

18" Woodworking Bandsaw



Operator's Manual

Record the serial number and date of purchase in your manual for future reference.

Serial Number: _____ Date of purchase: _____

For technical support or parts questions, email techsupport@rikontools.com or call toll free at (877)884-5167

Operator Safety: Required Reading

IMPORTANT! Safety is the single most important consideration in the operation of this equipment. **The following instructions must be followed at all times.**

There are certain applications for which this tool was designed. We strongly recommend that this tool not be modified and/or used for any other application other than that for which it was designed. If you have any questions about its application, do not use the tool until you have contacted us and we have advised you.

General Safety Warnings

KNOW YOUR POWER TOOL. Read the owner's manual carefully. Learn the tool's applications, work capabilities, and its specific potential hazards.

⚠ DANGER



ALWAYS GROUND ALL TOOLS.

If your tool is equipped with a three-pronged plug, you must plug it into a three-hole electric receptacle. If you use an adapter to accommodate a two-pronged receptacle, you must attach the adapter plug to a known ground. Never remove the third prong of the plug.

ALWAYS AVOID DANGEROUS ENVIRONMENTS.

Never use power tools in damp or wet locations. Keep your work area well lighted and clear of clutter.

⚠ DANGER



ALWAYS REMOVE THE ADJUSTING KEYS AND WRENCHES FROM TOOLS AFTER USE.

Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.

ALWAYS KEEP YOUR WORK AREA CLEAN. Cluttered areas and benches invite accidents.

⚠ DANGER



ALWAYS KEEP VISITORS AWAY FROM RUNNING MACHINES.

All visitors should be kept a safe distance from the work area.

ALWAYS MAKE THE WORKSHOP CHILDPROOF.

Childproof with padlocks, master switches, or by removing starter keys.

⚠ DANGER



NEVER OPERATE A TOOL WHILE UNDER THE INFLUENCE OF DRUGS, MEDICATION, OR ALCOHOL.

⚠ DANGER



ALWAYS WEAR PROPER APPAREL.

Never wear loose clothing or jewelry that might get caught in moving parts. Rubber-soled footwear is recommended for the best footing.

⚠ DANGER



ALWAYS USE SAFETY GLASSES AND WEAR HEARING PROTECTION.

Also use a face or dust mask if the cutting operation is dusty.

⚠ DANGER



NEVER OVERREACH.

Keep your proper footing and balance at all times.

⚠ DANGER



NEVER STAND ON TOOLS.

Serious injury could occur if the tool is tipped or if the cutting tool is accidentally

⚠ DANGER**ALWAYS DISCONNECT TOOLS.**

Disconnect tools before servicing and when changing accessories such as blades, bits, and cutters.

**ALWAYS AVOID ACCIDENTAL STARTING.**

Make sure switch is in "OFF" position before plugging in cord.

NEVER LEAVE TOOLS RUNNING UNATTENDED.**⚠ DANGER****ALWAYS CHECK FOR DAMAGED PARTS.**

Before initial or continual use of the tool, a guard or other part that is damaged should be checked to assure that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other damaged parts should immediately be properly repaired or replaced.



Special Safety Rules For Bandsaws

1. Always allow the Bandsaw blade to stop before removing scrap pieces from table.
2. Always keep hands and fingers away from the blade.
3. Never attempt to saw stock that does not have a flat surface, unless a suitable support is used.
4. Always hold material firmly and feed it into the blade at a moderate speed.
5. Always turn off the machine if the material is to be backed out of an uncompleted cut.
6. Adjust the upper guide about 1/8" above the material being cut.
7. Check for proper blade size and type for thickness and type of material being cut.
8. Make sure that the blade tension and blade tracking are properly adjusted.
9. Make "relief" cuts before cutting long curves.
10. Release blade tension when the saw will not be used for a long period of time.

Note: This owner's manual is not a teaching aid. Use of this owner's manual is intended to show assembly, adjustments, and general use.

SAVE THESE INSTRUCTIONS.
Refer to them often.

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Specifications

Model No.	10-345
Motor	
Horsepower	2-1/2 HP
Amps	11
Volts	220V, 60 Hz
Speed Range	1,510/3,220 FT/MIN
Cutting Capacity	
Height	12"
Width	18-3/8"
Blade	
Width	1/4" - 1-1/4"
Length	142"
Table	
Size	21" x 19"
Left Tilt	-10°
Right Tilt	45°
Miter Gauge Slot	(2) 3/8" x 3/4"
Height to Floor	37-3/4"
Overall	
Height	76"
Width	35-3/4"
Depth	26-1/2"
Base Size	29-15/16" x 18-1/8" x 2-7/16"
Net Weight	389 lbs.
Shipping Weight	446 lbs.
Shipping Carton	36" x 21-3/4" x 79"
Warranty	5 Years

Contents of Package

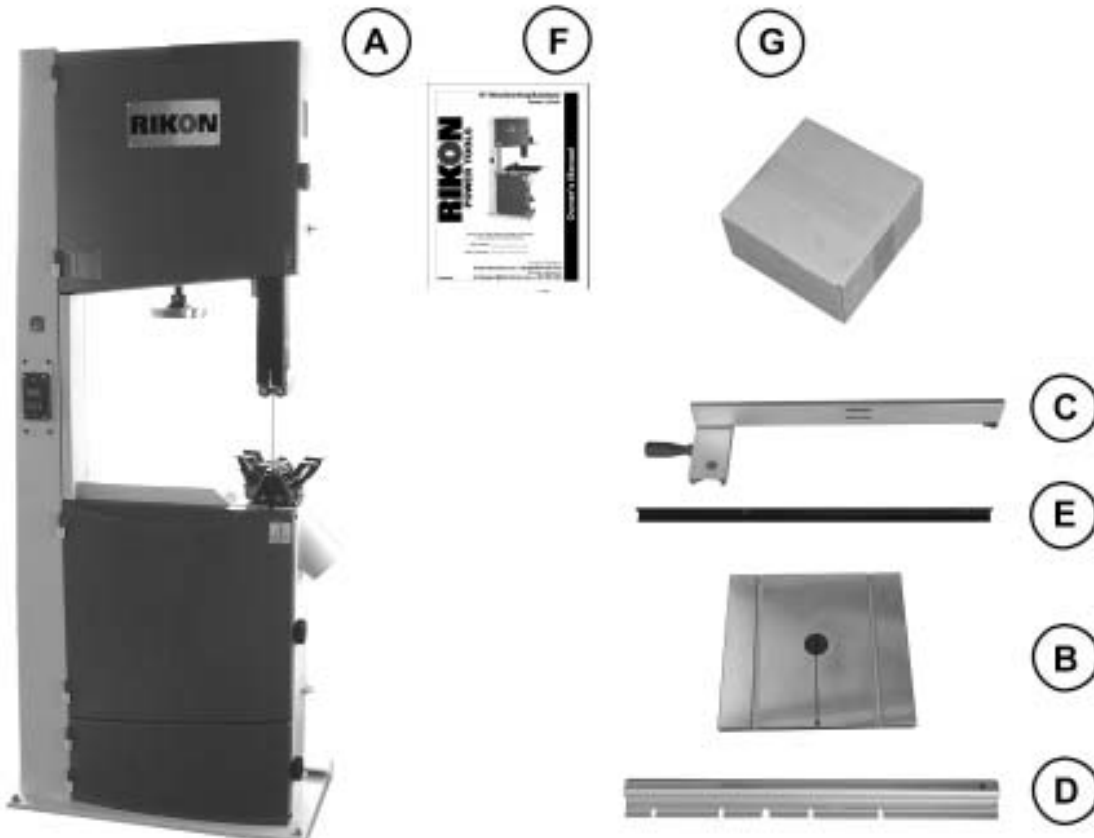
Model 10-345 18" Bandsaw is shipped complete in one box.

Unpacking and Checking Contents

- a. Separate all "loose parts" from packaging materials and check each item with "Table of Loose Parts" to make sure all items are accounted for, before discarding any packaging material.
- b. Thread hoist ring into threading hole on top of Bandsaw frame. This allows the user to connect a properly secured hoist mechanism to lift the Bandsaw.
- c. With the help of another person or by installing hoist ring, unbolt the Bandsaw from the packing pallet. Properly lift the Bandsaw off the packing pallet and place on level floor.
- d. Remove protective oil that is applied to the table. Use any ordinary house hold type grease or spot remover.
- e. Apply a coat of paste wax to the table to prevent rust. Wipe all parts thoroughly with a clean dry cloth.

TABLE OF LOOSE PARTS

Item	Part Name	Qty
A	Bandsaw Assembly	1
B	Table w/insert	1
C	Rip fence Assembly	1
D	Front guide rail	1
E	Rear guide rail	1
F	Owner's manual	1
G	Box of loose parts	1



Loose Parts List

List of loose parts in the box marked "G"



Hex head bolt M8x25 1pc



Hex nut M8-1.25 1pc



Hex head bolt M8x16 4pcs



Washer 8mm 4pcs



Spring washer 4pcs



Hex head bolt M6x12 2pcs



Washer 6mm 2pcs



Wing screw M8 4pcs



Washer 8mm 4pcs



Wing nut 1pc



Sleeve 1pc



Hex head screw 1pc



Resaw bar 1pc



Sleeve 1pc



Lever 1pc



Handwheel 1pc



Handwheel 1pc



Hoist Ring 1pc



L wrench 3mm 1pc



L wrench 4mm 1pc

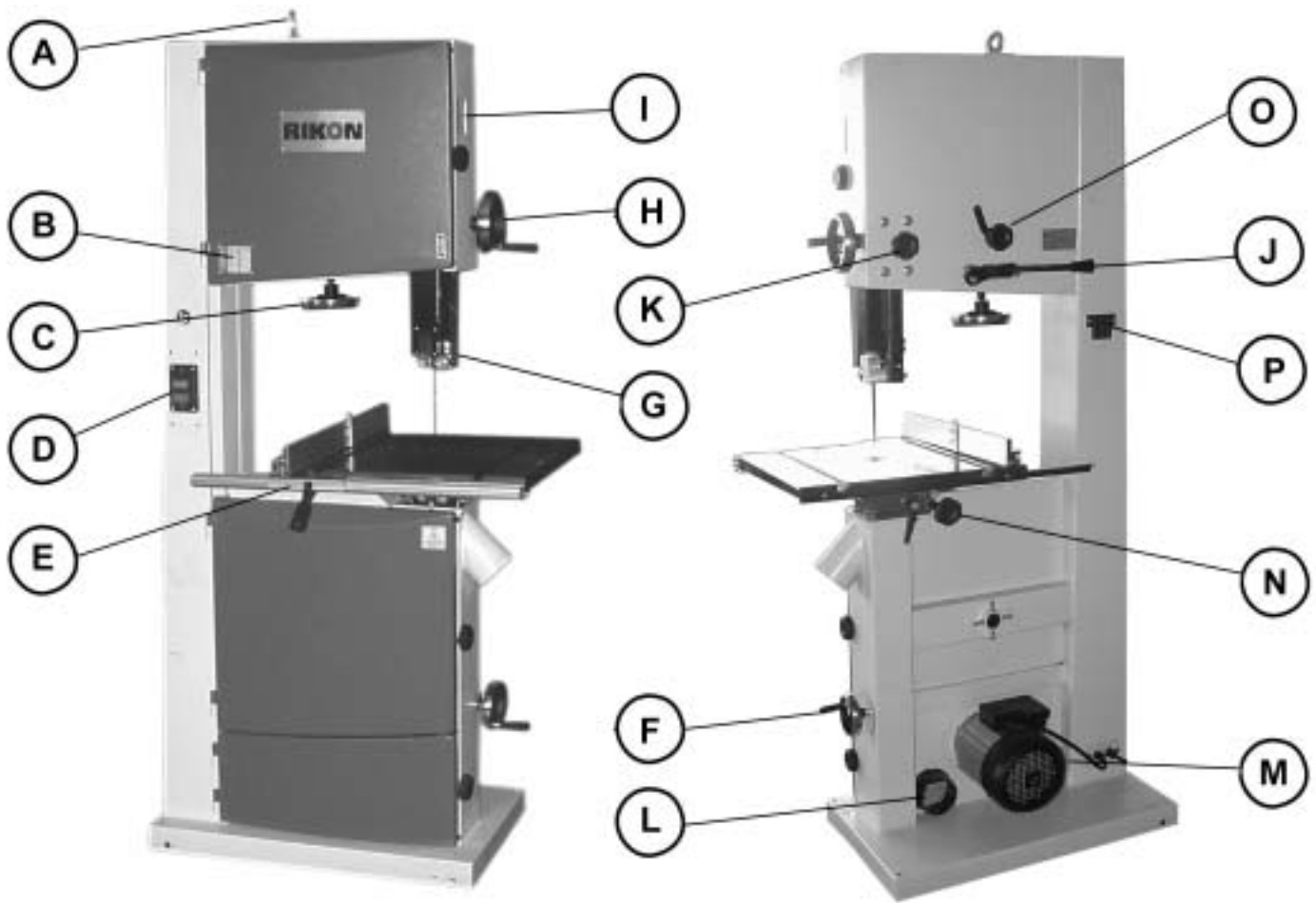


L wrench 5mm 1pc



L wrench 6mm 1pc

Getting to Know Your Bandsaw



- A. Hoist Ring
- B. Tension Indicator Window
- C. Blade Tension Hand-Wheel
- D. Switch
- E. Rip Fence
- F. Speed Hand-Wheel
- G. Blade Guide
- H. Guide Post Hand-Wheel

- I. Blade Tracking Window
- J. Quick Release Lever
- K. Guide Post Lock Knob
- L. 4" Dust Ports
- M. Motor
- N. Table Tilting Knob
- O. Blade Tracking Knob
- P. Tool Holder

Assembly

The 10-345 Bandsaw is supplied partly assembled. Prior to use, the following items have to be assembled: working table, rip fence and hand-wheels.

WARNING! To ensure sufficient upright stability and safety of this Bandsaw, you need to bolt the Bandsaw to the floor with M10 screws.(Fig 1) (not supplied)

Assemble Working Table

Installing 90° table stop: Thread screw (M8x25) and nut (M8-1.25) to the bottom of the table. (Shown Fig. 5A)

With the help of another person, lift the working table onto the trunnion.

Mount the working table to the trunnion using the supplied (4) hex bolts, (4) lock washers and (4) washers (A--Fig.2).

Installing Table Leveling Screw: Insert the hex socket screw and washer through top of table. Place bushing and wing nut from under the table and tighten. (B--Fig. 2)

Rip Fence Assembly

Install the rear fence rail to the table with (2) M6-1.0 x 20 hex bolts and (2) flat washers M6 (Fig. 3).

Install the front fence rail to the table with (4) thumbscrews and (4) flat washers M8 (Fig. 3).

Make sure the end cap is locked into the rear fence rail. Then set the fence on the front and rear rails.

Assemble Hand-Wheels

Attach the large crank handle (Fig. 4) to the rack and pinion shaft on the upper part of the bandsaw, using the 5mm "L" wrench provided.

Attach the small crank handle (Fig. 4) to the belt and speed control rod on the lower right side of the bandsaw, using the 5mm "L" wrench provided.



Figure 1

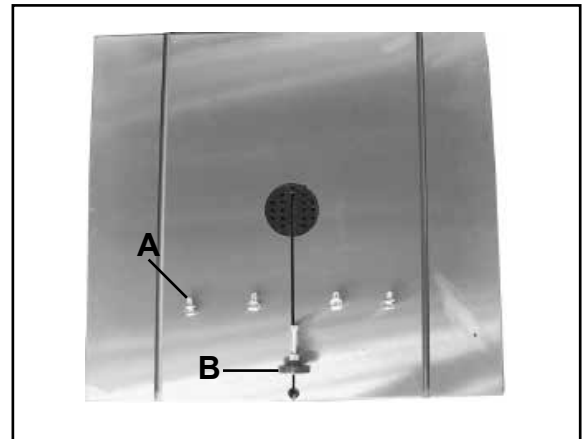


Figure 2

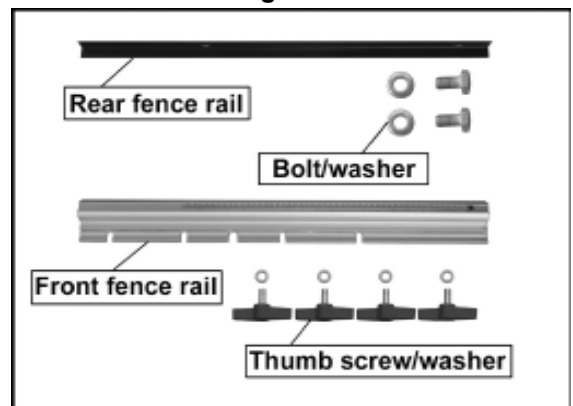


Figure 3



Figure 4

Adjustments

Setting the Table Square to Saw Blade

The table may be set at 90° to the saw blade sides by adjusting the table stop screw under the table. The table stop screw rests on the top of the quick release adjustment stop. By first loosening the locking nut (A--Fig. 5) and then adjusting the screw (B--Fig. 5), the table can be set correctly. Retighten the locking nut (A--Fig. 5) making sure that the setting is maintained.

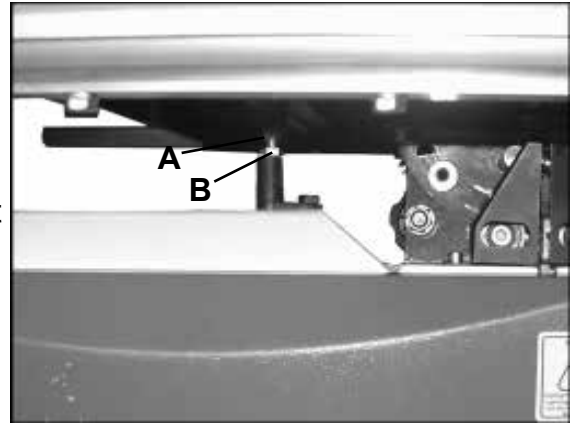


Figure 5
Figure 6

The table may also be set at 90° to the back of the saw blade by adjusting the trunnion micro adjustment screws. First, slightly loosen part #98 (refer to parts explosion on page 18 of this manual). Using the 3mm "L" wrench, turn the rear trunnion micro adjusting screws part #125. Turning the screws clockwise will raise the trunnion; counterclockwise will lower. Check table for 90° and tighten part #98.

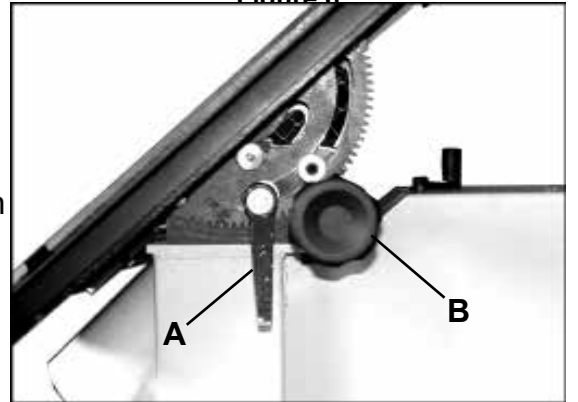


Figure 7

Tilting the Table

Loosen the lock handle (A--Fig. 6) on the table trunnion. Turn the table tilting knob (B--Fig. 6) to adjust the table to the desired angle. Use the angle indicator scale on the trunnion bracket to find the desired angle. Retighten the lock handle to secure the table.

Tracking the Saw Blade

Caution! Unplug the Bandsaw. First, make sure the upper and lower blade guides are adjusted away from the blade and the tension scale is set to correspond to the width of the blade you are using.

Then loosen the lock lever (A--Fig. 7) by turning it counter clockwise and turn the blade tracking knob (B--Fig. 7) clockwise/counterclockwise while turning the upper wheel by hand at least three rotations until the blade tracks centered on the wheel. Finally, tighten the lock lever and close the doors.

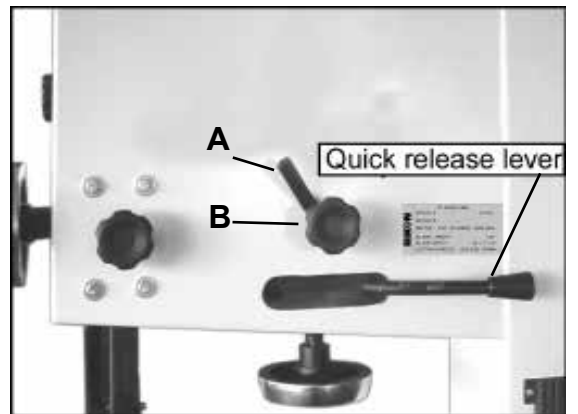
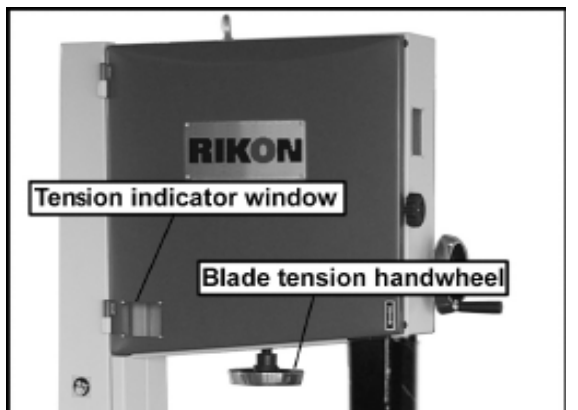


Figure 8

Adjusting the Blade Tension

To loosen the tension of the blade, turn the blade tension handwheel (Fig. 8) counter clockwise. To tighten the tension of the blade, turn the blade tension handwheel clockwise.



Tension the blade until the tension readings correspond

Adjusting the Blade Guides

Upper Guides: To adjust the upper blade guides, first position the roller guides relative to the blade by loosening the locking hex screw (A--Fig. 9) and moving the guide carrier until the roller guides are approximately 1/16" behind the gullets of the Bandsaw blade and tighten the hex nut (A--Fig. 9). Next set the roller guides to within 1/32" of the blade by releasing the screw (B--Fig. 9) on each side of the blade. Do not set the guides too close, as this will adversely affect the life of the blade. Finally, adjust the thrust bearing to be just clear of the back of the blade by unlocking the hex nut (C--Fig. 9). When the correct adjustment is reached, lock the thrust bearing in position with the hex nut (C--Fig. 9).

Lower Guides: To adjust the lower blade guides, first loosen the hex nut (A--Fig. 10) then move the guide carrier casting to allow the front to be approximately 1/16" behind the gullets of the Bandsaw blade and tighten the hex nut (A--Fig. 10). Next set the roller guides to within 1/32" of the blade by releasing the screw (B--Fig. 10) on each side of the blade. Adjust the thrust bearing to be just clear of the back of the blade by unlocking the hex nut (C--Fig. 10), and turning adjusting knob (D--Fig. 10). Finally, tighten hex nut (C--Fig. 10).

Make sure doors are closed, turn the bandsaw on and inspect that the upper, lower and thrust bearings are not turning. All bearings should not turn unless pressure from workpiece is applied to the blade. If bearings are turning under no pressure, repeat steps to adjust the blade guides.

Adjusting the Rip Fence Guide Scale

Slide the rip fence against the blade along the rail and loosen the indicator screw (A--Fig. 11). Then move the scale (B--Fig. 11) sideways and align the zero on the scale with the line on the magnifying window (C--Fig. 11). Retighten the indicator screw when the adjustment is correct.

Adjusting the Cutting Height

Loosen the guidepost lock knob (Fig. 12) and turn the guidepost handwheel (Fig. 12) to raise or lower the guide post/upper blade guide assembly to the desired height. Then tighten the guidepost lock knob. Note: The bottom edge of the guide bearings should be

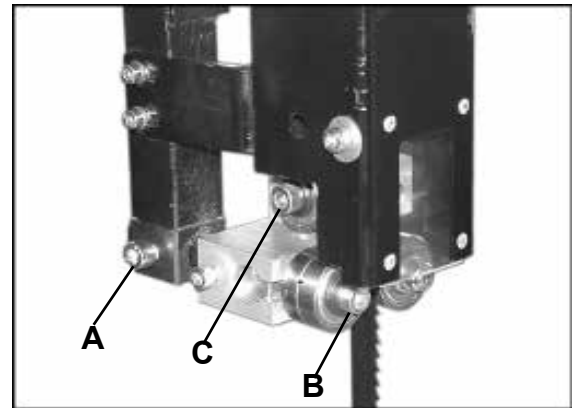


Figure 9

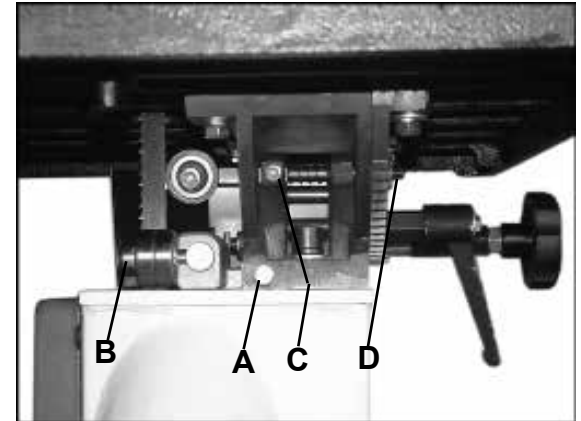


Figure 10

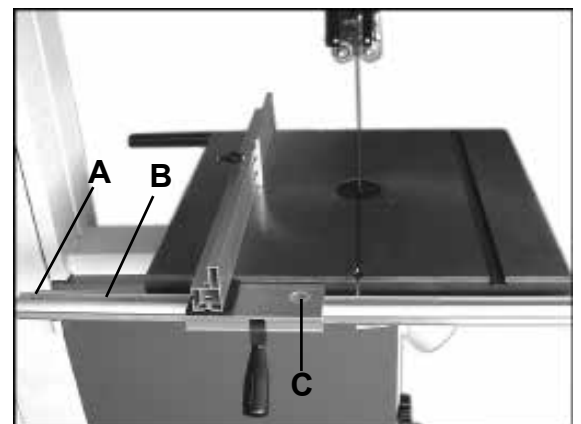


Figure 11



Figure 12

Changing the Blade Speed / Belt Tension

WARNING! Before changing the speed, always make sure the machine has been unplugged from the electrical supply.

This Bandsaw has two blade speeds, low speed (1510 ft/min) and high speed (3220 ft/min).

The lower wheel (A--Fig. 13) has two integral “V” form pulleys, and the motor shaft has a twin multi-vee form pulley (B--Fig. 13). The “V” belt (C--Fig. 13) passes around the wheel pulley and the motor pulley. The belt tension is released and applied by using the handwheel (D--Fig. 13).

For the high speed (3220 ft/min), the belt should be fitted to the rear pulley on both the motor and the wheel, as shown in Fig. 13.

For the low speed (1510 ft/min), the belt should be fitted to the front pulley on both the motor and wheel, as shown in Fig. 13.

To properly adjust belt tension, turn hand-wheel (D--Fig. 13) until there is 1/2” deflection in the “V” belt.

Replacing the Bandsaw Blade

Caution! Unplug the machine from the electrical supply. This ensures that the Bandsaw will not accidentally turn on if the ON/OFF switch is bumped.

- Open the top and bottom wheel doors by turning the door locking knobs.
- Remove the rip fence rail from the front of the table by loosening the 4 thumbscrews (Fig. 3 on page 8).
- Release the blade tension by moving the quick release lever (A--Fig. 14) from right to left. Open the hinged door on the blade guard by loosening the hex screw. (Fig. 15 on page 12)
- Remove the saw blade by feeding it through the slot in the table, upper and lower blade guides and the slot in the spine of the machine, being careful not to cut yourself. Wear gloves for protection.
- When installing the new blade, ensure the blade teeth are pointing downwards and towards you at

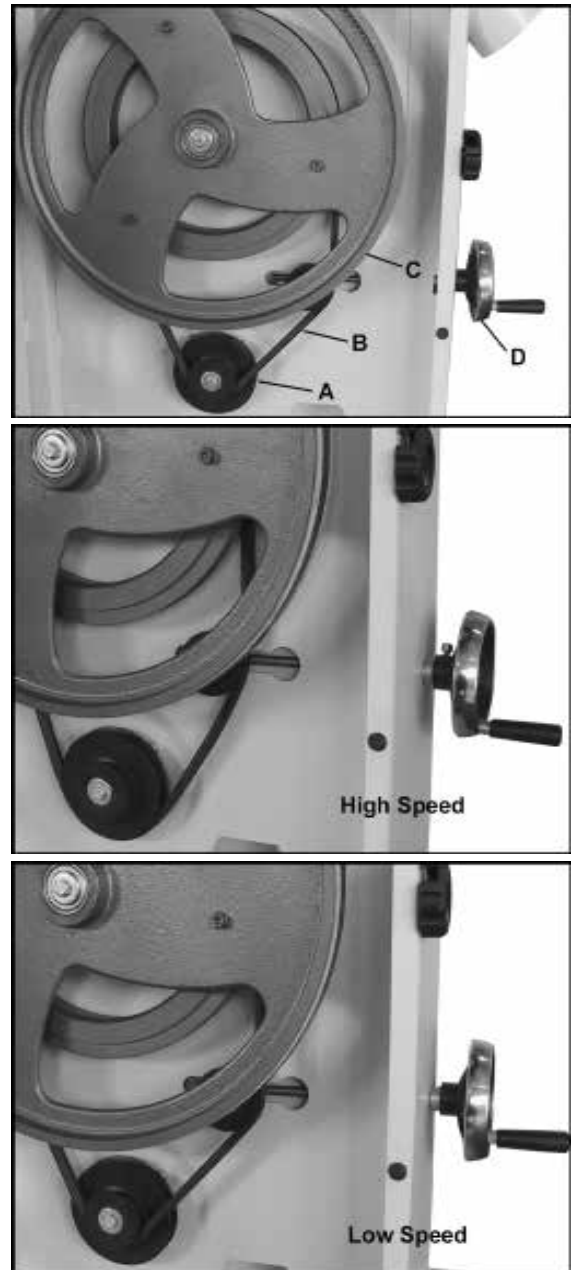


Figure 13

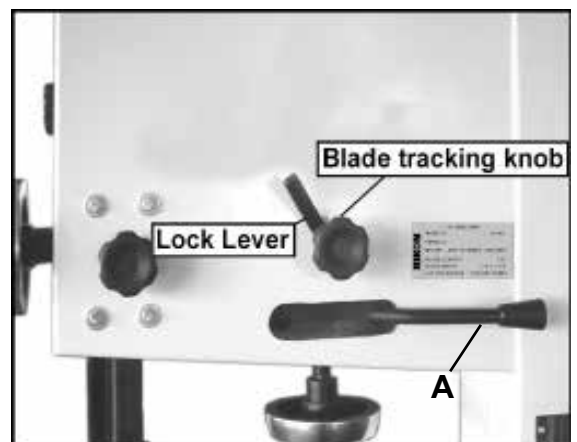


Figure 14

Replacing the Bandsaw Blade Cont.

- f) Re-tension the new blade by moving the quick release lever (Fig. 14 on page 11) right to left and check the blade tracking. The blade should run in the center of the wheel. Refer to “Tracking the Saw Blade” on page 6 for more details.
- g) Reset the blade guides as described in the section “Adjusting the Blade Guides” on page 10.
- h) Reset the blade tension as described in the section “Adjusting the Blade Tension” on page 9.
- i) Replace the rip fence guide, and retighten the 4 thumb-screws (Fig. 3 on page 8).
- j) Close the hinged door on the blade guard and tighten the hex screw. (Fig. 15)
- k) Close and lock both the wheel doors before reconnecting the power supply.

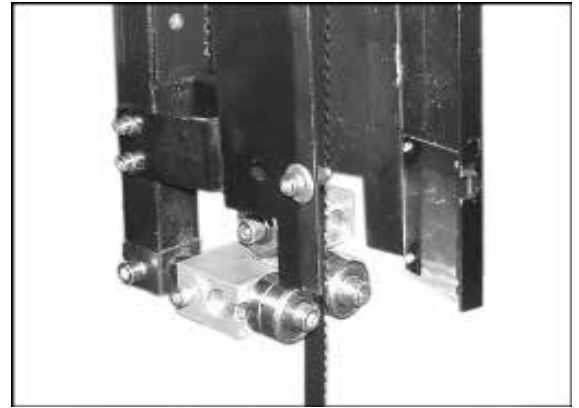


Figure 15

Re-sawing

For re-sawing, attach the 3/8” x 3” post to the slot on the fence. Position the re-saw bar so that it is aligned with the front of the blade. The re-saw bar helps to correct any blade wandering during re-sawing operations.

Operation

The blade cuts on a continuous down-stroke.

With both hands, firmly hold the workpiece down on the table, and feed it towards the blade slowly, keeping your hands away from the blade.

For best results the blade must be sharp. A dull blade will not cut correctly, especially when straight cutting, and causes excess pressure to be applied on the rear guide bearings.

Select the right blade for the job, depending on the thickness of the wood and the cut to be made. The thinner and harder the wood, the finer the teeth of the blade should be. Use a fine tooth blade for cutting sharp curves.

The machine is especially suited for cutting curves, but will also make straight cuts. When cutting, follow the design marked out by pushing and turning the workpiece evenly.

Do not attempt to turn workpiece without pushing it as this may cause the workpiece to get stuck, or the blade to bend.

Electrical Requirements

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 tool 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.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

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

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.*

Repair or replace a damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet that looks the one illustrated in Figure A below. The tool has a grounding plug that looks like the grounding plug as illustrated in Figure A below.

* Canadian electrical codes require extension cords to be certified SJT type or better.

** Use of an adapter in Canada is not acceptable.

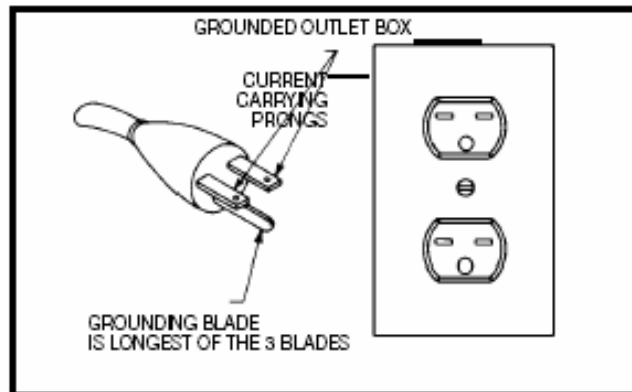


Figure A

Maintenance

Caution! BEFORE CLEANING OR CARRYING OUT MAINTENANCE WORK, DISCONNECT THE MACHINE FROM THE POWER SOURCE (WALL SOCKET). NEVER USE WATER OR OTHER LIQUIDS TO CLEAN THE MACHINE. USE A BRUSH OR COMPRESSED AIR. REGULAR MAINTENANCE OF THE MACHINE WILL PREVENT UNNECESSARY PROBLEMS.

Keep the table clean to ensure accurate cutting.

Keep the outside of the machine clean to ensure accurate operation of all moving parts and prevent excessive wear.

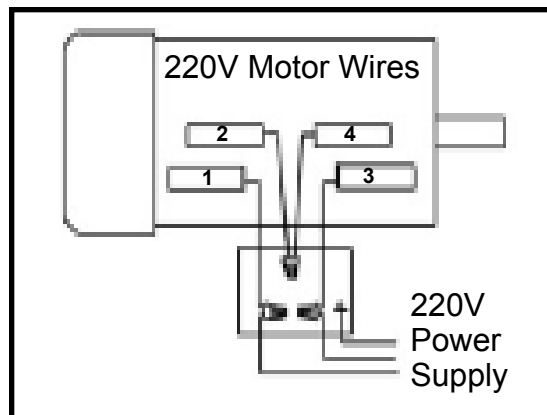
Keep the ventilation slots of the motor clean to prevent it from overheating.

Keep the inside (near the saw blade, etc.) clean to prevent accumulation of dust.

Keep guide bearings free of dust, clean frequently.

Wiring Diagram

WARNING! This machine must be grounded. Replacement of the power supply cable should only be done by a qualified electrician.



Troubleshooting

WARNING!

FOR YOUR OWN SAFETY, ALWAYS TURN OFF AND UNPLUG THE MACHINE BEFORE CARRYING OUT ANY TROUBLESHOOTING.

TROUBLE	PROBABLE CAUSE	REMEDY
The machine does not work when switched on.	<ol style="list-style-type: none"> 1. No power supply. 2. Defective switch. 	<p>Check the cable for breakage. Contact your local dealer for repair.</p>
The blade does not move with the motor running.	<ol style="list-style-type: none"> 1. The quick release lever or blade tension handwheel has not been tightened. 2. The blade has come off one of the wheels. 3. The saw blade has broken. 4. The drive belt has snapped. 	<p>Switch off the motor, tighten the quick release lever or blade tension handwheel. Open the hinged door and check. Replace the blade. Replace the belt.</p>
The blade does not cut in a straight line.	<ol style="list-style-type: none"> 1. Fence for cutting not used. 2. Too fast feed rate. 3. The blade teeth are dull or damaged. 4. Blade guides not suitably adjusted. 	<p>Use a fence. Put light pressure on the workpiece & make sure the blade does not bend. Use a new blade. Adjust the blade guides (see the section on page 10).</p>
The blade does not cut, or cuts very slowly.	<ol style="list-style-type: none"> 1. The teeth are dull, caused by cutting hard material or long use. 2. The blade was mounted in the wrong direction. 	<p>Replace the blade, use a 6 T.P.I. blade for wood and soft materials. Use a 14 T.P.I. blade for harder materials. A 14 T.P.I. blade always cuts slower due to the finer teeth and the slower cutting performance. Fit the blade correctly.</p>
Sawdust builds up inside the machine.	<ol style="list-style-type: none"> 1. This is normal 	<p>Clean the machine regularly. Open the hinged door and remove the sawdust with a vacuum cleaner.</p>
Sawdust inside the motor housing.	<ol style="list-style-type: none"> 1. Excessive dust build-up on the machine exterior components. 	<p>Clean the ventilating slots of the motor with a vacuum cleaner. From time to time remove the sawdust to prevent it from being sucked into the housing</p>
The machine does not cut at 45° or 90° angles.	<ol style="list-style-type: none"> 1. The table is not at right angles to the blade. 2. The blade is dull or too much pressure was put on the workpiece. 	<p>Adjust the table. Replace the blade or put less pressure on the workpiece.</p>
The blade cannot be properly positioned on	<ol style="list-style-type: none"> 1. The wheels are not in alignment. Defective bearing. 2. The blade tracking knob hasn't been properly adjusted. 3. Inferior blade. 	<p>Contact Technical Support @ 877-884-5167 or techsupport@rikontools.com. Adjust the knob (see the section on page 9). Replace the blade.</p>

For parts or technical questions contact: techsupport@rikontools.com or 877-884-5167.

Troubleshooting

Adjusting the Upper Blade Guide Bearings Parallel to the Blade

(Refer to page 19 parts diagram)

This step may not be necessary, it is factory preset. If adjustment is needed follow the steps below.

First slightly loosen part #162 (4 each) cap screw on rear of upper Bandsaw housing (see page 19 in parts diagram). This will allow you to adjust the micro adjustment screws on part #164 (Guide Bracket).

Next place a 3mm "L" wrench through one of the holes in part #169 (Guide Bracket Cover). Turning clockwise on the left two holes will adjust the left bearings to the right. Turning clockwise on the right two holes will adjust the right bearings to the left. Check bearings for parallel.

Lastly tighten parts #162 (4) on back of Bandsaw. Repeat steps if the bearings are still not parallel.

Adjust Upper Bearings Which Will Not Track Close to the Blade

(Refer to page 19 parts diagram)

If the right or left upper bearings do not adjust to within 1/32" of the blade, the guide post (part #157) may need adjustment.

First slightly loosen parts #162 (4) on the back of the upper Bandsaw cabinet.

Next slide the upper guide post right or left until bearings are properly spaced on each side of blade. Tighten part #162 (4) on the back of the upper Bandsaw cabinet.

Changing Bandsaw Tire

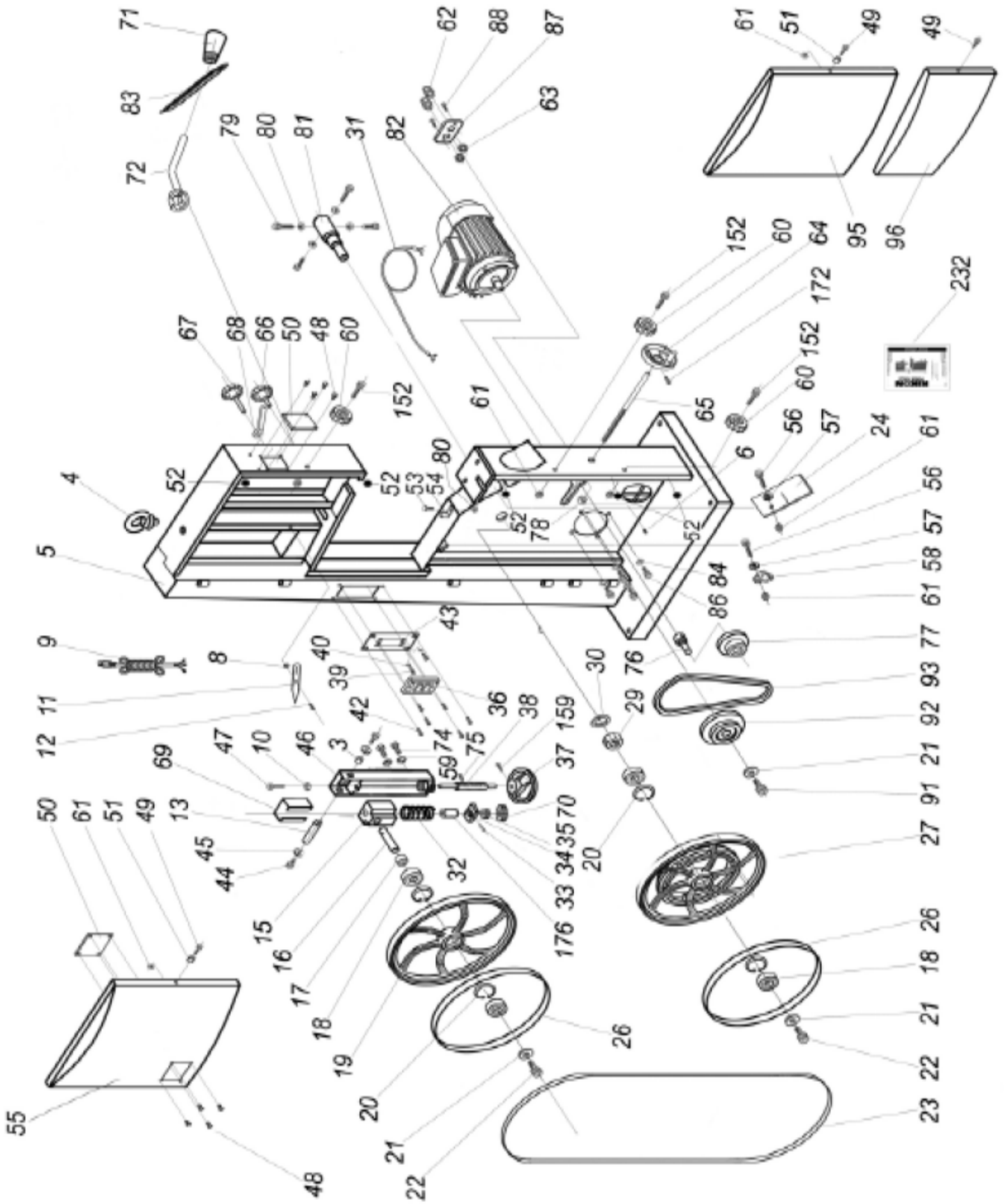
Use a putty knife to get underneath the tire and pull it up and away from the wheel. Work the putty knife all the way around the wheel to loosen the tire. Then, use the putty knife as leverage to flip the tire over and off of the wheel. Clean the inside of the groove, removing any dirt, debris or cement with lacquer thinner.

Soak the replacement tire in warm water to make it more flexible. Let tire dry and lay on top of wheel. Start by setting the tire into the wheel groove at the top of the wheel. Using a putty knife, work the new tire around the wheel, making sure not to slice the tire. If rubber cement is to be used, make sure

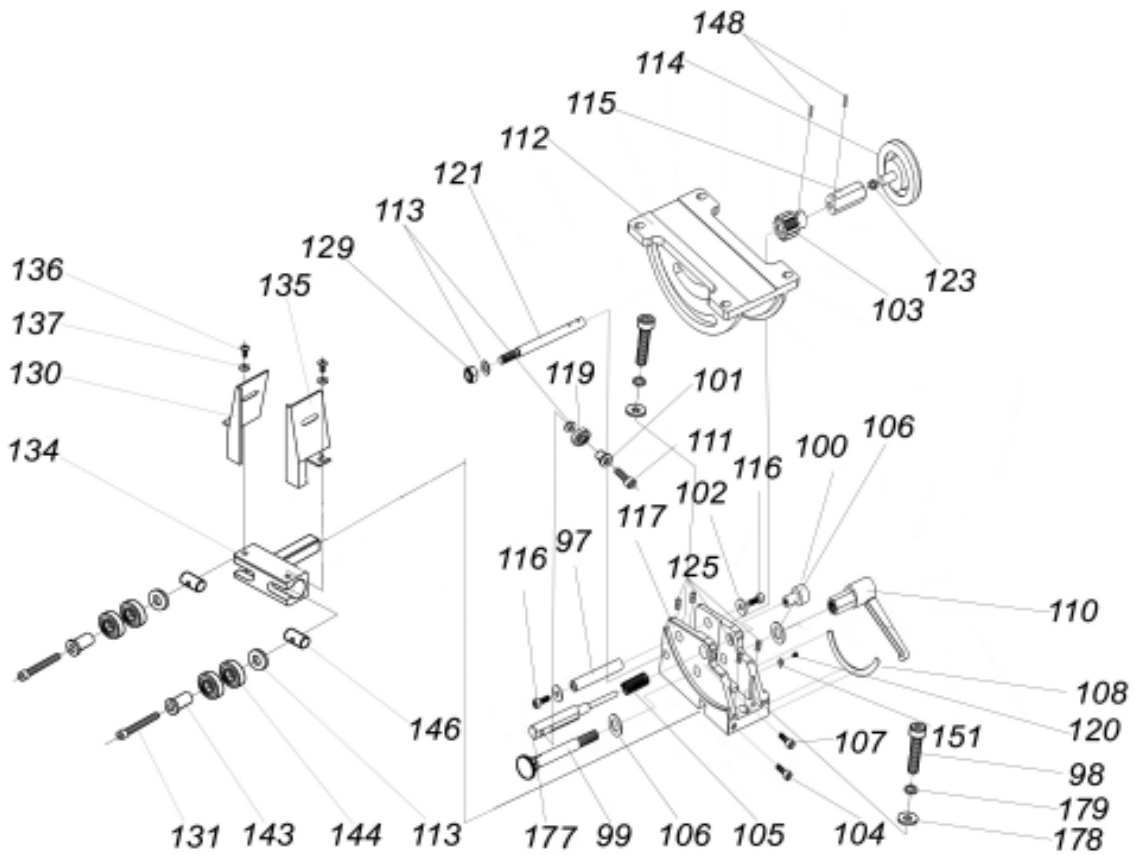
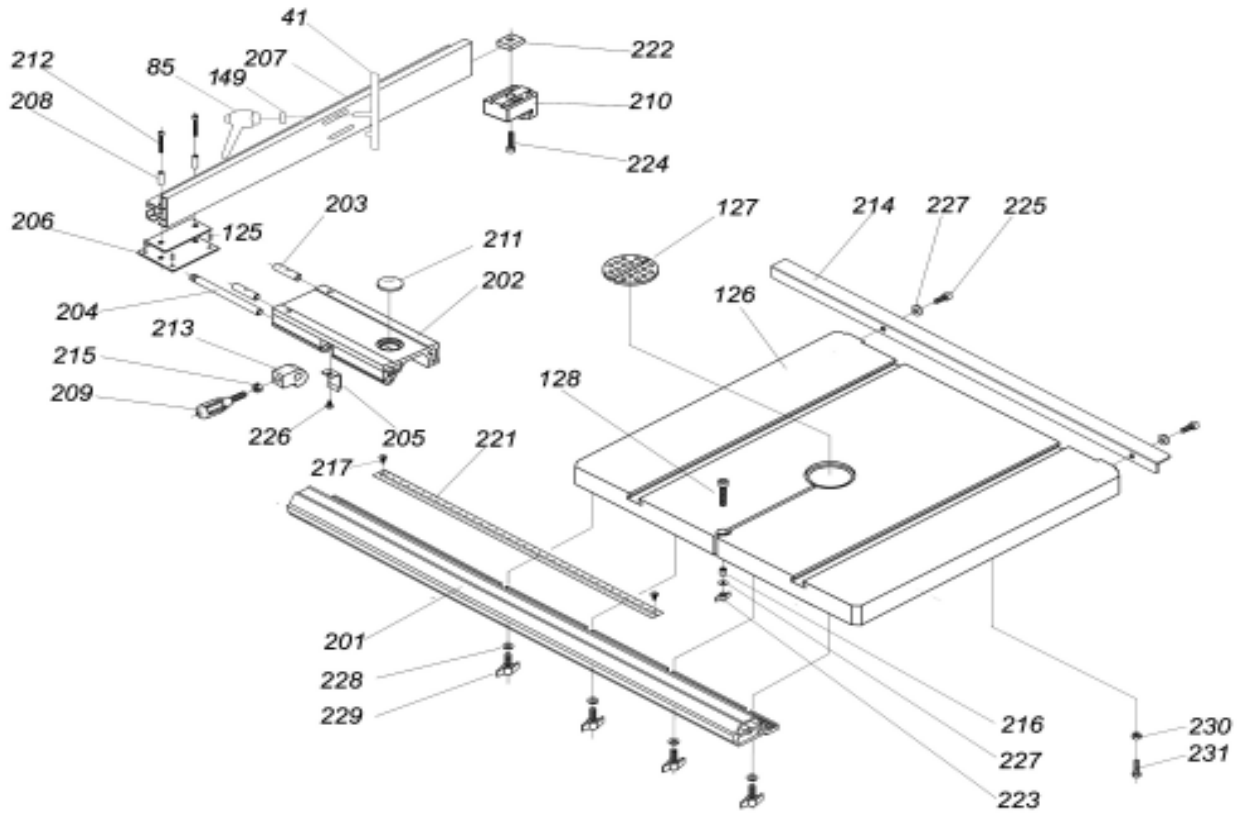
Adjusting Fence 90 Degrees to Table

Loosen slightly the two hex head screws (part#212) which hold the fence rail to the fence body. Raise or lower the four micro-adjusting screws (part#125) located on the fence body accordingly. (Refer to page 18 parts diagram)

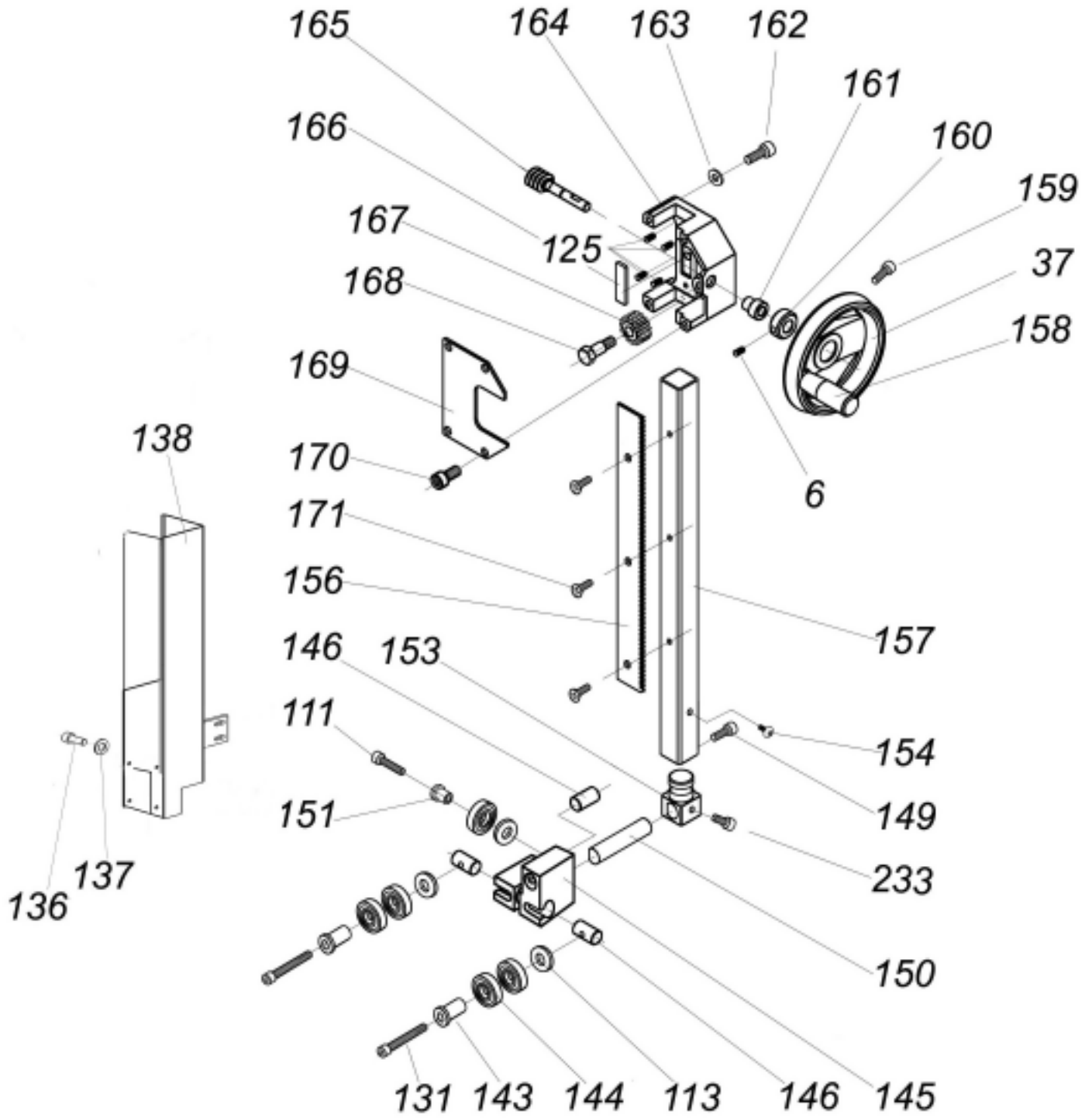
Parts Diagram



Parts Diagram



Parts Diagram



Parts List

Key No.	Part No.	Description	Key No.	Part No.	Description
3	1-JL26030017A	Tube	67	1-JL26030015-001S	Knob Bolt M10-1.5x53
4	1-M12GB825Z	Ring	68	1-JL26030016-001S	Threaded Handle M10-1.5
5	1-JL26011000F-050W	Frame	69	1-JL26030013	Sliding guide
6	1-M5X8GB78Z	Screw M5X8	70	1-BRG51105GB301	Thrust bearing
8	1-M5GB79D1Z	Flat washer M5	71	1-1904011	Shaft End
9	2-JL23123500-451	Power Cord	72	1-JL26030004	Rod
10	1-M6X25GB70D1	Hex Nut M6X25	74	1-M6X12GB5783Z	Hex. Bolt
11	1-JL26010004-002A	Pointer	75	1-M5X10GB77D	Hex. Socket set screw
12	1-JL26010010	Step Screw	76	1-JL26020009	Shaft-V Belt Pulley
13	1-JL26030001	Upper Shaft	77	1-JL26020008+1-BRG80101GB278V	Belt Pulley
15	1-JL26030009A	Upper Wheel Shaft Hinge	78	1-CLP10GB884Z	Circlip Ring
16	1-JL26020002	Upper Wheel Shaft	79	1-M8X25GB70Z	Hex. bolt
17	1-JL26030008	Bushing	80	1-M8GB6170Z	Hex. Bolt
18	1-BRG18204GB278	Bearing 18204	81	1-JL26020007	Lower Wheel Shaft
19	1-JL26020001B	Upper Wheel	82	1-H8022684+1-RK26081007	Motor
20	1-CLP47GB893D1B	Int Retaining Ring M47	83	1-JL26030019	Rubber cover
21	1-WSH8GB5287Z	Flat washer M8	84	1-WSH8GB93Z	Spring washer
22	1-M8X16GB5781Z	Hex Bolt M8x16	85	2-JL26042100-15	Lock handle
23	1-JL26020004A	Saw Blade	86	1-M8X16GB5781Z	Screw
24	1-JL26010013	Board	87	1-JL26010011-050W	Strain Relief Plate
26	1-JL26020003	Tire	88	1-M5X12GB818B	Screw
27	1-JL26022001B	Lower Wheel	89	1-JL26010002-050W	Sliding Cover
29	1-M27X2GB6171Z	Hex Nut M27x2	91	1-M8X20GB5783ZF	Hex Bolt M8-1.0x20LH
30	1-WSH27GB93Z	Spring washer	92	1-JL26020011	Motor Pulley
31	2-U13122000-467	Motor Cord	93	1-JL26020010	V-Belt
32	1-JL26030011	Spring	95	1-JL26014000-049W	Lower Wheel Cover
33	1-PIN2D5X16GB879B	Roll Pin 5x16	96	1-JL26013000-049W	Small Wheel Cover
34	1-JL26030010	Block	97	1-JL26050011	Guide shaft
35	1-BRG51201GB301	Bearing 51201	98	1-M12X35GB70B	Hex Bolt M12x35
36	1-HY56	Switch	99	1-M12X90GB801	Carriage bolt
37	1-JL26030012A-001G	Big Handwheel	100	1-JL26050010	Micro-adjust knob
38	1-JL26030003	Adjusting Rod	101	1-JL26041006	
39	1-M4X8GB818Z	Screw	102	1-WSH6GB96D1	Washer
40	1-WSH4GB862D2Z	Teeth washer	103	1-JL26054002	Small Gear
41	1-JL26061100	Resaw bar	104	1-M6X60GB70D1	Hex. Socket cap screw
42	1-M5X12GB818Z	Pan head screw	105	1-JL26050012	Spring
43	1-JL26010008-050W	Switch Plate	106	1-WSH12GB95	Washer
44	1-M8x10GB70Z	Hex Bolt M8x10	107	1-M6X10GB70D1	Hex. Socket cap screw
45	1-WSH8GB5287Z	Washer	108	1-JL26081012	Table tilt scale
46	1-JL26031000B	Upper Wheel Sliding Bracket	110	2-JL26055000	Lock Handle
47	1-M6X20GB70D1B	Screw	111	1-M8X25GB70D1	Screw
48	1-RVT3X7GB12618A	Rivet	112	1-JL26050002B	Table trunnion
49	1-M6X20GB70Z	Hex Bolt M6-1.0x20	113	1-WSH10GB95	Washer
50	1-JL26010001	Clear Window	114	1-JL26050006-001S	Table Tilting Knob
51	1-JL26010007	Bushing	115	1-JL26052001A	Table tilting shaft
52	1-JL22041007	Rubber feet	116	1-M6X12GB70D1	Hex. Socket head screw
53	1-JL26010015	Special screw	117	1-JL26050004C	Trunnion support bracket
54	1-JL26010014	Quick stopper	119	1-BRG80201GB278	Bearing
55	1-JL26012000-049W	Upper Wheel Cover	120	1-M3X5GB818	Pan head screw
56	1-M6X25GB5781Z	Hex Bolt M6-1.0x25	121	1-JL26054001	Thrust bearing bracket
57	1-WSH6GB96Z	Flat Washer M6	123	1-M10GB41	Nut
58	1-JL26010003	Brush	125	1-M6X16GB77	Hex. Socket set screw
59	1-WSH6GB93D	Washer	126	1-JL26050001-001G	Table
60	1-JL26010006-001S	Star Handle	127	1-JL26050008-001S	Table insert
61	1-M6GB889Z	Nylon Nut M6-1.0	128	1-M6X50GB70Z	Hex socket head screw
62	1-JL20072101	Strain Relief	130	1-JL26051002-001G	Left Cover
63	1-JL20072102	Strain Relief Nut	131	1-M8X40GB70Z	Hex Bolt M8-1.25x45
64	1-JL26020012A-001G	Small Handwheel	134	1-JL26051001B	LowerBladeGuideSupport
65	1-JL26020013	Thread Rod	135	1-JL26051003-001G	Right Cover
66	1-JL26040015-001S	Knob Bolt M10-1.5x20	136	1-M5X10GB70D1	Hex Bolt M5-0.8x10

Parts List

Key No.	Part No.	Description	Key No.	Part No.	Description
137	1-WSH5GB96D1	Flat Washer M5	201	1-JL26060001A	Front Fence Rail
138	2-JL26043000C	Blade guard assembly	202	1-JL26060014	Adjustable Base
143	1-JL26041002	Bushing	203	1-JL26060008	Fixed Shaft
144	1-BRG80201GB278	Bearing 6201	204	1-JL26060009	Shaft
145	1-JL26041001	Upper blade guide support	205	1-JL26060010	Spring Piece
146	1-JL26041003	Guide Ring	206	1-JL26060015B	Bracket
149	1-M6X12GB70Z	Hex socket head screw	207	1-JL26060002B	Support Tube
150	1-JL26041004	Adjusting bar	208	1-JL27060006	Internal plate
151	1-JL26050005A	Pointer	209	1-JL26060012-001S	Handle
152	1-M6X20GB70Z	Hex. Socket head screw	210	1-JL26060016-001S	End Cap
153	1-JL26041005	Upper guide support block	211	1-JL82213010A	Convex Window
154	1-M5X10GB818B	Pan head screw	212	1-M5X20GB70Z	Screw
156	1-JL26040001	Rack	213	1-JL82050008A	Lock Mechanism
157	1-JL26040009	Upper guide post	214	1-JL26060013-001G	Rear Fence Rail
158	1-1501009-20001S	Big crank handle	215	1-M10GB6172B	Hex Nut M8-1.25
159	1-M6X16GB70Z	Hex bolt M6x16	216	1-JL21031003	Bushing
160	1-CLP12GB884B	Bushing	217	1-ST3D9X10GB845Z	Tapping screw
161	1-JL26040003	Bushing	221	1-JL26060004A	Scale
162	1-M8X16GB5781Z	Cap Screw M8x16	222	1-JL82030006	Hex Nut M6-1.0
163	1-WSH8GB97D1Z	Flat washer	223	1-JL22020002-001S	Wing Nut
164	1-JL26040008	Guide Bracket	224	1-M6X12GB818B	Screw
165	1-JL26040004	Worm Cylinder	225	1-M6X12GB70Z	Hex Bolt M6x12
166	1-JL26040007	Fixed Plate	226	1-M4X5GB818Z	Pan Head Screw M4-0.7x5
167	1-1501006	Gear	227	1-WSH6GB97D1Z	Flat washer M6
168	1-JL26040006	Fixed Bolt	228	1-WSH8GB97D1Z	
169	1-JL26040002	Cover	229	1-JL20030003-001S	Thumb Screw
170	1-M8X16GB70Z	Hex Bolt M8-1.25x16	230	1-M8GB6170Z	Nut M8
171	1-M4X10GB819Z	Phlp M4-0.7x8	231	1-M8X50GB5781Z	Hex Bolt M8x25
172	1-M6X16GB70Z	Hex socket head screw	232	1-RK26081101	Manual
176	1-JL26030002	Bushing	233	1-M8X16GB70Z	Hex socket head screw

How-To's for all Band Saw Blades

Choosing the Correct Blade Width

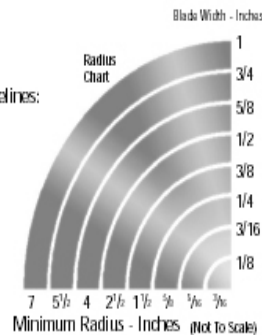
Blade width is measured from the tips of the teeth to the back edge of the blade as shown above. The instructions for the particular machine being used should be followed when selecting blade width.



If no such instructions are provided, blade width should be determined with the following guidelines:

For Cut-Off Sawing, the blade should be as wide as the machine will allow. The wider the band is, the straighter the cut will be. Faster feeding can be achieved.

For Contour Sawing, the blade should be as wide as the machine allows, but still narrow enough so that it can cut the desired shape (radius). Minimum dimensions for different cutting radii are shown on the chart at right.



How To Choose The Correct Number Of Teeth Per Inch (TPI)

The number of teeth per inch (TPI) is important in obtaining the finish desired and the proper feed rate. A coarse tooth blade (2, 3 TPI) should be used for resawing wood and cutting thicker stock up to 8". A fine toothed blade (18 to 32 TPI) should be used for thinner metals and plastics under 1/4". For general cutting of 3/4" wood 4 TPI will provide a fast cut and 14 TPI will cut slow, but leave a smoother finish.

When Selecting TPI remember:

- More TPI give a smoother but slower cut
- Fewer TPI allow a faster cut with a slightly rougher finish
- At least three teeth must be in the workpiece—the chart to the right will help you decide.

TPI	Minimum Material Thickness
32	3/32"
24	1/8"
18	5/32"
14	1/4"
10	5/16"
8	3/8"
6	1/2"
4	3/4"
3	1"
2	1-1/2"

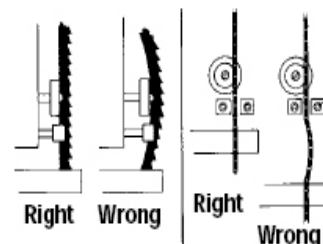
It is important to know the SFM for the various speed settings of your band saw, so that you can select the proper speed for cutting wood or other materials. Check the operator's manual of your band saw to determine the SFM or use the following procedure:

1. Determine the RPM: check the operator's manual or clock the revolutions per minute of the wheels with a tachometer or revolution counter.
2. Measure the diameter of the drive wheel in inches and multiply by .262 to obtain the wheel circumference. The RPM times circumference equals the surface speed of the blade.
 $RPM \times \text{diameter in inches} \times .262 = SFM.$

Note: Spring Steel Wood Cutting Band Saw Blades should never be operated at surface speeds above 3000 SFM. Carbon Hard Edge Flexible Back Band Saw Blades may be run up to 8000 SFM.

Installing your Band Saw Blade

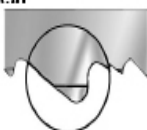
1. Unplug the saw, then loosen the tension on the upper wheel. With all the blade guides backed off, slip the new blade around the wheels and then tension it.
2. When you have tensioned the blade enough to keep it on the wheels, track it by turning the upper wheel with one hand while adjusting the tilt of the wheel's axis with the other hand. The blade should ride in the middle of the rim. **Never track the blade with the motor running and the cover open.**
3. Next, adjust the blade guides; first the thrust bearings: upper and lower, then the left and side guides.
4. Use a square to make sure you are not pushing the blade out of line and place a piece of white paper between the blade guide and the blade to allow for clearance.



Diagnosing Problems

1. Premature and Excessive Tooth Wear

- Feed pressure too light, increase it.
- Lower band velocity.
- Improper tooth selection, use a finer pitch.
- Improper break-in with new band. Velocity and feeding should be reduced the first few cuts.
- Teeth are running the wrong direction.
- Be sure teeth are pointing in proper direction.
- Incorrect saw guide insert size for the band, allowing them to strike teeth



2. Blade Vibration

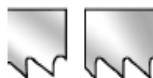
- Increase or decrease band velocity.
- Teeth too coarse for workpiece.
- Material not securely held.
- Increase tension of band.
- Increase feed pressure.

3. Gullets Loading

- Teeth too fine for workpiece - use a coarser pitch.
- Decrease band velocity.

4. Band Stalls in Work

- Feed pressure too great - decrease feed.
- Teeth too coarse, use finer tooth blade



5. Premature Blade Breakage

- Thickness of blade too heavy for diameter of wheels and speed of machine
- Increase or decrease velocity
- Check wheels for defects
- Teeth too coarse for workpiece - use a finer pitch
- Decrease blade tension - decrease feeding force
- Brittle weld - increase annealing period, decreasing heat gradually
- Check for proper adjustment of band guides, saw guides, saw guide inserts, and back-up bearings.

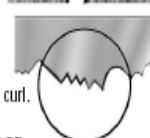
6. Blade Making Belly-Shaped Cuts

- Increase tension.
- Adjust guides closer to workpiece.
- Teeth too fine - use a coarse pitch.
- Decrease feed force.
- Teeth dull.



7. Tooth Strippage

- Teeth too coarse for workpiece.
- Material not securely held.
- Too much feed pressure - reduce for good chip curl.
- Band velocity too low - increase speed.



8. Band Develops a Negative Camber

- Band is riding on saw guide backup bearing too heavily. Adjust band for alignment on top and bottom wheels.
- Check band wheel alignment.



9. Blade Not Running True Against Saw Guide Backup Bearing

- If clicking noise against saw guide backup bearing, remove burr on band.
- Check band wheel alignment.
- Check saw guide backup bearing for wear, replace if necessary
- Weld not in proper alignment. Reweld blade straight and true.

10. Cutting Rate Too Slow

- Increase band velocity.
- Use a coarser pitch.
- Increase feed pressure.



11. Blade Leading In Cut

- Reduce feed pressure or rate.
- Check adjustments and wear of saw guides or rollers.
- Lack of band tension.
- Tooth set damage.



12. Premature Loss of Set

- Improper width selection - check chart for correct width for radius cutting.
- Reduce band velocity.

13. Band Develops Positive Camber

- Decrease force.
- Use a coarser pitch to increase tooth penetration.
- Adjust saw guides closer to work.



14. Band Develops Twist

- Wrong width for radius being cut - choose a narrower blade.
- Binding in cut - decrease feed pressure.
- Decrease band tension.
- Adjust saw guides further from workpiece.



15. Finished Cut Surface Too Rough

- Improper tooth selection - choose a finer pitch.
- Increase band velocity.
- Decrease feed rate.



16. Band Scoring (side wear or grooving)

- Check for wear on saw guide inserts.
- Too much pressure on saw guide inserts.
- Check alignment of saw guides - be sure they are square to front vise. Replace or clean guides.



17. Burring or Mushrooming of Blade Back Edge

- Increase tension and adjust guides.
- Check contact between blade and back edge rollers.
- Reduce feed pressure.
- Use coarser pitch blade.
- Use finishing stone.



WARRANTY



5-Year Limited Warranty

RIKON Power Tools Inc. (“Seller”) warrants to only the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship for a period of two (5) years from the date the product was purchased at retail. This warranty may not be transferred.

This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs, alterations, lack of maintenance or normal wear and tear. Under no circumstances will Seller be liable for incidental or consequential damages resulting from defective products. All other warranties, expressed or implied, whether of merchantability, fitness for purpose, or otherwise are expressly disclaimed by Seller. This warranty does not cover products used for commercial, industrial or educational purposes.

This limited warranty does not apply to accessory items such as blades, drill bits, sanding discs or belts and other related items.

Seller shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty proof of purchase documentation, which includes date of purchase and an explanation of the complaint, must be provided.

The Seller reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

To take advantage of this warranty, please fill out the enclosed warranty card and send it to:
RIKON Warranty
16 Progress Rd.
Billerica, MA 01821

The card must be entirely completed in order for it to be valid. If you have any questions please contact us at 877-884-5167 or warranty@rikontools.com.



**For more information:
16 Progress Rd
Billerica, MA 01821**

**877-884-5167/978-528-5380
techsupport@rikontools.com
www.rikontools.com**