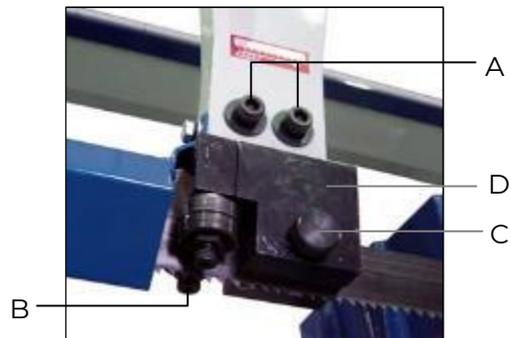
- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Dimensional properties of material must be consistent and not exceed the machine capacity values.
- Chemical structure of material must be consistent.
- Buy certificated steel from the same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

MACHINE SET UP and ADJUSTMENTS

WARNING: Unless specifically needed to complete the procedure, make sure the electrical disconnect is **OFF** before working on the machine.

Thrust Roller Adjustment

1. Disconnect machine from the power source.
2. Loosen two hex socket cap screws (A).
3. Move guide seat (D) up or down until a clearance of .003" to .005" between back of blade and thrust roller is obtained.
4. Tighten two hex socket cap screws (A).
5. Repeat for other blade guide assembly.
6. Connect machine to the power source.



Guide Roller Adjustment



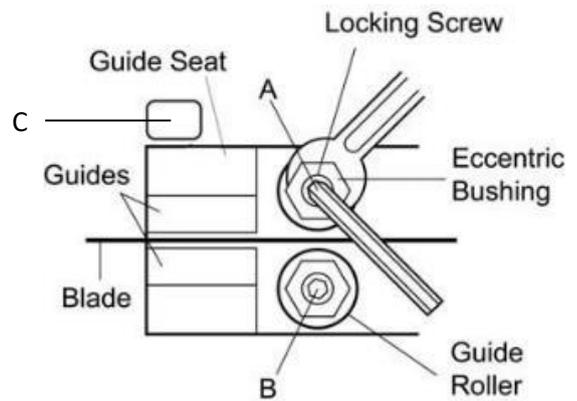
Note: Only bearing (A) is adjustable. Bearing (B) is fixed.

1. Disconnect machine from the power source.
2. Loosen blade guides by loosening guide adjustment screw (C).
3. Loosen locking screws (A) by using a hex wrench.
4. Adjust the eccentric bushings with a combination wrench until the ball bearings are snug to the blade (A). Do not pinch the blade.



Note: The blade should travel freely up and down between the ball bearings.

5. Tighten locking screws (A).
6. Connect machine to the power source.

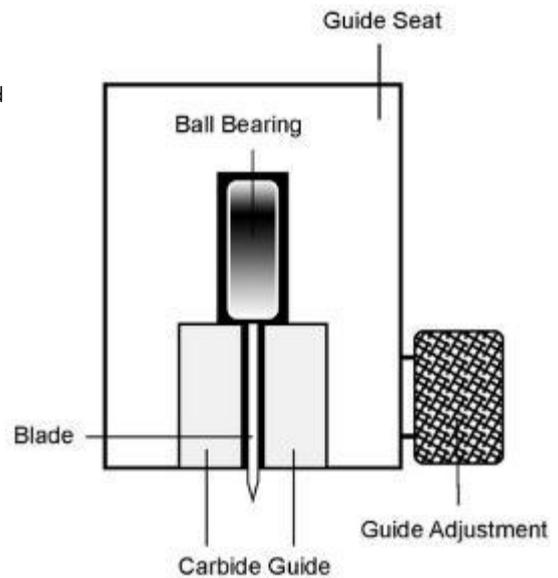


Tungsten Carbide Guides Adjustment

The blade is guided by the upper ball bearings, side ball bearings, and tungsten carbide guides.

When ready to cut the work piece, the carbide guide must be adjusted by adjusting the screws to properly compressed blade. The tungsten carbide blades should touch, but not pinch the blade.

1. For moving the blade guide posts or changing blade, the tungsten carbide guides should be released by using the guide adjusting screw.
2. In case the blade needs to be replaced, make sure to always install the correct thickness blade.
3. To adjust the carbide guides, turn the guide adjustment clockwise until it is tight, then loosen it 1/16-1/8 of a turn. This should allow the blade to be pressed down ward approximate 1/8" (3mm). This movement should be snug, but smooth.

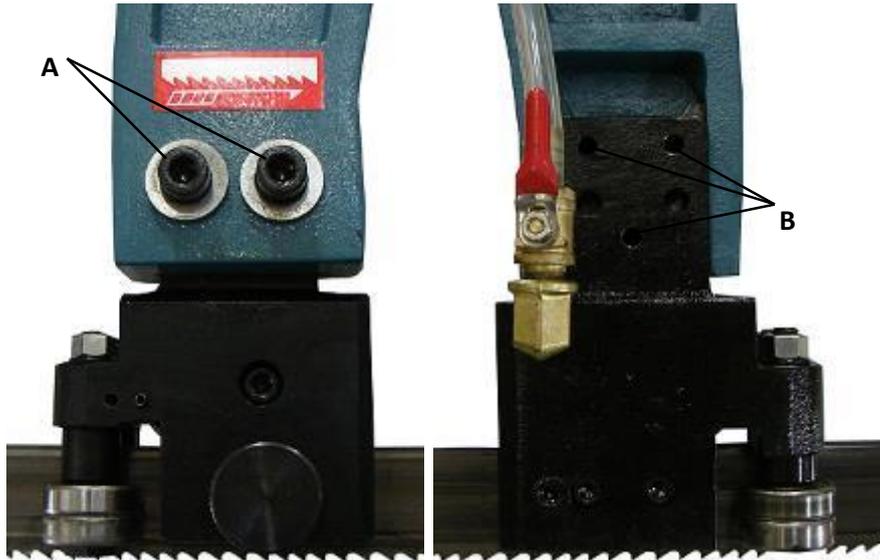


Cutting Precision Adjustment

The cutting precision has been set at the factory.

This adjustment should only be accomplished by qualified personnel that are familiar with this type of adjustment.

1. Disconnect the machine from power supply.
2. Loosen the adjusting bolts (A) slightly.
3. On the back side of the guide, adjust the three setscrews (B) to adjust the alignment of the guide blocks so that the blade tracks perfectly straight between the guides.
4. After adjusting, tighten the adjusting bolts (A).



OPERATION

CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges.
When handling large heavy materials make sure they are properly supported.
NEVER operate saw without blade guards in place.

Starting the Saw

When ready to perform a cutting operation, set up the saw to match the material to be cut.

1. Set the descent control knob to the ZERO position to prevent the bow from lowering into the material until completely ready.
 2. Turn on the main disconnect on the electrical cabinet door. The power lamp will be illuminated.
 3. Reset the emergency stop button to supply power to the controls.
 4. Press the hydraulic pump start switch to start and run the hydraulic system.
 5. Turn Mode selector switch to the left, manual operation position.
-
6. Press and hold the saw bow up button to raise the saw bow until the up limit switch stop travel.
 7. Set the saw to the desired left or right angle. Remove the filler cover if an angle is to be cut.
 8. Set the vise to a position which will clamp the material and not interfere with the saw blade and bow travel.
 9. Set the guide post as close to the material as possible without interfering with the cut or the vise.
 10. Set the upper limit stop plate to allow the bow to raise high enough to clear the material.
 11. If desired, set the material stop to set a desired cut length.
 12. Press and hold the vise open button to open the vise enough to load material.
 13. Load the working material.
 14. Press and hold the vise closed button until the vise closes and secures the material.
 15. Verify that blade is clear of any obstructions and start the saw blade.
 16. Turn Mode selector switch to the right, auto operation position.
 17. Start operation by using the start button.
 18. Set the blade speed as is needed for the material to be cut.
 19. Start the coolant flow (C).
 20. Adjust the descent control knob (G) to the rated needed for the material being cut.
 21. When the cutting operation is finished the saw bow will automatically rise to the preset height ready for the next operation.

Stopping the Saw

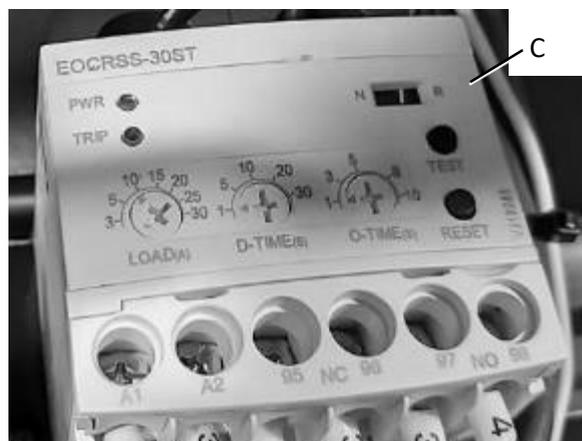
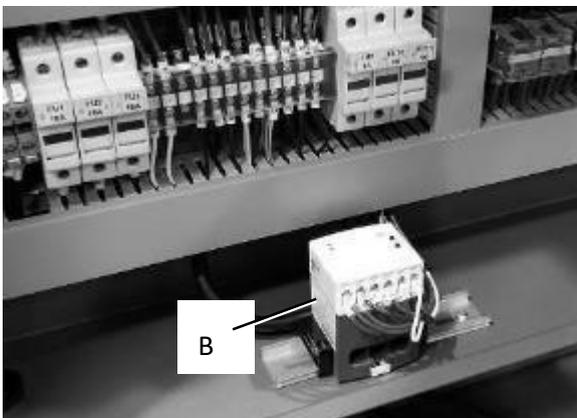
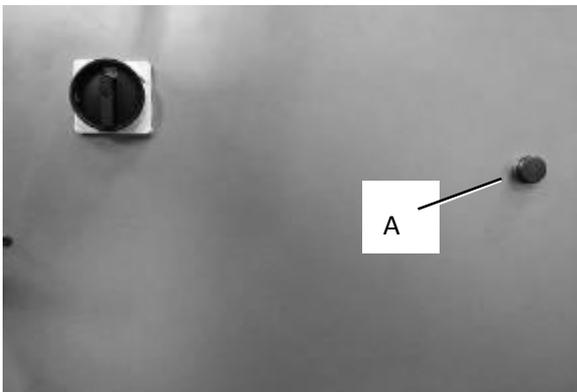
Stopping or Emergency Stopping There are two ways to stop the machine in an event of an emergency or improper operation.

- For most situations, use the stop switch. Using the stop switch will not reset the controls and your operation setting. The blade and drive motor will stop. Then the saw bow will raise to the top position. Open the vise to check the issue. After checking, close the vise and start the cutting cycle again.
- For unsafe and emergency conditions use the emergency stop button. Using emergency stop button will stop the machine in last position. The motor and hydraulic will stop and control setting will be reset.
- To restart, the emergency stop button must be turned to release from the pressed position.

Automatic Shutoff During Machine Operation

If there are any improper operation or situation, the machine is designed to automatically shut off during the operation cycle to prevent any further damage from occurring.

- In case cutting gets tough results blade motor current rises violently, an overload relay is actuated to stop blade to prevent blade from being stuck in material. In the meantime, a red warning light (A) on electrical cabinet's door lights up.
- Overload relay (B) is installed in electrical cabinet at bottom.
- In case overload relay actuates to stop blade's running, open cabinet's door to find overload relay. Press reset button (C) of overload relay, then through regular procedures to turn machine power on and rise saw bow to safety height. Adjust cutting conditions properly and re-start working.
- Overload relay completes setup in factory before shipping. Don't change the setup.



LUBRICATION AND MAINTENANCE

WARNING: Make sure the electrical disconnect is **OFF** before working on the machine. Maintenance should be performed on a regular basis by qualified personnel. Always follow proper safety precautions when working on or around any machinery.

The maintenance jobs are listed below, divided into daily, weekly, and monthly intervals. If the following operations are neglected, the result will be premature wear of the machine and poor performance.

Daily

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- Give general cleaning to the machine to remove accumulated shavings.
- Clean the lubricating coolant drain hole to avoid excess fluid. Top off the level of lubricating coolant.
- Check blade for wear.
- Check functionality of the shields and emergency stops.

Weekly

- Thoroughly clean the machine to remove shavings, especially from the coolant tank.
- Removal of pump from its housing, cleaning of the suction filter and suction zone.
- Clean the filter of the pump suction head and the suction area.
- Use compressed air to clean the blade guides (guide bearings and drain hole of the lubricating and cooling tank).
- Clean flywheel housings and the race of the flywheels.
- Lubricate threaded components and sliding devices. Apply rust inhibitive lubricant to all non-painted surfaces.

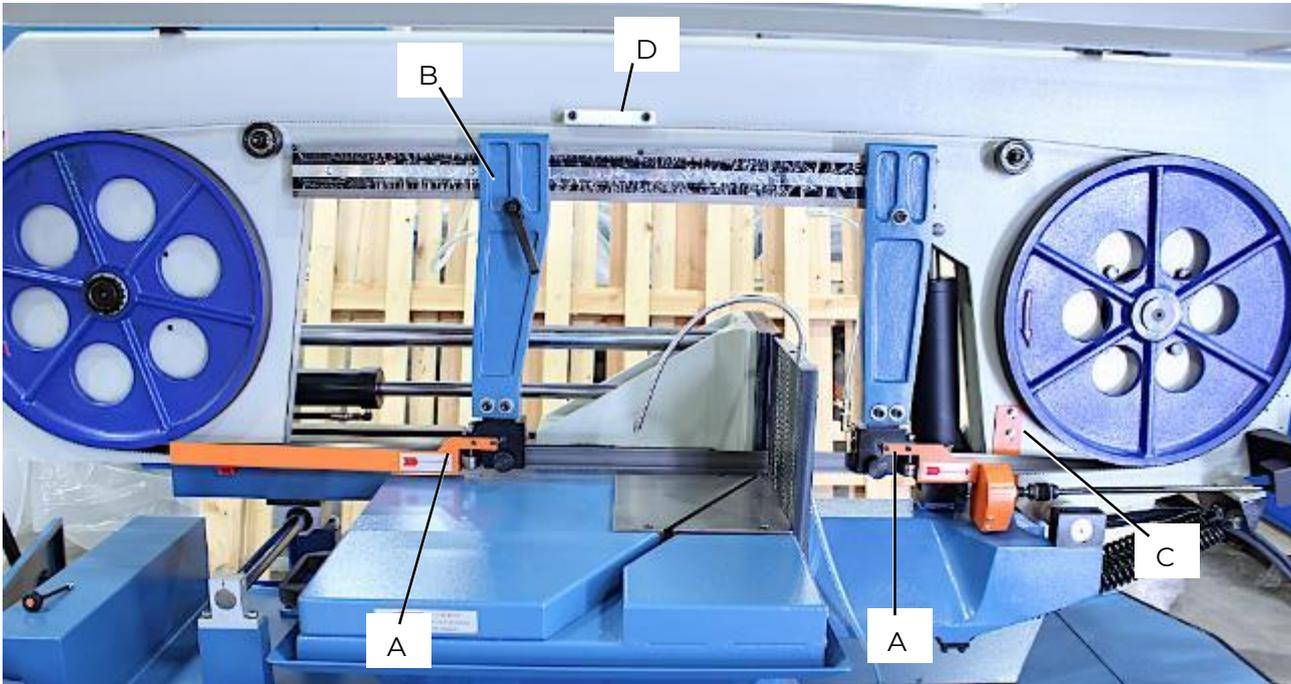
Monthly

- Check the tightness of the drive wheel screws.
- Check that the blade guide bearings on the heads are in perfect running condition.
- Check the tightness of the screws for the motor, pump, and accident protection guards.

Blade Removal and Installation

WARNING: Disconnect the machine from the power source before making any adjustments or repairs!
Failure to comply may result in serious injury!

Blade changes are periodically required when they become worn or to match the properties of varying materials.

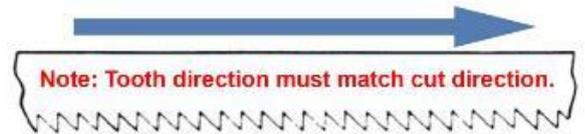


1. Raise the saw bow approximately 6" in height.
2. Disconnect the machine from the power source.
3. Remove the hand bolts from each end of the saw blade cover and lift and latch the cover in the open position.
4. Remove the orange blade guards (A) from the base of the guide post and saw bow.
5. Release the tension on the carbide guides by turning the knob counter clockwise 1/4-1/2 turn.
6. Loosen moveable blade guide (B) post lock handles and slides it to the right side (toward the stationary post) as far as possible.
7. Remove the two cap screws (C) securing the chip brush to the saw bow. Allow the brush assembly to hang free while completing the blade change.
8. Release the blade tension. Turn the blade tension handle to "Loosen" position to free the blade.

CAUTION: Even dull blades are sharp to the skin! Use extra caution handling band saw blades! Wear gloves for protection from the sharp blade!

9. Remove the old blade from both wheels and out of each blade guide.
10. Using compressed air, blow out metal chips and grit from between the bearings, blade guides, and inside of the blade guards and covers.

11. Place the new blade in the carbide guides, and then slide the blade over the wheels and under the blade guide block (D). The teeth should be pointing towards the drive side as they pass through the carbide guides. The blade teeth should protrude from 4.5mm to 5mm from the face of the blade wheels.
12. With the blade in place, turn the tension handle to the "Tighten" (center of the green range) to tension the blade.
13. Set the carbide guides. Tighten the two carbide adjustment knobs until they are tight on the blade and then loosen 1/16 – 1/8 turn.
14. Turn the blade wheels by hand a few rotations to check that the blade is tracking correctly on the blade wheels.
15. Install the blade guards and chip brush.
16. Close all covers.
17. Connect machine to power and run the blade freely for one minutes.
18. Turn the power OFF.
19. Recheck the blade tension and chip brush contact and tracking.
20. If further adjustment is necessary disconnect the saw from the power source, make adjustments, re- connect the power, and then test again.



Saw Blade Break-In

When a new blade is used, be sure to first break in the blade before using it for extended operation. Failure to break in the blade will shorten the service life of the blade, and result in less than optimum efficiency.

1. Reduce the blade speed setting to one half of its normal setting.
2. Lengthen the feed rate time required for cutting to 2-3 times that of normal.
3. The break-in operation can be considered sufficient if all unusual noises or metallic sounds have been eliminated. For instance, to completely break in the blade, a minimum of five complete cuts of 8" (200mm) diameter work-piece will be required.
4. After the break-in operation has been completed, return the blade speed and feed rate to their normal setting.

Accessing and Cleaning the Coolant System

1. Raise the bow to the maximum height and stop the machine and lock out power.
2. Clean the chips and debris from the saw and vise table.
3. Remove the drip tray.
4. Remove the chip drawer and empty the chips and clean the screens.
5. Using a suitable container, remove the drain plug and drain the coolant tank.
6. Flush and clean the tank, pump, and pump inlet and replace the drain plug.
7. Install the chip drawer.
8. Re-fill tank with coolant solution to the full level on the sight glass.
9. Install the drip tray.

Oils for Lubricating Coolant

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

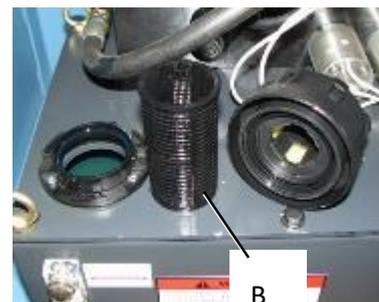
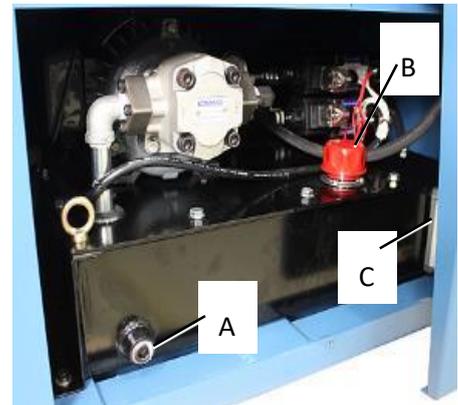
Hydraulic System

The hydraulic oil is the primary medium for transmitting pressure and also must lubricate the running parts of the pump.

Change the hydraulic oil after the first 3 months of operation. Then change the oil annually or after every 3,000 hours of operation, whichever comes first.

- Keep hydraulic oil temperature between 50°F - 140°F.
- Avoid mixing cutting fluid with the hydraulic oil.
- Check hydraulic oil level periodically by monitoring the sight gauge on the tank.
- Tank capacity is approximately 5.3 US gal. (20L).

1. Disconnect power to the saw.
2. Use hydraulic oil #68 SHELL BRAND or an equivalent with similar specifications.
3. Keep hydraulic reservoir filled to 90% of capacity.
4. DO NOT rely totally on the oil gauge as they can sometimes indicate an incorrect level reading. Do a visual inspection with the oil fill cap removed as well.
5. A shortage of hydraulic oil will cause hydraulic system breakdown to major mechanical components due to overheating.
6. Change the hydraulic oil every 12 months along with the oil filter.
7. Remove the cover panel to access the hydraulic tank.
8. Place a suitable container under the drain plug (A) to drain the oil into. Remove plug and drain oil.
9. If cleaning the inside of the tank, remove the bolts securing the cover to the tank and slide the cover over enough to access the inside. Replace the cover when complete.
10. Clean filter basket (B) when filling or changing hydraulic oil.
11. Fill to the full mark on the sight gauge (C).
12. Operate the hydraulics to cycle each cylinder to full extension and retraction several times to purge any air from the system.
13. Install the access cover.



Oil Disposal

The disposal of these products is controlled by strict regulations. Follow all local regulation for proper disposal.

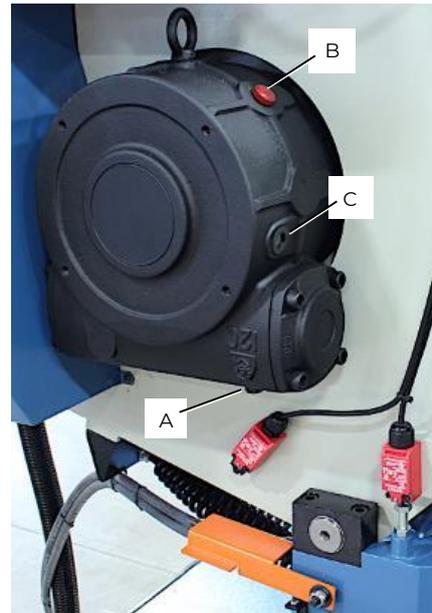
Changing Gear Oil

The gearbox requires periodic changing of oil.

The oil must be changed by the first 6 months of a new machine and every year thereafter.

To change the gear box oil:

1. Lower the saw bow to as near to horizontal as the limit switch will allow.
2. Disconnect the machine from the power source.
3. Using a suitable container, remove the drain plug (A) and drain the gear oil into the container.
4. When the oil is drained, replace the drain plug (A).
5. Remove the filler/vent cap (B) and fill the gear box with oil up to center of the oil sight gauge (C). For reference use SHELL type gear oil or Mobil gear oil #90.
6. Replace the fill/vent cap (B).



Storing Machine for Extended Period of Time

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

- Disconnect the electrical supply from the power panel.
- Empty and clean the coolant reservoir.
- Clean and grease the machine.
- Cover the machine.

Blade Tracking Adjustment

When the blade is installed and tracking correctly, the tips of the blade teeth will be evenly positioned .17"-.19" (4.5-5mm) beyond the edge of the wheels with only light contact on the wheel flange.

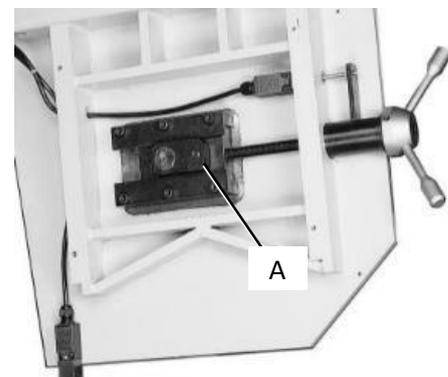
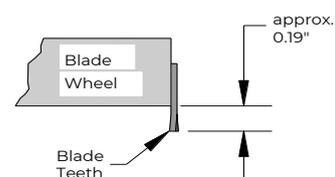
The blade tracking is factory set and should not require any adjustment. If a tracking problem occurs, adjust as follows:

1. Raise saw arm 4" - 6" (102 - 127mm) above the horizontal position to a usable height.
2. Disconnect the machine from the power source.
3. Remove the front side idler wheel cover.
4. Locate tracking adjustment bolt (A) on the blade tension slide block.
5. Tracking adjustment is accomplished by either raising or lowering **adjusting screw (A)**.
6. Tracking is set properly when the tips of the blade teeth will be evenly positioned .17"-.19" (4.5-5mm) beyond the edge of the wheels with only light contact on the wheel flange.



Note: Over tracking (allowing blade back to rub hard against wheel flange) will damage the blade wheels and blade.

7. Install and secure the front side idler wheel cover.
8. Connect machine to the power source.
9. Run the saw in pulses to observe the blade tracking. Each pulse may be slightly longer until you are confident that the blade is tracking correctly.



Hydraulic Vise Pressure

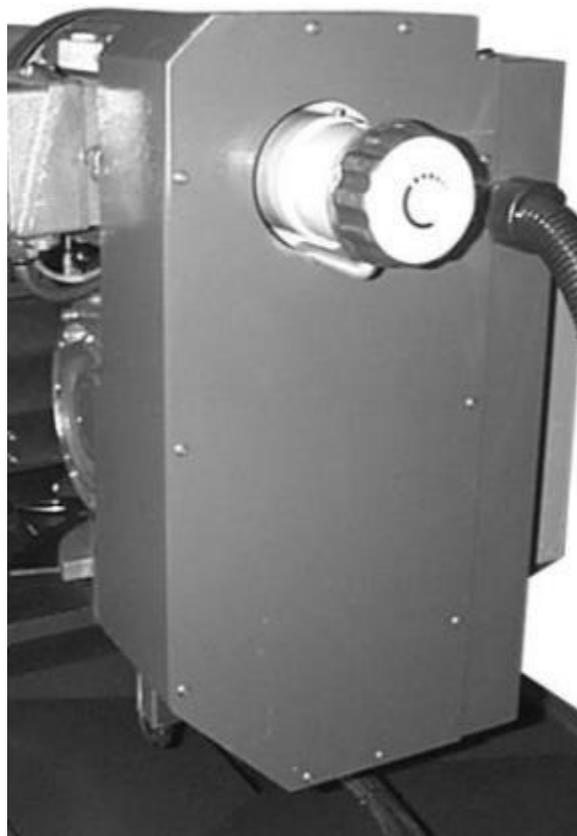
The hydraulic vise pressure can be monitored and adjusted by a pressure gauge on the base of the machine.

- The normal pressure is set at 35kgs/cm². This is good for most solid firm materials.
- For softer, hollow, or pipe materials reduce the pressure to approximately 25kgs/cm². Other materials may require different clamping force.
- The clamping pressure may be adjusted by a knob at the base of the pressure gauge assembly.



Changing the Transmission Belt

Over time and due to normal wear and tear the pulley belt will need to be changed.

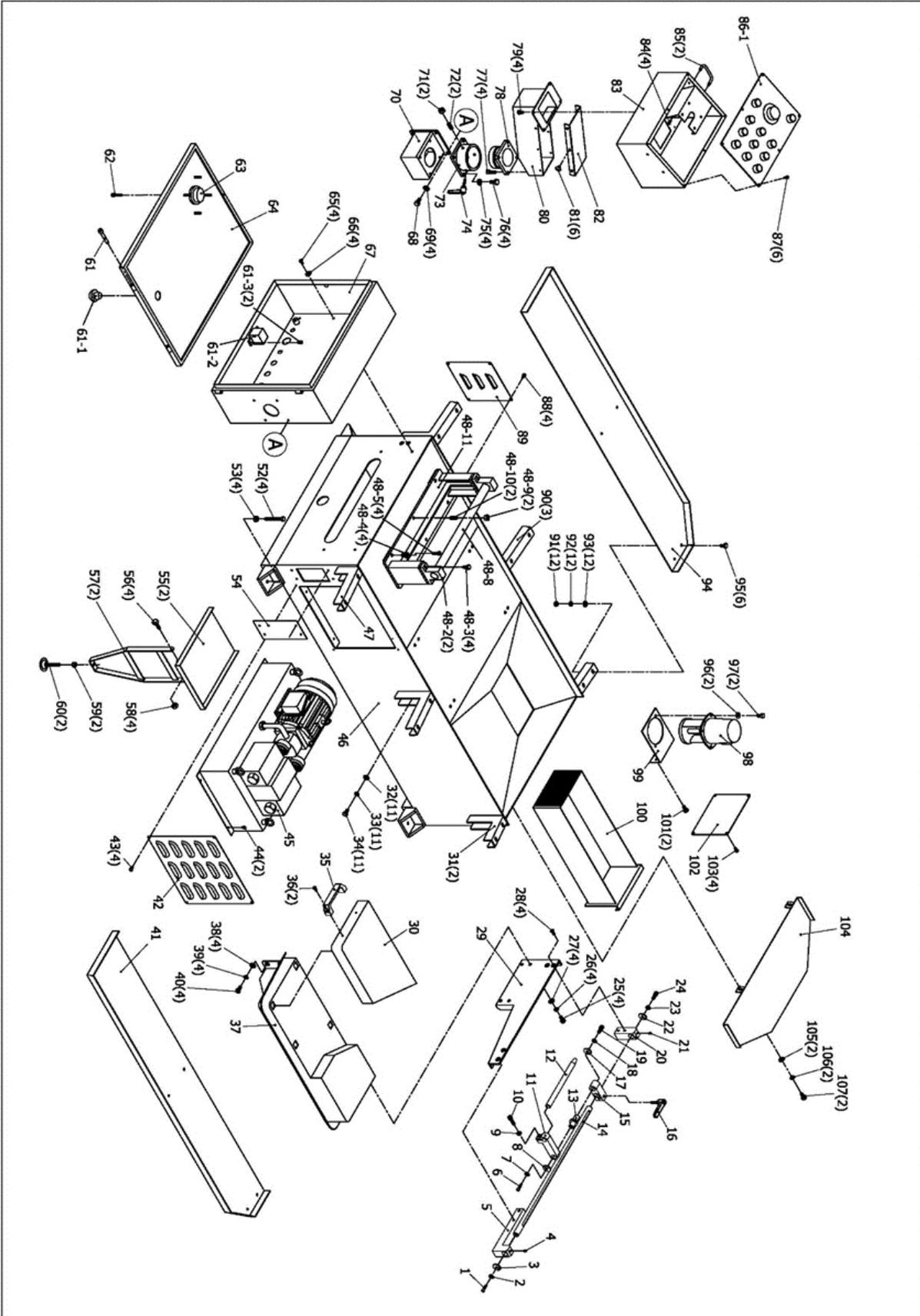


1. Disconnect the machine from power supply.
2. Open the belt cover. Remove 4 screws from the top. Remove 1 screw from the front. Remove 8 screws from the cover.
3. Turn the dial counter-clockwise to open the pulley discs and loosen the belt.
4. Replace the belt.
5. Turn the dial to pretension the belt.
6. Start and run the saw with no load for 3 – 5 minutes to break in the belt.
7. Replace and secure the covers before returning the saw to service.

EXPLOSION DRAWING / ERSATZTEILZEICHNUNG / VUE ÉCLATÉE

BS-24SA-DM

SECTION A - PARTS BREAKDOWN



PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
1	TS-0209051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	3/8"x1"L	1
2	TS-0720091	Spring Washer / Federscheibe / Rondelle élastique	3/8"	1
3	BS24SADM-A3	Washer / Waschmaschine / Laveuse	S1380221-3	1
4	TS-0270022	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	5/16"x5/16"L	1
5	BS24SADM-A5	Position Bracket (L) / Position Halterung (L) / Support de position (L)	S1380221-2	1
6	TS-0209051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	3/8"x1"L	1
7	TS-0720091	Spring Washer / Federscheibe / Rondelle élastique	3/8"	1
8	BS24SADM-A8	Washer / Waschmaschine / Laveuse	S1380221-3	1
9	TS-0720091	Spring Washer / Federscheibe / Rondelle élastique	3/8"	1
10	TS-0209051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	3/8"x1"L	1
11	BS24SADM-A11	Shaft Bracket / Wellenhalterung / Support d'arbre	S1380110-C	1
12	BS24SADM-A12	Upper Shaft / Oberer Schacht / Arbre supérieur	460D2-64	1
13	BS24SADM-A13	Shaft / Welle / Arbre	S1380221-2	1
14	BS24SADM-A14	Length Scale Rod / Länge Skala Stab / Longueur Échelle Tige	S1380221	1
15	BS24SADM-A15	Adjusting Block / Verstellbarer Block / Bloc de réglage	S1380110-B	1
16	BS24SADM-A16	Locking Handle / Verriegelungsgriff / Poignée de verrouillage	TRT80-3/8"Wx30L	1
17	BS24SADM-A17	Washer / Waschmaschine / Laveuse	S1380221-3	1
18	TS-0720091	Spring Washer / Federscheibe / Rondelle élastique	3/8"	1
19	TS-0209051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	3/8"x1"L	1
20	BS24SADM-A20	Position Bracket (R) / Position Halterung (R) / Support de position (R)	S1380110-A	1
21	TS-0270022	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	5/16"x5/16"L	1
22	BS24SADM-A22	Washer / Waschmaschine / Laveuse	S1380221-3	1
23	TS-0720091	Spring Washer / Federscheibe / Rondelle élastique	3/8"	1
24	TS-0209051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	3/8"x1"L	1
25	TS-1491031	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M10x25L	4
26	TS-2361101	Spring Washer / Federscheibe / Rondelle élastique	M10	4
27	BS24SADM-A27	Washer / Waschmaschine / Laveuse	M10	4
28	TS-0246031	Socket Head Flat Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	5/16"x3/4"L	4

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
29	BS24SADM-A29	Outlet Side Plate / Auslass-Seitenplatte / Plaque latérale de sortie	460D3-40-B	1
30	BS24SADM-A30	Removable Retrieval Plate / Abnehmbare Retrievalplatte / Plaque de récupération amovible	460D3-40-A	1
31	BS24SADM-A31	Fixing Bracket / Befestigungsbügel / Support de fixation	460D3-02-B	2
32	BS24SADM-A32	Washer/ Waschmaschine / Laveuse	M8	11
33	TS-2361081	Spring Washer / Federscheibe / Rondelle élastique	M8	11
34	TS-2208201	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M8x20L	11
35	BS24SADM-A35	Handle / Handgriff / Poignée	9160502	1
36	BS24SADM-A36	Big Round Head Screw / Große Rundkopfschraube / Grande vis à tête ronde	M6x12L	2
37	BS24SADM-A37	Retrieval Table / Abruftabelle / Tableau d'extraction	460D3-40	1
38	BS24SADM-A38	Washer / Waschmaschine / Laveuse	M12	4
39	TS-2361121	Spring Washer / Federscheibe / Rondelle élastique	M12	4
40	TS-1492011	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M12x25L	4
41	BS24SADM-A41	Coolant Tray / Kühlmittelwanne / Bac à liquide de refroidissement	460D3-02-A	1
42	BS24SADM-A42	Cover / Abdeckung / Couverture	460D3-05-A	1
43	TS-2246082	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M6x8L	4
44	TS-1503031	Socket Head Cap Screw/ Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x12L	2
45	BS24SADM-A45	Hydraulic Unit / Hydraulische Einheit / Unité hydraulique		1
46	BS24SADM-A46	Machine Base / Maschine Basis / Base de la machine	460D3-01	1
47	BS24SADM-A47	Supporting Bracket / Stützbügel / Support de fixation	460D3-02-C	1
48-2	BS24SADM-A48-2	Support Base / Stützpunkt / Base de soutien	SH35A	2
48-3	TS-1491021	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M10x20L	4
48-4	BS24SADM-A48-4	Adjusting Screw / Justierschraube / Vis de réglage	460D2-66	4
48-5	TS-149105	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M10x35L	4
48-8	BS24SADM-A48-8	Shaft / Welle / Arbre	SCF-35-570	1
48-9	TS-1540081	Nut / Nuss / Écrou	M12	2
48-10	TS-1526041	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	M12x25L	2
48-11	BS24SADM-A48-11	Shaft Bracket Set / Wellenhalterungssatz / Jeu de supports d'arbre	460D3-38-F	1

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Index No.	Part No.	Description	Size	Q'ty
52	TS-1494052	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête	M16x60L	4
53	TS-2310162	Nut / Nuss / Écrou	M16	4
54	BS24SADM-A54	Cover / Abdeckung / Couverture	460D3-06	1
55	BS24SADM-A55	Movable Coolant Tray / Bewegliche Kühlmittelwanne / Bac de refroidissement mobile	460D3-39	2
56	TS-1482021	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête	M6x12L	4
57	BS24SADM-A57	Bracket / Halterung / Support	460D3-39-A	2
58	TS-1540041	Nut / Nuss / Écrou	M6	4
59	TS-0640111	Nut / Nuss / Écrou	1/2"	2
60	BS24SADM-A60	Adjusting Bolt / Justierbolzen / Boulon de réglage	331D4-37	2
61	BS24SADM-A61	Door Pin / Türstift / Goupille de porte		2
61-1	BS24SADM-A61-1	O.L. Indicator Light / O.L.-Anzeigeleuchte / Témoin lumineux O.L.		1
61-2	BS24SADM-A61-2	Blade Stuck Overload Relay / Klinge klemmt Überlastrelais / Lame coincée Relais de surcharge		1
61-3	BS24SADM-A61-3	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M4x8L	2
62	TS-1503071	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x30L	1
63	BS24SADM-A63	Power Switch / Netzschalter / Interrupteur d'alimentation		1
64	BS24SADM-A64	Electric Box Cover / Abdeckung Elektrokasten / Couvercle de boîte électrique	331D3-07	1
65	TS-1502011	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x8L	4
66	BS24SADM-A66	Spring Washer / Federscheibe / Rondelle élastique	M6	4
67	BS24SADM-A67	Electric Box (Swivel) / Elektrobox (schwenkbar) / Boîte électrique (pivotante)	331D3-06-E	1
68	TS-2228161	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête	M8x16L	4
69	TS-2361081	Spring Washer / Federscheibe / Rondelle élastique	M8	4
70	BS24SADM-A70	Fixing Bracket / Befestigungsbügel / Support de fixation	331D3-37	1
71	TS-1540041	Nut / Nuss / Écrou	M6	2
72	TS-1523081	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	M6x30L	2
73	BS24SADM-A73	Shaft Bushing / Wellenbuchse / Douille d'arbre	331D1-18-A	1
74	BS24SADM-A74	Locking Handle / Verriegelungsgriff / Poignée de verrouillage	M8x30L	1
75	TS-2361081	Spring Washer / Federscheibe / Rondelle élastique	M8	4
76	TS-2228161	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête	M8x16L	4
77	TS-1482031	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête	M6x16L	4
78	BS24SADM-A78	Swiveling Shaft / Schwenkbare Welle / Arbre pivotant	331D1-18	1

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

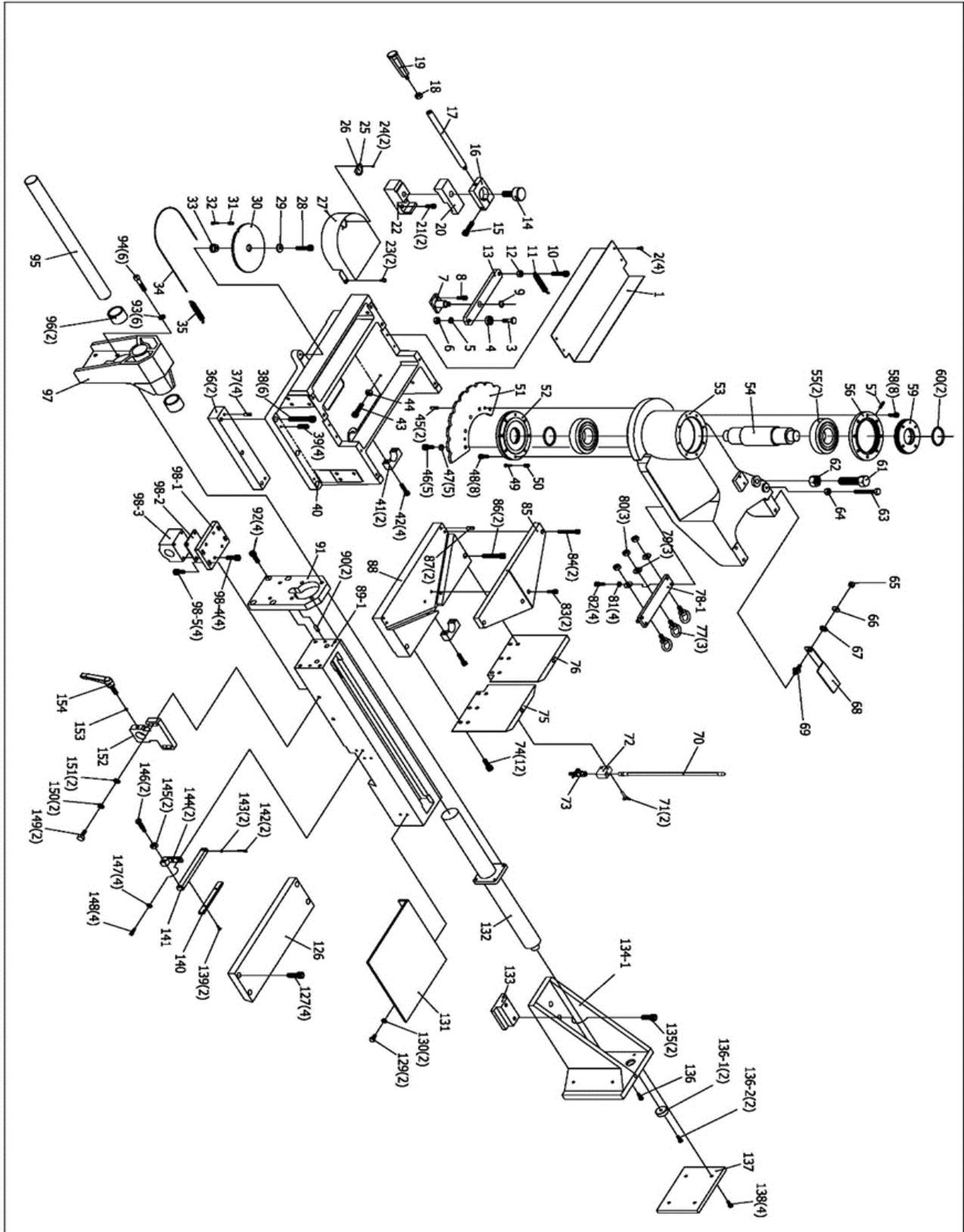
BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
79	TS-2246082	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M6x8L	4
80	BS24SADM-A80	Swiveling Bracket / Schwenkbare Halterung / Support pivotant	460D3-09	1
81	BS24SADM-A81	Big Round Head Screw / Große Rundkopfschraube / Grande vis à tête ronde	M6x8L	6
82	BS24SADM-A82	Cover / Abdeckung / Couverture	460D3-09-A	1
83	BS24SADM-A83	Operation Box / Betrieb Box / Boîte d'opération	331D3-08C	1
84	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	4
85	BS24SADM-A85	Handle / Handgriff / Poignée	A-42-C	2
86-1	BS24SADM-A86-1	Control Panel / Bedienfeld / Panneau de contrôle		1
87	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	6
88	TS-2246082	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M6x8L	4
89	BS24SADM-A89	Hydraulic Rear Cover / Hydraulische Abdeckung hinten / Couvercle arrière hydraulique	460D3-05-B	1
90	BS24SADM-A90	Fixing Bracket / Befestigungsbügel / Support de fixation	331D3-02-B	3
91	TS-2311081	Nut / Nuss / Écrou	M8	12
92	TS-2361081	Spring Washer / Federscheibe / Rondelle élastique	M8	12
93	BS24SADM-A93	Washer / Waschmaschine / Laveuse	M8	12
94	BS24SADM-A94	Coolant Plate (L) / Kühlmittelplatte (L) / Plaque de refroidissement (L)	460D3-02	1
95	TS-2208201	Hex. Cap Screw/ Sechskant. Kopfschraube / Hex. Vis à tête	M8x20L	12
96	TS-1482021	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête	M6x12L	2
97	TS-2361061	Spring Washer / Federscheibe / Rondelle élastique	M6	2
98	BS24SADM-A98	Coolant Pump / Kühlmittelpumpe / Pompe de refroidissement	1/6"x150L	1
99	BS24SADM-A99	Fixing Plate / Fixierungsplatte / Plaque de fixation	331D3-39	1
100	BS24SADM-A100	Chip Box / Chip-Box / Boîte à puce	460D3-04	1
101	TS-2246122	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M6x12L	2
102	BS24SADM-A102	Cover / Abdeckung / Couverture	460D3-05	1
103	TS-2246082	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M6x8L	4
104	BS24SADM-A104	Coolant Plate (Rear) / Kühlmittelplatte (hinten) / Plaque de refroidissement (arrière)	460D3-03-A	1
105	BS24SADM-A105	Washer / Waschmaschine / Laveuse	M8	2
106	TS-2361081	Spring Washer / Federscheibe / Rondelle élastique	M8	2
107	TS-2228161	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête	M8x16L	2

EXPLOSION DRAWING / ERSATZTEILZEICHNUNG / VUE ÉCLATÉE

BS-24SA-DM

SECTION B - PARTS BREAKDOWN



PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
1	BS24SADM-B1	Cover Plate / Abdeckplatte / Plaque de recouvrement	460D3-26-A	1
2	F009884	Socket Head Button Screw / Innensechskantschraube / Vis à tête cylindrique	M5x8L	4
3	BS24SADM-B3	Cam Shaft / Nockenwelle / Arbre à came	331D2-31	1
4	BB6000	Bearing / Lager / Roulement	6000	1
5	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	1
6	BS24SADM-B6	Nut / Mutter / Écrou	M10	1
7	BS24SADM-B7	Cam Bracket / Nockenhalterung / Support de came	331D2-30	1
8	TS-1504051	Socket Head Cap Screw / Innensechskantschraube / Vis à tête cylindrique	M8x25L	2
9	BS24SADM-B9	CRing / C-Ring / Anneau en C	S16	1
10	TS-1505061	Socket Head Cap Screw / Innensechskantschraube / Vis à tête cylindrique	M10x40L	1
11	BS24SADM-B11	Cam Spring / Nockenfeder / Ressort de came	331D4-02	1
12	BS24SADM-B12	Nut / Mutter / Écrou	M10	1
13	BS24SADM-B13	ConnectingPlate / Verbindungsplatte / Plaque de connexion	460D2-32	1
14	BS24SADM-B14	LockingBolt / Verriegelungsbolzen / Boulon de verrouillage	331D2-27	1
15	TS-1505081	Socket Head Cap Screw / Innensechskantschraube / Vis à tête cylindrique	M10x50L	1
16	BS24SADM-B16	ConnectingBlock / Verbindungsblock / Bloc de connexion	331D2-28	1
17	BS24SADM-B17	LockingRod / Verriegelungsstange / Tige de verrouillage	460D2-29	1
18	BS24SADM-B18	Nut / Mutter / Écrou	M12	1
19	BS24SADM-B19	Rubber Handle / Gummigriff / Poignée en caoutchouc	9160501	1
20	BS24SADM-B20	Brake Plate / Bremsplatte / Plaque de frein	331D2-26	1
21	TS-1504041	Socket Head Cap Screw / Innensechskantschraube / Vis à tête cylindrique	M8x20L	2
22	BS24SADM-B22	Brake Bracket / Bremsträger / Support de frein	331D1-11	1
23	TS-2246082	Socket Head Button Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x8L	2
24	TS-1501011	Socket Head Cap Screw / Innensechskantschraube / Vis à tête cylindrique	M4x6L	2
25	BS24SADM-B25	Magnifier Holder / Lupenhalterung / Support de loupe	331D3-43	1
26	BS24SADM-B26	Angle Magnifier / Winkellupe / Loupe d'angle	331D4-09	1
27	BS24SADM-B27	Cover / Abdeckung / Couverture	331D3-25	1
28	TS-1505061	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x40L	1
29	TS-2361101	Washer / Waschmaschine / Laveuse	M10	1
30	BS24SADM-B30	Center Wheel / Zentrales Rad / Roue centrale	331D2-33	1

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Index No.	Part No.	Description	Size	Q'ty
31	BS24SADM-B31	Wire Fastener / Drahtbefestigung / Attache en fil de fer		1
32	BS24SADM-B32	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M5x15L	1
33	BS24SADM-B33	Bushing / Buchse / Douille	331D2-34	1
34	BS24SADM-B034B	Steel Rope Assembly / Stahlseilmontage / Assemblage de câbles d'acier	Incl: 31, 32,34, 35,49,50	1
35	BS24SADM-B35	Angle Spring / Eckige Feder / Ressort d'angle	331D4-03	1
36	BS24SADM-B36	Plate / Platte / Assiette	460D2-50	2
37	BS24SADM-B37	SpringPin / Federstift / Goupille à ressort	8x20L	4
38	BS24SADM-B38	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M12x130L	6
39	BS24SADM-B39	Set Screw / Stellschraube / Vis de réglage	M12x25L	4
40	BS24SADM-B40	Table / Tabelle / Tableau	460D1-01	1
41	BS24SADM-B41	FixingBlock / Fixierblock / Bloc de fixation	331D2-04	2
42	TS-1505051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x35L	4
43	TS-1505061	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x40L	1
44	BS24SADM-B44	Nut / Nuss / Écrou	M10	1
45	BS24SADM-B45	SpringPin / Federstift / Goupille à ressort	8x20L	2
46	TS-1505021	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête	M10x20L	5
47	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	5
48	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	8
49	BS24SADM-B49	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M5x15L	1
50	BS24SADM-B50	Wire Fastener / Drahtbefestigung / Attache en fil de fer	331D2-35	1
51	BS24SADM-B51	Position Plate / Position Platte / Plaque de position	331D2-25	1
52	BS24SADM-B52	Lower Cover / Untere Abdeckung / Couvercle inférieur	331D2-05	1
53	BS24SADM-B53	Swiveling / Schwenken / Pivotant	460D1-06	1
54	BS24SADM-B54	SwivelingShaft / Schwenkbare Welle / Arbre pivotant	331D2-03	1
55	BB30312	Bearing / Lager / Palier	30312	2
56	BS24SADM-B56	Upper Cover / Obere Abdeckung / Couvercle supérieur	331D2-06	1
57	BS24SADM-B57	Set Screw / Stellschraube / Vis de réglage	M6x25L	1
58	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	8
59	BS24SADM-B59	Tighten Plate / Platte festziehen / Serrer la plaque	331D2-06-A	1

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Index No.	Part No.	Description	Size	Q'ty
60	BS24SADM-B60	Oil Ring / Ölring / Bague d'huile	P60	2
61	BS24SADM-B61	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M20x65L	1
62	BS24SADM-B62	Nut / Nuss / Écrou	M20	1
63	TS-1491101	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M10x60L	1
64	BS24SADM-B64	Nut / Nuss / Écrou	M10	1
65	BS24SADM-B65	Nylon Nut / Nylon-Mutter / Écrou en nylon	M10	1
66	BS24SADM-B66	Washer / Waschmaschine / Laveuse	S138F2-26-A	1
67	BS24SADM-B67	Washer / Waschmaschine / Laveuse	S138F2-26-B	1
68	BS24SADM-B68	Position AdjustingPlate / Position der Einstellplatte / Plaque de réglage de la position	S138F3-29	1
69	BS24SADM-B69	Position Bolt / Position Riegel / Boulon de position	S20A2-01	1
70	BS24SADM-B70	Hose / Schlauch / Tuyau	SP103 1/4"x18"	1
71	BS24SADM-B71	WingScrew / Flügelschrauben / Vis à oreilles	M6x30L	2
72	BS24SADM-B72	Hose Seat / Schlauch Sitz / Siège du tuyau	H46A2-39	1
73	BS24SADM-B73	Coolant Switch / Kühlmittelschalter / Interrupteur de liquide de refroidissement	1/4x1/4	1
74	TS-1505041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x30L	12
75	BS24SADM-B75	Attached Plate (R) / Befestigte Platte (R) / Plaque de fixation (R)	460D2-24	1
76	BS24SADM-B76	Attached Plate (L) / Befestigte Platte (L) / Plaque de fixation (L)	460D2-23	1
77	BS24SADM-B77	Screw Holder / Schraubenhalterung / Support de vis	1/2"x50L	3
78-1	BS24SADM-B78-1	Lower Bracket / Untere Halterung / Support inférieur	461F3-64	1
79	TS-0680061	Washer / Waschmaschine / Laveuse	1/2"	3
80	BS24SADM-B80	Nut / Nuss / Écrou	1/2"	3
81	TS-2361081	SpringWasher / Federscheibe / Rondelle élastique	M8	4
82	TS-1504051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x25L	4
83	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	2
84	BS24SADM-B84	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x55L	2
85	BS24SADM-B85	Angle CuttingTable / Winkelschneidetisch / Table de coupe angulaire	460D1-03	1
86	TS-1505101	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x60L	2

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

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Index No.	Part No.	Description	Size	Q'ty
87	BS24SADM-B87	SpringPin / Federstift / Goupille à ressort	8x20L	2
88	BS24SADM-B88	CuttingPlatform / Schneideplattform / Plate-forme de coupe	460D1-02	1
89-1	BS24SADM-B89-1	Vise Table / Schraubstock-Tisch/ Table d'étau	460D1-04-B	1
90	BS24SADM-B90	SpringPin / Federstift / Goupille à ressort	8x20L	2
91	BS24SADM-B91	Position Plate / Position Platte / Plaque de position	460D2-65	1
92	TS-1506041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M12x35L	4
93	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	6
94	TS-1505061	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x40L	6
95	BS24SADM-B95	Upper Shaft / Oberer Schacht / Arbre supérieur	460D2-56	1
96	BS24SADM-B96	OillessBearing / Ölloses Lager / Palier sans huile	45x55x40	2
97	BS24SADM-B97	Central Bracket / Zentrale Klammer / Panier central	460D1-21	1
98-1	BS24SADM-B98-1	Slider Block / Schieberegler-Block / Bloc coulissant	460D3-38-B	1
98-2	BS24SADM-B98-2	Pad / Pad / Tampon	460D3-38-A	1
98-3	BS24SADM-B98-3	Slider Seat / Schiebesitz / Siège coulissant	SMA35UU	1
98-4	TS-1504061	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x30L	4
98-5	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	4
126	BS24SADM-B126	Guide Plate / Leitblech / Plaque de guidage	460D2-17	1
127	TS-1506041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M12x35L	4
129	TS-2208201	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M8x20L	2
130	TS-2361081	SpringWasher / Federscheibe / Rondelle élastique	M8	2
131	BS24SADM-B131	Table Plate / Tischplatte / Assiette de table	460D3-26	1
132	BS24SADM-B132	Front Vise Cylinder / Vorderer Schraubstock-Zylinder / Cylindre d'étau avant		1
133	BS24SADM-B133	Position Block / Position Blöcke / Bloc de position	331D2-18-A	1
134-1	BS24SADM-B134-1	Front Vise / Vorderer Schraubstock / Étau frontal	460D1-05-A	1
135	TS-1506031	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M12x30L	2
136	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	1
136-1	BS24SADM-B136-1	Vise Cylinder Block / Schraubstock-Zylinderblock / Bloc- cylindre de l'étau	460D2-88	2
136-2	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	2

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

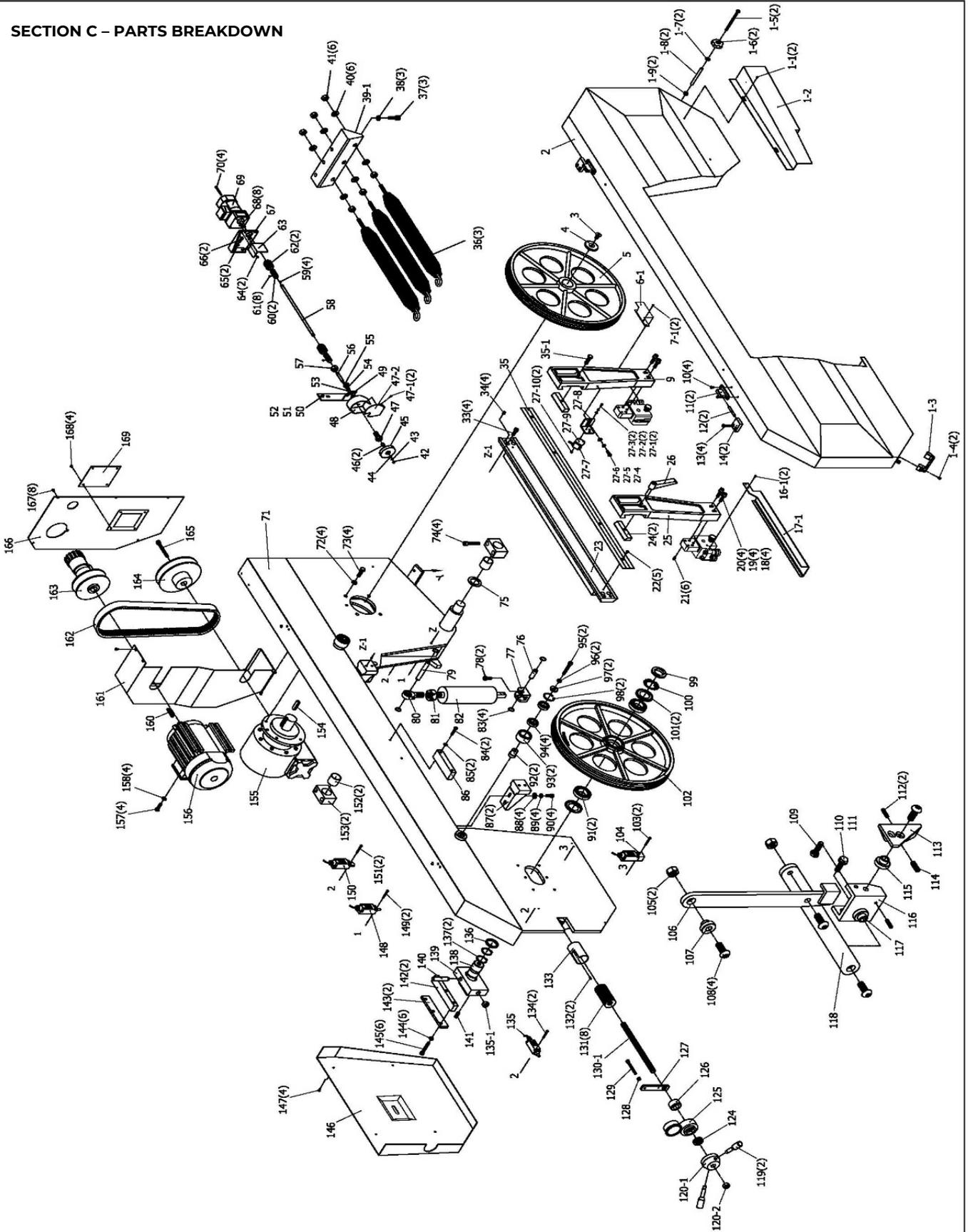
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Index No.	Part No.	Description	Size	Q'ty
137	BS24SADM-B137	Attached Plate / Befestigte Platte / Plaque jointe	460D2-22	1
138	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	4
139	TS-1513021	Socket Head Flat Screw / Flachkopfschraube mit Innensechskant / Vis plate à tête creuse	M5x12L	2
140	BS24SADM-B140	Copper Sheet / Kupferblech / Feuille de cuivre	H46D2-19	1
141	BS24SADM-B141	Position Block / Position Blöcke / Bloc de position	460D2-86	1
142	TS-1502051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M5x20L	2
143	BS24SADM-B143	Nut / Nuss / Écrou	M5	2
144	BS24SADM-B144	FixingFrame / Fixierahmen / Cadre de fixation	H46D2-19A	2
145	BS24SADM-B145	Nut / Nuss / Écrou	M12	2
146	BS24SADM-B146	AdjustingScrew / Justierschraube / Vis de réglage	H46D2-19-B	2
147	TS-2361081	SpringWasher / Federscheibe / Rondelle élastique	M8	4
148	TS-1504041	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	4
149	BS24SADM-B149	Steel Hex. Cap Bolt / Stahl Sechskant. Schraube / Boulon à tête hexagonale en acier Boulon à tête hexagonale	M12	2
150	TS-2361121	SpringWasher / Federscheibe / Rondelle élastique	M12	2
151	TS-2360121	Washer / Waschmaschine / Laveuse	M12	2
152	BS24SADM-B152	Position Block / Position Blöcke / Bloc de position	460D2-87	1
153	BS24SADM-B153	Brass / Messing / Laiton	H46D2-25	1
154	BS24SADM-B154	Handle / Handgriff / Poignée	TRT80 M12x50L	1

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BS-24SA-DM

SECTION C – PARTS BREAKDOWN



PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
1-1	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	2
1-2	BS24SADM-C1-2	Cover / Abdeckung / Couverture	460D3-36	1
1-3	BS24SADM-C1-3	Handle / Handgriff / Poignée	9160502	1
1-4	BS24SADM-C1-4	Big Round Head Screw / Große Rundkopfschraube / Grande vis à tête ronde	M6x12L	2
1-5	BS24SADM-C1-5	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M6x100L	2
1-6	BS24SADM-C1-6	Nylon Knob / Nylon Knopf / Bouton en nylon	SK34	2
1-7	TS-1550041	Washer / Waschmaschine / Laveuse	M6	2
1-8	BS24SADM-C1-8	Pipe / Rohrleitung / Tuyau		2
1-9	BS24SADM-C1-9	Nut / Nuss / Écrou	M6	2
2	BS24SADM-C2	Wheel Cover / Radabdeckung / Enjoliveur de roue	460D3-10-C	1
3	TS-1517011	Socket Head Flat Screw / Flachkopfschraube mit Innensechskant / Vis plate à tête creuse	M12x25L	1
4	BS24SADM-C4	Driver Wheel Washer / Radwaschanlage für Fahrer / Lave-roue conducteur	331D2-49	1
5	BS24SADM-C5	Driver Wheel / Antriebsrad / Roue motrice	460D1-13	1
6-1	BS24SADM-C6-1	Blade Guard / Klingenschutz / Protection de la lame	460D3-13-B	1
7-1	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	2
9	BS24SADM-C9	Guide Post (R) / Leitpfosten (R) / Poteau guide (R)	460D1-07-A	1
10	TS-2246162	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M6x16L	4
11	BS24SADM-C11	Cover Latch / Deckelverriegelung / Loquet du couvercle	460D2-45	2
12	BS24SADM-C12	Pin / Stift / Épingle	8x70L	2
13	TS-2248302	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M8x30	4
14	BS24SADM-C14	Latch Block / Verriegelungsblock / Bloc de verrouillage	460D2-44	2
16-1	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	2
17-1	BS24SADM-C17-1	Blade Guard / Klingenschutz / Protection de la lame	460D3-12-B	1
18	TS-1505051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x35L	4
19	TS-1550071	Washer / Waschmaschine / Laveuse	M10	4
20	TS-2361101	Spring Washer / Federscheibe / Rondelle élastique	M10	4
21	TS-1524041	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	M8x16L	6

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BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
22	BS24SADM-C22	Round Head Screw / Rundkopfschraube / Vis à tête ronde	M5x8L	5
23	BS24SADM-C23	Guide Plate / Leitblech / Plaque de guidage	460D1-08	1
24	BS24SADM-C24	LockingBlock / Verriegelungsblock / Bloc de verrouillage	460D2-46	2
25	BS24SADM-C25	Guide Post (L) / Führungsposten (L) / Poteau de guidage (L)	460D1-07	1
26	BS24SADM-C26	LockingHandle / Verriegelungsgriff / Poignée de verrouillage	M12x50L	1
27-1	BS24SADM-C27-1	Half Round Head Screw / Halbrundkopfschraube / Demi-vis à tête ronde	M3x12L	2
27-2	TS-2361031	SpringWasher / Federscheibe / Rondelle élastique	M3	2
27-3	TS-1550011	Washer / Waschmaschine / Laveuse	M3	2
27-4	TS-1502031	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M5x12L	1
27-5	TS-2361051	SpringWasher / Federscheibe / Rondelle élastique	M5	1
27-6	TS-1550031	Washer / Waschmaschine / Laveuse	M5	1
27-7	BS24SADM-C27-7	Laser Device / Lasergerät / Dispositif laser	3300419-1	1
27-8	BS24SADM-C27-8	Laser Plate / Laserplatte / Plaque laser	460D2-61-A	1
27-9	BS24SADM-C27-9	Laser Bracket / Laser-Halterung / Support pour laser	3300419-2	1
27-10	BS24SADM-C27-10	Nut / Nuss / Écrou	M3	2
33	TS-1505021	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x20L	4
34	TS-1525031	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	M10x16L	4
35	BS24SADM-C35	Metal Scale / Metallwaage / Écaille de métal		1
35-1	BS24SADM-C35-1	Hex. Cap Steel Screw / Sechskant. Stahlschraube mit Kappe / Hex. Vis à tête hexagonale en acier	M12x50L	1
36	BS24SADM-C36	Spring / Frühling / Printemps	9.0x56x54N	3
37	TS-2249252	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x25L	3
38	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	3
39-1	BS24SADM-C39-1	Upper Bracket / Obere Klammer / Support supérieur	461F3-65	1
40	TS-0680061	Washer / Waschmaschine / Laveuse	1/2"	6
41	BS24SADM-C41	Nut / Nuss / Écrou	1/2"	6
42	BS24SADM-C42	Nut / Nuss / Écrou	M6	1
43	TS-2361061	SpringWasher / Federscheibe / Rondelle élastique	M6	1
44	TS-1550041	Washer / Waschmaschine / Laveuse	M6	1
45	BS24SADM-C45	Brush / Bürste / Brosse	331D4-08	1
46	BS24SADM-C46	OillessBush / Ölloser Busch / Buisson sans huile	1212	2
47	BS24SADM-C47	Shaft Bushing / Wellenbuchse / Douille d'arbre	460D2-59	1

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BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
47-1	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	2
47-2	BS24SADM-C47-2	Cover / Abdeckung / Couverture	460D3-31-D	1
48	BS24SADM-C48	Brush Cover / Bürstenabdeckung / Couvercle de brosse	460D3-31	1
49	BS24SADM-C49	Fixing Bracket / Befestigungsbügel / Support de fixation	460D3-31-A	1
50	TS-2208201	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M8x20L	2
51	TS-2361081	Spring Washer / Federscheibe / Rondelle élastique	M8	2
52	TS-1550061	Washer / Waschmaschine / Laveuse	M8	2
53	TS-2361061	Spring Washer / Federscheibe / Rondelle élastique	M6	1
54	BS24SADM-C54	Wing Screw / Flügelschraube / Vis à oreilles	M6x10L	1
55	TS-2246202	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x20L	1
56	BS24SADM-C56	Brush Shaft / Bürstenwelle / Arbre à brosse	460D2-59-1	1
57	BS24SADM-C57	Nut / Nuss / Écrou	M20	1
58	BS24SADM-C58	Transformer Shaft / Transformator-Welle / Arbre du transformateur	460D2-59-2	1
59	BS24SADM-C59	Key / Schlüssel / Clé	4x15L	4
60	BS24SADM-C60	Universal Joint / Kardangelenk / Joint universel	L25A4-02	2
61	TS-1522011	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	M5x6L	8
62	BS24SADM-C62	Universal Joint Cover / Kardanabdeckung / Couvercle du joint universel	L25A4-02-1	2
63	BS24SADM-C63	Universal Joint Plate / Kardangelenkplatte / Plaque de joint universel	460D3-31-C	1
64	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	2
65	BS24SADM-C65	Chip Motor Bracket / Chip-Motor-Halterung / Support du moteur à copeaux	460D3-31-B	1
66	TS-2361081	Spring Washer / Federscheibe / Rondelle élastique	M8	1
67	TS-2248202	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	1
68	BS24SADM-C68	Nut / Nuss / Écrou	M6	8
69	BS24SADM-C69	Chip Motor / Chip-Motor / Moteur à puce		1
70	BS24SADM-C70	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x90L	4
71	BS24SADM-C71	Saw Bow / Sägebügel / Arc de scie	460D3-10-A	1

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
72	TS-2361121	SpringWasher / Federscheibe / Rondelle élastique	M12	4
73	BS24SADM-C73	Hex. Cap Steel Screw / Sechskant. Stahlschraube mit Kappe / Hex. Vis à tête hexagonale en acier	M12x45L	4
74	BS24SADM-C74	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M12x70L	4
75	BS24SADM-C75	Shaft Washer / Wellenunterlegscheibe / Rondelle d'arbre	331D2-01-A	1
76	BS24SADM-C76	Lower Shaft / Unterer Schacht / Arbre inférieur	460D2-37	1
77	BS24SADM-C77	Lower Bracket / Untere Halterung / Support inférieur	460D1-18	1
78	TS-2248202	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x20L	2
79	BS24SADM-C79	Upper Shaft / Oberer Schacht / Arbre supérieur	460D2-38	1
80	BS24SADM-C80	Eye Bearing / Augenlager / Palier de l'œil	POS16	1
81	BS24SADM-C81	Nut / Nuss / Écrou	M20xP1.5	1
82	BS24SADM-C82	Lift Cylinder / Hubzylinder / Cylindre de levage		1
83	BS24SADM-C83	Ring / Ring / Anneau	S20	4
84	TS-2248402	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x40L	2
85	TS-2361081	SpringWasher / Federscheibe / Rondelle élastique	M8	2
86	BS24SADM-C86	PressBlock / Presse-Block / Bloc de presse	460D2-55	1
87	BS24SADM-C87	Support Plate / Trägerplatte / Plaque de support	460D1-08-A	2
88	TS-1550071	Washer / Waschmaschine / Laveuse	M10	4
89	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	4
90	TS-2249302	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x30L	4
91	BB32009	Bearing / Lager / Roulement	32009	2
92	BS24SADM-C92	Guide Roller Shaft / Führungsrolle Welle / Arbre du rouleau de guidage	460D2-11	2
93	BS24SADM-C93	Guide Roller / Führungsrolle / Rouleau de guidage	460D2-10	2
94	BB6005	Bearing / Lager / Roulement	6005	4
95	BS24SADM-C95	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M12x60L	2
96	TS-2361121	SpringWasher / Federscheibe / Rondelle élastique	M12	2
97	BS24SADM-C97	Washer / Waschmaschine / Laveuse	460D2-11-A	2
98	BS24SADM-C98	Ring / Ring / Anneau	R47	2
99	BS24SADM-C99	Nut / Nuss / Écrou	AN09	1
100	BS24SADM-C100	Teeth Washer / Zahnwaschmaschine / Lave-dents	AW09	1
101	BS24SADM-C101	Shaft Cover / Schachtabdeckung / Couvercle d'arbre 32009AV	460D4-08	2

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Index No.	Part No.	Description	Size	Q'ty
102	BS24SADM-C102	Idle Wheel / Leerlaufgrad / Roue libre	460D1-12	1
103	TS-1501091	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M4x35L	2
104	BS24SADM-C104	Limit Switch / Endschalter / Interrupteur de fin de course	AZD-S11	1
105	BS24SADM-C105	Nut / Nuss / Écrou	M8	2
106	BS24SADM-C106	Short Bracket / Kurze Klammer / Support court	460D3-27-A	1
107	BS24SADM-C107	Spacer / Abstandshalter / Entretoise	460D3-27-C	1
108	TS-2248252	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M8x25L	4
109	TS-2208201	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M8x20L	1
110	TS-2208201	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M8x20L	1
111	TS-2361081	SpringWasher / Federscheibe / Rondelle élastique	M8	1
112	TS-1521051	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	M4x12L	2
113	BS24SADM-C113	Safe Locker / Safe Schließfach / Coffre-fort	460D3-27-4	1
114	BS24SADM-C114	Spring / Frühling / Printemps		1
115	BS24SADM-C115	Spacer / Abstandshalter / Entretoise	460D3-27-6	1
116	BS24SADM-C116	HoldingBracket / Haltebügel / Support de maintien	460D3-27-2	1
117	BS24SADM-C117	Bracket Bush / Klammerbuchse / Douille de support	460D3-27-5	1
118	BS24SADM-C118	LongBracket / Lange Klammer / Support long	460D3-27	1
119	BS24SADM-C119	Handle / Handgriff / Poignée	3500217	2
120-1	BS24SADM-C120-1	Handwheel / Handrad / Roue à main	3500216	1
120-2	BS24SADM-C120-2	Nylon Nut / Nylon-Mutter / Écrou en nylon	M20	1
124	BB51105	Bearing / Lager / Roulement	51105	1
125	BS24SADM-C125	Blade Tension Gauge / Blattspannungsmessgerät / Jauge de tension de la lame	460D4-12	1
126	BS24SADM-C126	Screw Bushing / Schraubbuchse / Douille à vis	460D2-16-B	1
127	BS24SADM-C127	Plate / Platte / Assiette	460D2-48	1
128	BS24SADM-C128	Nut / Nuss / Écrou	M8	1
129	TS-1490111	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M8x60L	1
130-1	BS24SADM-C130-1	Lead Screw / Leitspindel / Vis de plomb	M20x425L	1
131	BS24SADM-C131	Disc Spring / Tellerfeder / Ressort de disque	502225	8
132	BS24SADM-C132	SpringPin / Federstift / Goupille à ressort	5x12L	2

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

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Index No.	Part No.	Description	Size	Q'ty
133	BS24SADM-C133	SpringBush / Federbusch / Buisson de printemps	460D2-47	1
134	TS-1501091	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M4x35L	2
135	BS24SADM-C135	Limit Switch / Endschalter / Interrupteur de fin de course	AZD-1001T	1
135-1	BS24SADM-C135-1	Nut / Nuss / Écrou	M20	1
136	BS24SADM-C136	Idle Wheel Washer / Leerlauf-Radwaschanlage / Rondelle de roue libre	460D2-12-C	1
137	BS24SADM-C137	Ring / Ring / Anneau	S45	2
138	BS24SADM-C138	Idle Wheel Shaft Set (type 120) / Leerlaufgrad-Wellensatz (Typ 120) / Jeu d'arbres de roue libre (type 120)	460D2-12	1
139	BS24SADM-C139	Slide (type 120) / Schlitten (Typ 120) / Diapositive (type 120)	460D2-13	1
140	BS24SADM-C140	Pin / Stift / Épingle	16x90L	1
141	TS-1526041	Socket Set Screw / Stellschraube mit Innensechskant / Vis à tête creuse	M12x25L	1
142	BS24SADM-C142	Slide Guide / Dia-Führer / Guide des diapositives	460D2-14	2
143	BS24SADM-C143	Slide Plate / Schiebepatte / Plaque de glissement	331D2-15	2
144	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	6
145	BS24SADM-C145	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M10x60L	6
146	BS24SADM-C146	Idle Wheel Cover (Type 120) / Leerlaufgradabdeckung (Typ 120) / Enjoliveur de roue de ralenti (Type 120)	460D3-11-A	1
147	TS-2246082	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M6x8L	4
148	BS24SADM-C148	Limit Switch / Endschalter / Interrupteur de fin de course	AZD-1001T	1
149	TS-1501091	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M4x35L	2
150	BS24SADM-C150	Limit Switch / Endschalter / Interrupteur de fin de course	ED-1-3-32	1
151	TS-1501091	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M4x35L	2
152	BS24SADM-C152	OillessBearing / Ölloses Lager / Palier sans huile	4040	2
153	BS24SADM-C153	Spacer / Abstandshalter / Entretoise	331D2-02-A	2
154	BS24SADM-C154	Key / Schlüssel / Clé	14x9x50	1
155	BS24SADM-C155	Gear Reducer / Untersetzungsgetriebe / Réducteur à engrenages	120#1/40	1
156	BS24SADM-C156	Motor / Motor / Moteur	5HP	1
157	TS-1491041	Hex. Cap Screw / Sechskant. Kopfschraube / Hex. Vis à tête hexagonale	M10x30L	4

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

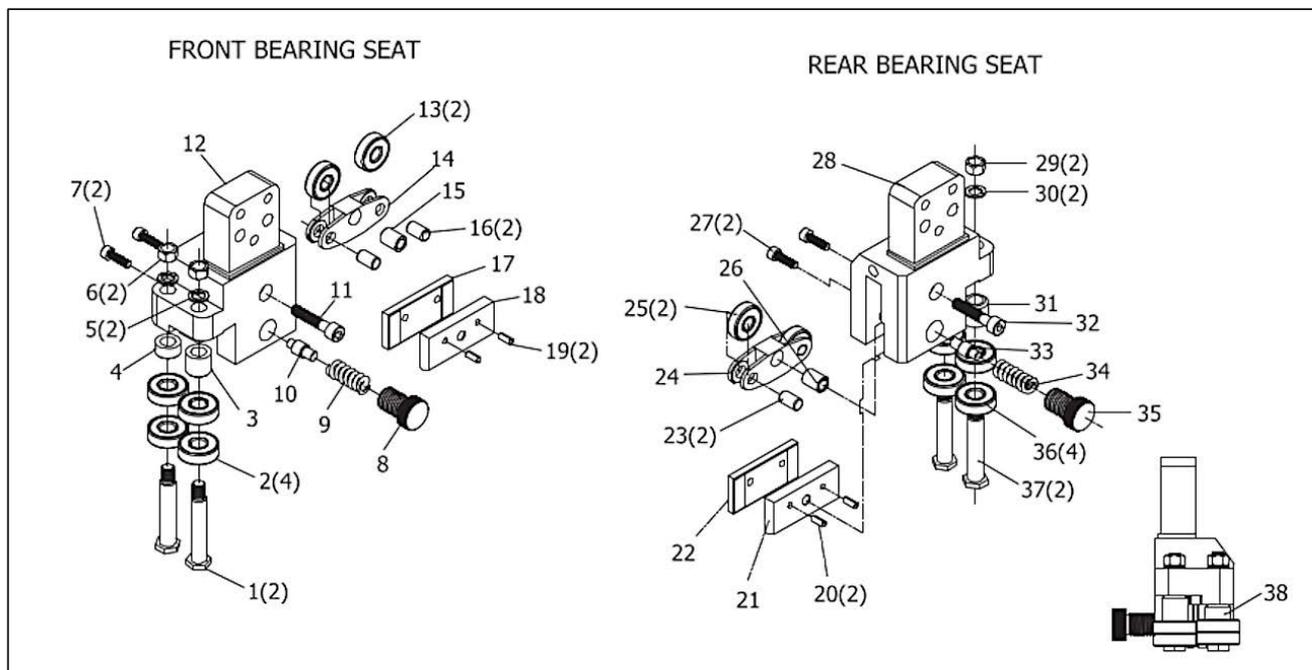
BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
158	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	4
160	BS24SADM-C160	Key / Schlüssel / Clé	10x8x40	1
161	BS24SADM-C161	Wheel Box (Type 120) / Radkasten (Typ 120) / Boîte à roues (Type 120)	460D3-15	1
162	BS24SADM-C162	Belt / Gürtel / Ceinture	1922V504	1
163	BS24SADM-C163	Speed Controlled Wheel (Variable) / Geschwindigkeitsgesteuertes Rad (variabel) / Roue à vitesse contrôlée (variable)	460D4-16	1
164	BS24SADM-C164	Speed Controlled Wheel (Fixing) / Geschwindigkeitsgesteuertes Rad (Fixierung) / Roue à vitesse contrôlée (fixation)	460D4-16	1
165	BS24SADM-C165	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x65L	1
166	BS24SADM-C166	Wheel Box Cover (Type 120) / Radkastenabdeckung (Typ 120) / Enjoliveur de boîte de vitesses (Type 120)	460D3-16	1
167	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	8
168	F009884	Socket Head Button Screw / Zylinderkopfschraube mit Innensechskant / Vis à tête creuse et à bouton	M5x8L	4
169	BS24SADM-C169	Cover Plate / Abdeckplatte / Plaque de couverture	460D3-16-A	1

EXPLOSION DRAWING / ERSATZTEILZEICHNUNG / VUE ÉCLATÉE

BS-24SA-DM

SECTION D - PARTS BREAKDOWN



PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
1	BS24SADM-D1	BearingLongShaft / Lager Lange Welle / Palier arbre long	L46F2-54	2
2	BB6201	Bearing / Lager / Roulement	6201	4
3	BS24SADM-D3	BearingSleeve (Long) / Lagerhülse (lang) / Douille de roulement (longue)	460D2-63B	1
4	BS24SADM-D4	BearingSleeve / Lagerhülse / Douille de palier	L46F2-55	1
5	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	2
6	TS-2311101	Nut / Nuss / Écrou	M10	2
7	TS-1503051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x20L	2
8	BS24SADM-D8	AdjustingScrew / Justierschraube / Vis de réglage	460D2-25	1
9	BS24SADM-D9	AdjustingSpring / Einstellfeder / Ressort de réglage	460D4-11	1
10	BS24SADM-D10	Guide Pin / Führungsstift / Goupille de guidage	3500210	1
11	TS-1504081	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x40L	1
12	BS24SADM-D12	Left Guide Block / Linker Führungsblock / Bloc de guidage gauche	460D1-09B	1
13	BB6200	Bearing / Lager / Roulement	6200	2
14	BS24SADM-D14	BearingBracket / Lagerkonsole / Support de palier	460D1-22	1
15	BS24SADM-D15	Shaft Sleeve / Wellenhülse / Manchon d'arbre	460D2-27	1
16	BS24SADM-D16	Bracket Shaft / Halterung Welle / Arbre du support		2
17	BS24SADM-D17	Guide Carbide / Führung Hartmetall / Guide Carbure	460D2-26	1
18	BS24SADM-D18	Guide Carbide / Führung Hartmetall / Guide Carbure	460D2-26A	1
19	BS24SADM-D19	SpringPin / Federstift / Goupille à ressort	D5x12L	2
20	BS24SADM-D20	SpringPin / Federstift / Goupille à ressort	D5x12L	2
21	BS24SADM-D21	Guide Carbide / Führung Hartmetall / Guide Carbure	460D2-26C	1
22	BS24SADM-D22	Guide Carbide / Führung Hartmetall / Guide Carbure	460D2-26B	1
23	BS24SADM-D23	BearingShaft / Halterung Welle / Arbre du support		2
24	BS24SADM-D24	BearingBracket / Lagerkonsole / Support de palier	460D1-22	1
25	BB6200	Bearing / Lager / Roulement	6200	2
26	BS24SADM-D26	Shaft Sleeve / Wellenhülse / Manchon d'arbre	460D2-27	1
27	TS-1503051	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M6x20L	2
28	BS24SADM-D28	Right Guide Block / Rechter Führungsblock / Bloc de guidage droit	460D1-10B	1
29	TS-2311101	Nut / Nuss / Écrou	M10	2
30	TS-2361101	SpringWasher / Federscheibe / Rondelle élastique	M10	2

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

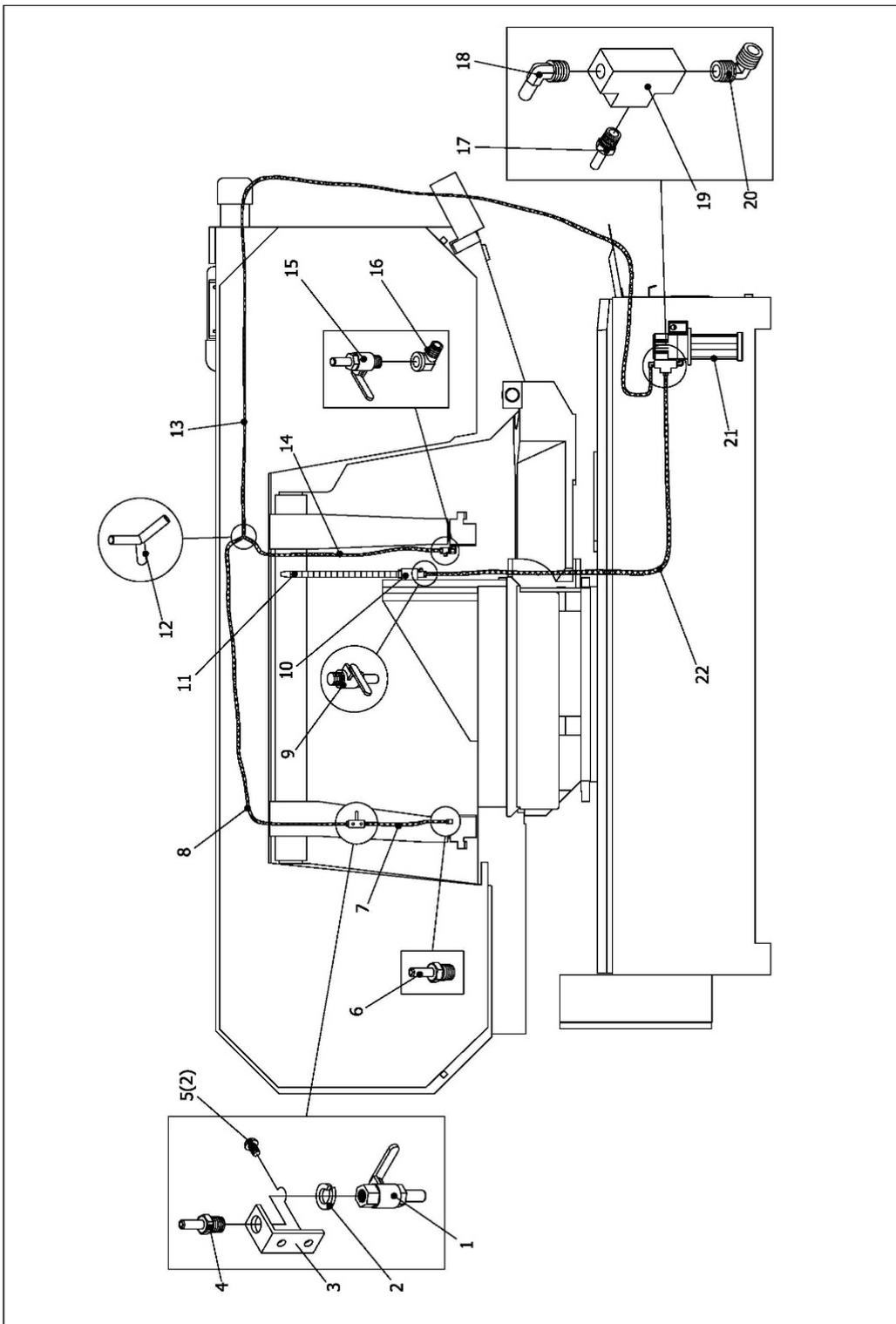
BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
31	BS24SADM-D31	BearingSleeve (Long) / Lagerhülse (lang) / Douille de roulement (longue)	460D2-63	1
32	TS-1504081	Socket Head Cap Screw / Zylinderschraube mit Innensechskant / Vis à tête creuse	M8x40L	1
33	BS24SADM-D33	Guide Pin / Führungsstift / Goupille de guidage	3500210	1
34	BS24SADM-D34	Spring / Frühling / Printemps	460D4-11	1
35	BS24SADM-D35	AdjustingScrew / Justierschraube / Vis de réglage		1
36	BB6201	Bearing / Lager / Roulement	6201	4
37	BS24SADM-D37	BearingLongShaft / Lager Lange Welle / Palier arbre long	L46F2-54	2
38	BS24SADM-D38	BearingSleeve / Lagerhülse / Douille de palier	L46F2-55	1

EXPLOSION DRAWING / ERSATZTEILZEICHNUNG / VUE ÉCLATÉE

BS-24SA-DM

SECTION E - PARTS BREAKDOWN



PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

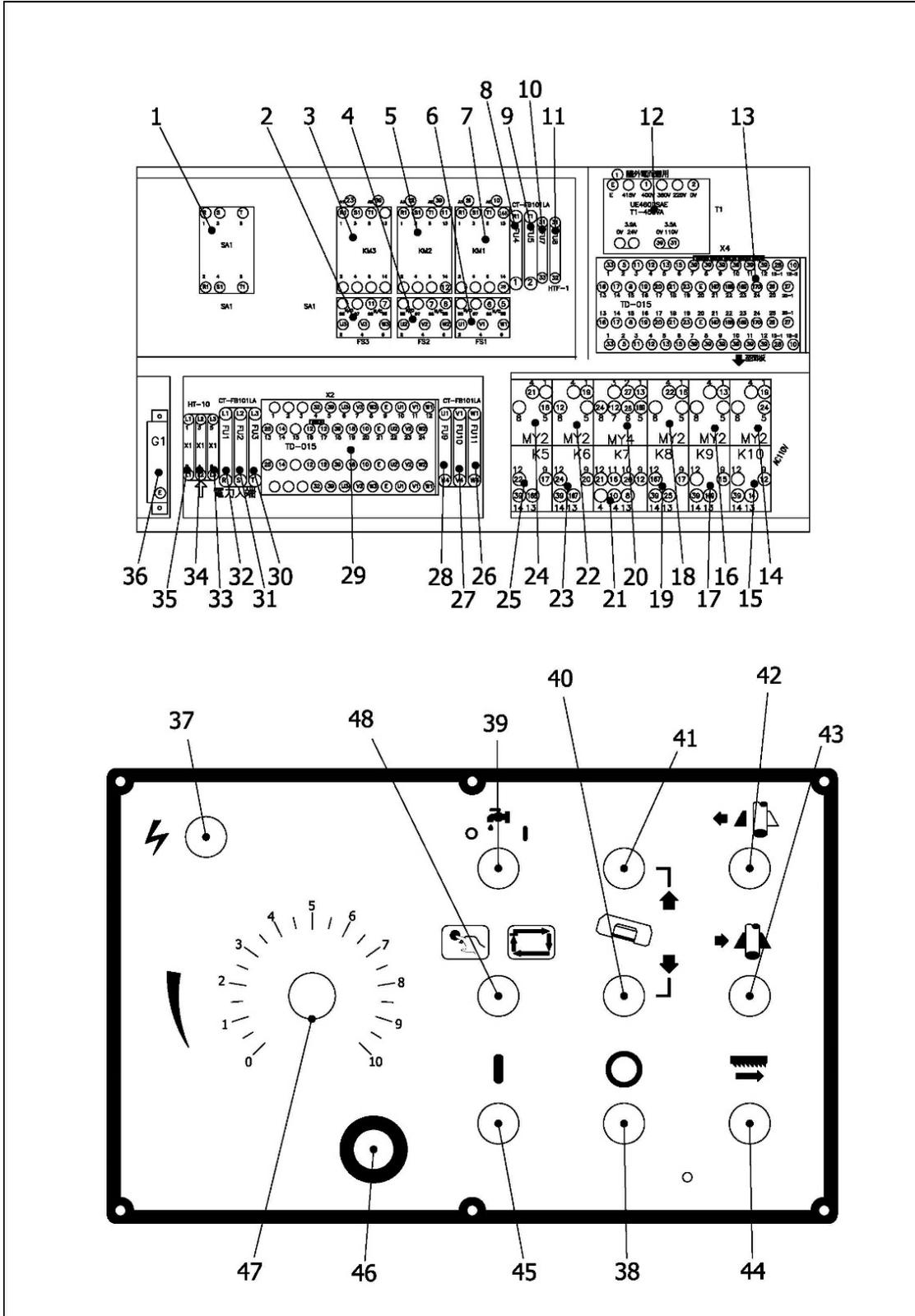
BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
1	BS24SADM-E1	Cock / Schwanz / Coq	1/4x1/4"	1
2	TS-2361121	SpringWasher / Federscheibe / Rondelle élastique	M12	1
3	BS24SADM-E3	FixingBracket / Befestigungsbügel / Support de fixation	331D3-22	1
4	BS24SADM-E4	Fitting / Einbau / Adaptation	1/4x1/4"	1
5	BS24SADM-E5	BigRound Head Screw / Große Rundkopfschraube / Grande vis à tête ronde	M6x8L	2
6	BS24SADM-E6	Fitting / Einbau / Adaptation	1/4x1/4"	1
7	BS24SADM-E7	Hose / Schlauch / Tuyau	185mmX1/4"	1
8	BS24SADM-E8	Hose / Schlauch / Tuyau	2215mmX1/4"	1
9	BS24SADM-E9	Cock / Schwanz / Coq	1/4x1/4"	1
10	BS24SADM-E10	Nozzle Set / Düsensatz / Jeu de buses	H46A2-39	1
11	BS24SADM-E11	Nozzle / Düse / Buse	1/4"x18"L	1
12	BS24SADM-E12	YFit / Y Passform / Y Fit	L25A4-60	1
13	BS24SADM-E13	Hose / Schlauch / Tuyau	2700mmX1/4"	1
14	BS24SADM-E14	Hose / Schlauch / Tuyau	1580mmX1/4"	1
15	BS24SADM-E15	Cock / Schwanz / Coq	1/4x1/4"	1
16	BS24SADM-E16	90° Fitting / 90°-Verschraubung / Raccord à 90	1/4x1/8"	1
17	BS24SADM-E17	Fitting / Einbau / Adaptation	3/8x1/4"	1
18	BS24SADM-E18	90° Fitting / 90°-Verschraubung / Raccord à 90	3/8x1/4"	1
19	BS24SADM-E19	FittingSet / Beschlagsatz / Kit de montage	3/8"	1
20	BS24SADM-E20	90° Fitting / 90°-Verschraubung / Raccord à 90	1/2x3/8"	1
21	BS24SADM-E21	Coolant Pump / Kühlmittelpumpe / Pompe de refroidissement	1/6HPx150L 220V/440v ,3Ph,2P	1
22	BS24SADM-E22	Hose / Schlauch / Tuyau	1400mmX1/4"	1

EXPLOSION DRAWING / ERSATZTEILZEICHNUNG / VUE ÉCLATÉE

BS-24SA-DM

SECTION F – PARTS BREAKDOWN



PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

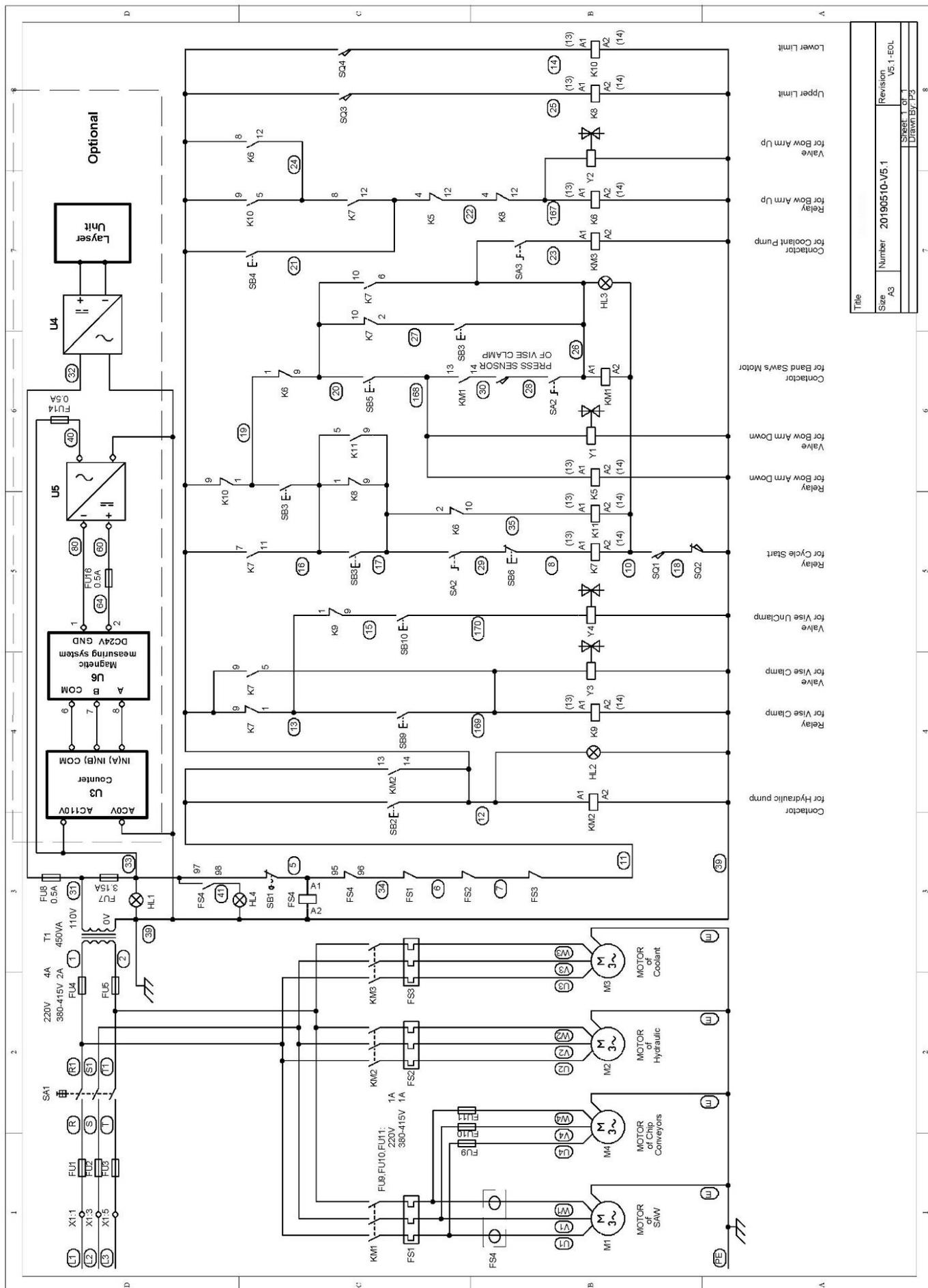
Index No.	Part No.	Description	Size	Q'ty
1	BS24SADM-F1	Power Switch / Netzschalter / Interrupteur d'alimentation		1
2	BS24SADM-F2	Coolant Overload Relay / Kühlmittel-Überlastrelais / Relais de surcharge du liquide de refroidissement	0.35-0.5A	1
3	BS24SADM-F3	Coolant Magnetic Switch / Magnetischer Schalter für Kühlmittel / Interrupteur magnétique pour le liquide de refroidissement		1
4	BS24SADM-F4	Hydraulic Overload Relay / Hydraulisches Überlastrelais / Relais de surcharge hydraulique	1.9-2.5A	1
5	BS24SADM-F5	Hydraulic Magnetic Switch / Hydraulischer Magnetschalter / Interrupteur magnétique hydraulique		1
6	BS24SADM-F6	Blade Overload Relay / Klinge Überlastrelais / Relais de surcharge de lame	8-11A	1
7	BS24SADM-F7	Blade Magnetic Switch / Klängenmagnetschalter / Interrupteur magnétique à lame		1
8	BS24SADM-F8	Transformer Power in Fuse / Transformator Leistung in Sicherung / Transformateur Puissance dans le fusible	FU4 2A	1
9	BS24SADM-F8	Transformer Power in Fuse / Transformator Leistung in Sicherung / Transformateur Puissance dans le fusible	FU5 2A	1
10	BS24SADM-F10	AC110VFuse / AC 110V-Sicherung / AC 110V Fusible	FU7 3.15A	1
11	BS24SADM-F11	AC110VFuse / AC 110V-Sicherung / AC 110V Fusible		1
12	BS24SADM-F12	Transformer / Transformator / Transformateur	450VA	1
13	BS24SADM-F13	Terminal Block / Klemmleiste / Bornier		1
14	BS24SADM-F14	Relay Base / Relaissockel / Base du relais	MY2	1
15	BS24SADM-F15	Relay / Relais / Relais		1
16	BS24SADM-F14	Relay Base / Relaissockel / Base du relais	MY2	1
17	BS24SADM-F17	Relay / Relais / Relais		1
18	BS24SADM-F18	Relay Base / Relaissockel / Base du relais	MY2	1
19	BS24SADM-F19	Relay / Relais / Relais		1
20	BS24SADM-F20	Relay Base / Relaissockel / Base du relais	MY4	1
21	BS24SADM-F21	Relay / Relais / Relais		1
22	BS24SADM-F14	Relay Base / Relaissockel / Base du relais	MY2	1
23	BS24SADM-F23	Relay / Relais / Relais		1
24	BS24SADM-F14	Relay Base / Relaissockel / Base du relais	MY2	1
25	BS24SADM-F25	Relay / Relais / Relais		1
26	BS24SADM-F26	Fuse / Sicherung / Fusible	FU11 1A	1
27	BS24SADM-F26	Fuse / Sicherung / Fusible	FU10 1A	1

PART LIST / ERSATZTEILLISTE / LISTE DES PIÈCES DÉTACHÉES

BS-24SA-DM

Index No.	Part No.	Description	Size	Q'ty
28	BS24SADM-F26	Fuse / Sicherung / Fusible	FU9 1A	1
29	BS24SADM-F29	Terminal Block / Klemmleiste / Bornier		1
30	BS24SADM-F30	Power in Fuse / Strom in der Sicherung / Puissance dans le fusible	FU3 16A	1
31	BS24SADM-F30	Power in Fuse / Strom in der Sicherung / Puissance dans le fusible	FU2 16A	1
32	BS24SADM-F30	Power in Fuse / Strom in der Sicherung / Puissance dans le fusible	FU1 16A	1
33	BS24SADM-F33	Power in Terminal / Strom im Terminal / Alimentation dans le terminal		1
34	BS24SADM-F33	Power in Terminal / Strom im Terminal / Alimentation dans le terminal		1
35	BS24SADM-F33	Power in Terminal / Strom im Terminal / Alimentation dans le terminal		1
36	BS24SADM-F36	GroundingPlate / Erdungsplatte / Plaque de mise à la terre		1
37	BS24SADM-F37	Power Indicator Light / Netzkontrollleuchte / Voyant d'alimentation		1
38	BS24SADM-F38	Blade Stop Button / Klingenstopp-Taste / Bouton d'arrêt de la lame		1
39	BS24SADM-F39	Coolant Start Switch / Kühlmittel-Startschalter / Interrupteur de démarrage du liquide de refroidissement		1
40	BS24SADM-F40	Bow Down Button(Green) / Bow Down Button(Grün) / Bouton Bow Down (vert)		1
41	BS24SADM-F41	Bow Up Button(Black) / Bow Up Knopf (Schwarz) / Bouton à nœud(Noir)		1
42	BS24SADM-F42	Vise Open Button(Green) / Schraubstock-Öffnen-Taste (grün) / Bouton d'ouverture de l'étau (vert)		1
43	BS24SADM-F43	Vise Close Button(Black) / Schraubstock-Schließknopf (schwarz) / Bouton de fermeture de l'étau (noir)		1
44	BS24SADM-F44	Blade Start Button / Klinge Start-Taste / Bouton de démarrage de la lame		1
45	BS24SADM-F45	HydraulicStart Button / Hydraulischer Startknopf / Bouton de démarrage hydraulique		1
46	BS24SADM-F46	Emergency Stop Button / Not-Aus-Taste / Bouton d'arrêt d'urgence		1
47	BS24SADM-F47	CuttingFeed Rate Valve / Schneidvorschub-Ventil / Vanne d'avance de coupe		1
48	BS24SADM-F48	Select Switch / Schalter wählen / Commutateur de sélection		1

ELECTRICAL DIAGRAM / ELEKTRISCHE ANLAGE / SCHÉMA ÉLECTRIQUE (400V)



Title	
Size	Number
A3	20190510-V5.1
Revision	V5.1-EOL
Sheet 1 of 1	Drawn By: P3



ENVIRONMENTAL PROTECTION

Protect the environment.

Your appliance contains valuable materials which can be recovered or recycled. Please leave it at a specialized institution.



This symbol indicates separate collection for electrical and electronic equipment required under the WEEE Directive (Directive 2012/19/EC) and is effective only within the European Union.



UMWELTSCHUTZ

Schützen Sie die Umwelt!

Ihr Gerät enthält mehrere unterschiedliche, wiederverwertbare Werkstoffe. Bitte entsorgen Sie es nur an einer spezialisierten Entsorgungsstelle.



Dieses Symbol verweist auf die getrennte Sammlung von Elektro- und Elektronikgeräten, gemäß Forderung der WEEE-Richtlinie (2012/19/EU). Diese Richtlinie ist nur innerhalb der Europäischen Union wirksam.



PROTECTION DE L'ENVIRONNEMENT

Protégez l'environnement!

Votre appareil comprend plusieurs matières premières différentes et recyclables. Pour éliminer l'appareil usagé, veuillez l'apporter dans un centre spécialisé de recyclage des appareils électriques.



Ce symbole indique une collecte séparée des équipements électriques et électroniques conformément à la directive DEEE (2012/19/UE). Cette directive n'est efficace que dans l'Union européenne.





WARRANTY / GARANTIE

TOOL FRANCE guarantees that the supplied product(s) is/are free from material defects and manufacturing faults. This warranty does not cover any defects which are caused, either directly or indirectly, by incorrect use, carelessness, damage due to accidents, repairs or inadequate maintenance or cleaning as well as normal wear and tear.

Further details on warranty (e.g. warranty period) can be found in the General Terms and Conditions (GTC) that are an integral part of the contract.

These GTC may be viewed on the website of your dealer or sent to you upon request.

TOOL FRANCE reserves the right to make changes to the product and accessories at any time.

TOOL FRANCE garantiert, dass das/die von ihr gelieferte/n Produkt/e frei von Material- und Herstellungsfehlern ist. Diese Garantie deckt keinerlei Mängel, Schäden und Fehler ab, die - direkt oder indirekt - durch falsche oder nicht sachgemäße Verwendung, Fahrlässigkeit, Unfallschäden, Reparaturen oder unzureichende Wartungs- oder Reinigungsarbeiten sowie durch natürliche Abnutzung durch den Gebrauch verursacht werden.

Weitere Einzelheiten zur Garantie können den allgemeinen Geschäftsbedingungen (AGB) entnommen werden.

Diese können Ihnen auf Wunsch per Post oder Mail zugesendet werden.

TOOL FRANCE behält sich das Recht vor, jederzeit Änderungen am Produkt und am Zubehör vorzunehmen.

TOOL FRANCE garantit que le/les produit(s) fourni(s) est/sont exempt(s) de défauts matériels et de défauts de fabrication. Cette garantie ne couvre pas les défauts, dommages et défaillances causés, directement ou indirectement, par l'utilisation incorrecte ou inadéquate, la négligence, les dommages accidentels, la réparation, la maintenance ou le nettoyage incorrects et l'usure normale.

Vous pouvez trouver de plus amples détails sur la garantie dans les conditions générales (CG). Les CG peuvent être envoyées sur demande par poste ou par e-mail.

TOOL FRANCE se réserve le droit d'effectuer des changements sur le produit et les accessoires à tout moment.

UK DECLARATION OF CONFORMITY

Edition March 2024

Product:

METAL BAND SAW

Model:

BS-24SA-DM

Brand:

BAILEIGH

Manufacturer or authorized representative:

TOOL FRANCE

Unit 1a Stepnell Park

Off Lawford Road

Rugby

CV21 2UX

United Kingdom

We hereby declare that this product complies with the regulations:

SUPPLY OF MACHINERY (SAFETY) REGULATIONS 2008
ELECTROMAGNETIC COMPATIBILITY REGULATIONS 2016

Designed in consideration of the standards:

EN ISO 12100 :2018

EN ISO 13849-1 : 2015

EN ISO 16093 : 2017

EN 60204-1 : 2018

Responsible for the documentation / Dokumentations-Verantwortung / Responsable de la documentation :



JÉRÔME GERMAIN

GENERAL MANAGER

DIRECTEUR GÉNÉRAL

N° de série / serial number :

At lisses / Hergestellt in / Fait à Lisses

Date :

**CE-CONFORMITY DECLARATION
CE-KONFORMITÄTSERKLÄRUNG
DÉCLARATION DE CONFORMITÉ CE**

Edition March 2024

Product/Produkt/Produit:

Metal Band Saw / Scie A Ruban A Métal / Metallbandsäge

BS-24SA-DM

Brand/Marke/Marque:

BAILEIGH

Manufacturer or authorized representative/Hersteller oder Bevollmächtigter/Fabricant ou son mandataire:

TOOL FRANCE

9 Rue des Pyrénées, 91090 LISSES, France

We hereby declare that this product complies with the regulations
Wir erklären hiermit, dass dieses Produkt der folgenden Richtlinie entspricht
Par la présente, nous déclarons que ce produit correspond aux directives suivantes

2006/42/EC

Machinery Directive / Maschinenrichtlinie / Directive Machines

designed in consideration of the standards
und entsprechend folgender zusätzlicher Normen entwickelt wurde
et été développé dans le respect des normes complémentaires suivantes

EN ISO 12100 :2018

EN ISO 13849-1 : 2015

EN ISO 16093 : 2017

EN 60204-1 : 2018

Original instruction manual / Original-Bedienungsanleitung / Notice d'instruction Originale
Responsible for the documentation / Dokumentations-Verantwortung / Responsable de la documentation :



JÉRÔME GERMAIN

GENERAL MANAGER

DIRECTEUR GÉNÉRAL

N° de série / serial number :

At lisses / Hergestellt in / Fait à Lisses

Date :