LAGUNA

151-V10

LAGUNA V10 Bandsaw 230V

Manual – EN

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151-V10 LAGUNA V10 Bandsaw 230V Manual EN v1.01.01 A4ob
MAN - VZOR Laguna EN v1.01.01

MANUAL

igmtools.info

Dear customer,
thank you for the confidence you have placed in us with the purchase of your new Laguna machine from IGM.

This manual was prepared for the owner and operator of **LAGUNA V10 Bandsaw 230V** to promote safety during setup, operation and maintenance. Please read carefully and understand the information contained in this manual and accompanying documents. To obtain maximum service life and performance, use the machine according to these instructions and safety guidelines. Observe work safety.

We wish you a lot of work satisfaction and joy when working with the LAGUNA V10 Bandsaw 230V.

Contents

1 Warranty

IGM always strives to deliver a high-quality and efficient product. The warranty is governed by the valid terms and conditions of IGM.

1.1 Declaration of Conformity

LAGUNA

EC DECLARATION OF CONFORMITY

We
(Manufacturer) **Laguna Tools Inc.**
744 Refuge Way, Suite 200, Grand Prairie, TX 75050, USA

Declare that the product name: **Band Saw**

Model Name: **MBAND10V10 / V:10**

Conform with the essential safety requirements of the relevant European Directive:

Machine Directive 2006/42/EC
Electromagnetic Compatibility 2014/30/EU

The person who compile technical file established within the EU:
Name: IGM nastroje a stroje s.r.o.
Address: Ke Kopanine 560, Tuchomerice, CZ-252 67
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Mounting and connecting instructions defined in catalogues and technical construction files must be respected by the user.

They are based on the following standards: EN 62841-1:2015+AC+A11, EN 62841-3-5:2022+A11:2022, EN 55014-1:2021, EN 61000-3-2:2019+A1+A2

EC type examination performed by: TÜV Rheinland LGA Products GmbH, Tillystraße , 90431 Nürnberg

Test report no.: CN 25268F 001 part I. and partII. CN2611UW 001

Responsible for the documentation: Head Product Management, Laguna Tools Inc.

Name : Stephen Stoppenbrink / Chief Executive Officer
Responsibility

Authorized signature :

Date : January 9, 2026

Place : Laguna Tools Inc.
In 744 Refuge Way, Suite 200, Grand Prairie, Texas 75050, USA
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LAGUNA TOOLS INCORPORATED SEAL CALIFORNIA 1998

CE

2 Product Specifications

Machine Dimensions (WxHxD) Stand footprint:	570 x 876 x 560 mm
Machine Dimensions (WxHxD) with mobility kit:	720 x 1580-1780 x 650 mm
Table size:	350 x 318 mm
Table height to floor:	368 mm
Table tilt:	-5-45°
Machine Weight:	42,5 kg
Package Dimensions (WxHxD):	400 x 455 x 900 mm
Package Weight:	46 kg
Blade width (min/max):	3/13 mm
Blade speed:	462 and 1000 m/min
Max. cutting height:	146 mm
Max. cutting width to fence:	202 mm
Max. cutting width to column:	244 mm
Blade length (min/max):	1780/1800 mm
Motor:	750 W
Power:	230 V / 50 Hz / 1 Phase
Fly wheel:	Cast iron
Guides:	Laguna ceramic
Dust extraction outlet:	63 mm

3 Safety

Proper use includes compliance with the instructions given in this manual and general regulations applicable in your country. The operator is liable for any use in violation of the intended use.

3.1 Intended Use

The machine is designed to cut wood and wood-fiber composites. Do not use this machine for anything other than its intended use.

3.2 General Safety Instructions

Warning! Read all instructions and safety guidelines. Failure to follow safety instructions may result in damage to the machine and serious injury to the operator. Keep the manual for future reference.

- The machine may be dangerous if not used properly.
- The machine may be operated only by a person familiar with the contents of this manual and machine operation.
- Keep children and pets away from packaging materials supplied with this machine.
- Place the machine on a stable and well-lit surface. There must be sufficient space around the machine for safe operation.
- Check the technical condition of the machine before operation. The machine may be used only in a perfect technical condition. If you notice any defects, do not start the machine and have it repaired by a qualified person.
- Replace damaged parts immediately. Use only original spare parts.
- All safety covers must be mounted before operation. Replace damaged covers immediately.
- The machine may be used, assembled, and maintained only by persons familiar with its operation and aware of potential danger. No changes to the machine may be made!
- Carry out maintenance regularly.
- Keep the machine and the surrounding area clean and well-lit. Remove all tools from the machine and surroundings before starting the machine.
- Carry out assembly, repairs and maintenance only when the machine is disconnected from the power supply.
- Prevent unintentional start of the machine. Before connecting the machine to the power supply, make sure the switch is in the OFF position.
- Make sure the circuit requirements specified in this manual are met.
- Take care of your safety when operating the machine. Long hair, loose clothing and jewellery may cause injury. Wear suitable work clothing, footwear, head, eye, ear and respiratory protection.
- Do not use gloves when operating the machine.
- Do not operate the machine if you are tired, ill or under the influence of drugs or alcohol.
- Watch your hands and fingers. Always use both hands when working.
- Do not lean over the machine. Always maintain balance and stand on a firm and stable surface when working.
- Keep children and other persons from moving freely around the workplace. Keep the machine out of reach of children and unqualified persons. Do not allow anyone unfamiliar with the machine and this manual to operate the machine.
- Never leave a running machine unattended. After you finish your work, turn off the machine and disconnect it from the power supply.
- Do not leave the machine in a damp environment and do not expose it to rain.
- Do not overload the machine.

- Do not operate the machine near flammable liquids or gases.
- Keep the motor fan clear.

3.3 Symbols

	Read the manual and all instructions carefully before use.
	Wear ear and eye protection.
	Wear respiratory protection.
	Wear suitable work clothing and footwear.
	Turn off and disconnect the machine from the power supply before assembly, maintenance and repairs.
	Disconnect the machine from the power supply.
	Warning of general danger.
	Warning of electric shock.
	Warning of injury caused by moving parts of the machine.
	Do not use gloves when operating the machine!
	Do not use gloves when operating the machine!
	Scan the QR code and find the manual in your language.
	CE mark: The product is in compliance with EEA directives.
	Do not dispose of the appliance in the municipal waste.
	Recycle package materials.

3.4 Additional Instructions for Bandsaws

WARNING: For your own safety, read instruction manual before operating band saw

1. Do not remove jammed workpieces until the blade has come to a complete stop.

2. Maintain proper machine adjustment, especially the blade tension. Regularly inspect the blade guide and roller bearings.
3. Adjust the blade guide position to match the height of the workpiece.
4. Ensure the workpiece is pressed firmly against the work table during cutting.
5. Use a push stick to feed the material; never allow your hands to come near the saw blade.
6. Avoid excessive pressure on the workpiece to prevent overloading the machine.
7. Release the blade tension during periods of inactivity; always tension the blade correctly before starting work.

3.5 Power Supply

Warning! Any modification to the electrical installation may be carried out only by a qualified electrician in accordance with all applicable regulations.

Warning! Do not connect the machine to the power supply until it is ready for operation. 

Circuit Requirements
Warning! These requirements apply to a dedicated circuit where only one machine runs at a time. Consult a qualified electrician before connecting the machine to a shared circuit. Make sure the circuit is properly sized for safe operation.

This machine is designed to operate on a grounded power supply. The power circuit includes all electrical appliances between the machine and the breaker box or fuse panel in the building. The power circuit used for this machine must be sized to safely handle a full load current for an extended time.

Grounding and Plug Requirements
Caution! Improper grounding and connection of the machine to the power supply may result in an electric shock, damage or fire.

This machine is equipped with a grounded power cord. Insert the plug only into a matching outlet that is properly installed and grounded in accordance with all local regulations. Do not modify the provided plug!

Do not use the machine if the power cord or plug is damaged. All repairs may be carried out only by a qualified electrician!

3.6 Environment

Do not dispose of the appliance in the municipal waste. Electronic appliances must be collected and handed in for proper recycling. Recycle package material and other accessories. Observe safety regulations applicable in your country.

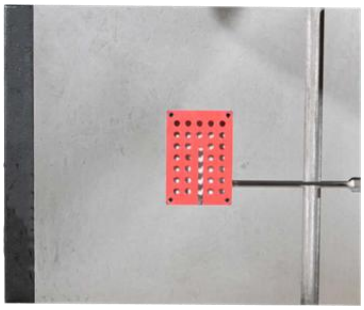
4 Machine Description

Carefully observe the images below and familiarize yourself with the package contents and listed machine parts and features.

4.1 Package Contents

A. Bandsaw Frame Assembly
B. Table with Blade Insert
C. Front Rail for Rip Fence
D. Rip Fence with Carrier Assembly
E. Magnetic Dust Chamber
F. Blade Tension Knob
G. Leveling Bolt & Knob
H. Bolts (4) and Lock Washers (4) to attach table to trunnion on bandsaw frame
I. Hex Wrenches: 3,4,5,6, mm
J. Wrenches: 10,13 mm
K. Owner’s Manual (not shown)

A



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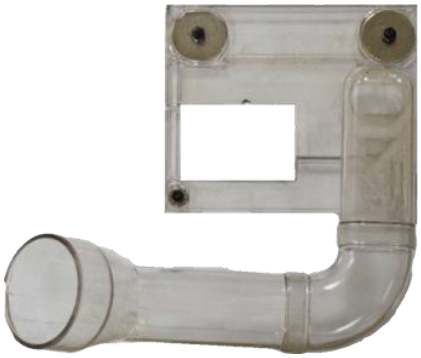


E

F

G

H

I

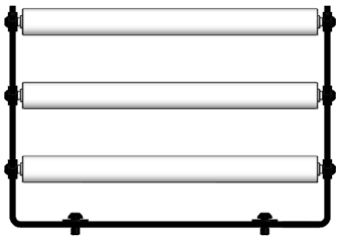
J

4.2 Optional Accessories (Each sold separalety)

A. LAGUNA Stand for V10 and G8 151-V10S
B. LAGUNA Outfeed Roller Table for V10 151-V10R
C. LAGUNA Caster Set for V10 151-V10CS

D. IGM Carbon FORCE SKIP Bandsaw blade 1784mm - 6 x 0,65mm 4Tpi F215-006 (not shown)
E. IGM Carbon FORCE REGULAR Bandsaw blade 1784mm - 8 x 0,65mm 8TPi F215-008 (not shown)
F. IGM Carbon FORCE REGULAR Bandsaw blade 1784mm - 10 x 0,65mm 6TPi F215-010 (not shown)
G. IGM Carbon FORCE REGULAR Bandsaw blade 1784mm - 13 x 0,65mm 6TPi F215-013 (not shown)

A



B

C

4.3 Parts Description

1 – Upper Door
2 – Column Post Cap
3 – Upper Wheel
4 – Blade Tension Knob
15 – Stand (optional)
16 – Quick Release Blade Tension Lever
17 – Tracking Handle and Locking Knob
18 – Blade Guard Adjustment Knob

5 – Blade Tracking Window
6 – Door Latch
7 – Rip Fence Assembly
8 – Blade Guide
9 – Light ON/OFF Switch
10 – Power ON/OFF Switch
11 – Lower Door
12 – Dust Collection Port
13 – Blade Tracking Window
14 – Lower Wheel
19 – Tool Holder
20 – Safety switch
21 – Blade
22 – Table
23 – Outfeed Roller (optional)
24 – Flywheel Assembly with Shaft Nut
25 – Dust Collection Port
26 – Power Cord
27 – Drive Belt Tension Release Nut
28 – Motor

The bandsaw does not have many parts. The major parts are discussed in this manual. If you are not familiar with the bandsaw, take the time to read this section and become familiar with the machine.

1. Upper door

Allows access to the to upper wheel

2. Column Post Cap

Prevents debris from entering the machine

3. Upper wheel

Wheel on the upper half of the machine that the bandsaw goes

4. Blade tension knob

Tightens and loosens the bandsaw tension. Clockwise-tightens. Counterclockwise-loosens.

5. Blade tracking window

Allows the operator to safely view the tension of the bandsaw. Tension indicators are designed to indicate the compression of a spring. As a rule, the greater the spring compression, the greater the tension on the blade. The tension scale does not register until the blade is relatively taut and is located on the inside of the body of the bandsaw. The tension scale is a general reference and not a rule. The tension indicator is visible with the upper door closed by looking through the tension indicator window.

6. Door latch

Locks the door in place so that it does not open during operation.

7. Rip Fence Assembly

Guides and secures the workpiece, ensuring straight and accurate cuts, especially during ripping and resawing, and helps to compensate for blade drift. The rip fence assembly consists of a guide rail, cast knuckle, fence attachment casting, rule and a high-low fence. The guide rail is attached to the table side. It guides the fence assembly across the table. The cast knuckle slides on the guide rail and is lockable in any position to suit the width of cut. The fence attachment. casting is attached to the cast knuckle with three screws that when loosened allow the fence to be adjusted for drift. The fence is attached to the fence attachment casting with two studded knobs that allow the fence to be adjusted laterally across the table to suit the job being cut. The fence can be fitted in the low 1/2" or high 5 1/2" position. There is a rule that is fitted to the side of the table and can be used as a quick guide on the distance that the fence is from the blade. Note. The rule will have to be adjusted each time the fence is adjusted for drift, as this will change the distance the fence is from the blade.

8. Blade guide

There are two sets of blade guides, one above and one below the table. The function of the guides is to give the blade stability and ensure that the blade movement left/right, forward/back is kept to a minimum. The guides above the table are fitted to a shaft that has vertical adjustment. The upper guides are adjustable so that the guides are held just above the job being cut. This gives the blade the maximum amount of stability and also keeps the amount of blade that is exposed to a minimum. The guides have beating guide inserts that can be adjusted for almost zero clearance

9. Light ON/OFF Switch

Powers the bandsaw light on and off

10. Power ON/OFF Switch

Powers the bandsaw on and off. Upper button-ON Lower button-OFF

11. Lower Door

Allows access to the lower wheel

12. Dust Port

Port for dust collection hose to extract dust

13. Blade tracking window

Tension indicators are designed to indicate the compression of a spring. As a rule, the greater the spring compression, the greater the tension on the blade. The tension scale does not register until the blade is relatively taut and is located on the inside of the body of the bandsaw. The tension scale is a general reference and not a rule. The tension indicator is visible with the upper door closed by looking through the tension indicator window.

14. Lower Wheel

Wheel on the lower half of the machine that the bandsaw goes around.

15. Stand (sold separately)

Optional stand that elevates and stabilizes the bandsaw

16. Quick Release Blade Tension Lever

Quickly releases blade tension. This tension lever is at the back of the bandsaw. This lever is a convenient way of quickly releasing the tension on the blade and speeds up the blade change dramatically.

17. Blade Tracking Handle

The blade-tracking knob is located at the back of the bandsaw and is used to adjust the blade tracking. The knob must be locked once the adjustment is completed.

18. Tracking Handle and Locking Knob

The upper blade guide is fixed to the blade guide shaft, which is vertically adjustable. Once the guides have been adjusted vertically, the shaft is locked in position with the lock knob.

19. Tool Holder

Holds tools that may be needed for maintenance

20. Safety switch

When the door body of the band saw is opened, the safety switch can cut off the power in an emergency.

21. Blade

Blade that cuts the material

22. Table

The table supports the work piece and can tilt to produce cuts at various angles. It has a groove to the right-hand side of the blade, which is used to guide the miter gauge. In the center there is a table insert which the blade passes through. Should the blade wander off center, this table insert will protect the blade from damage, as it is soft and should not damage the blade. The table also supports the adjustable fence, which is used for parallel cuts. There is a nut and bolt that join both sides of the table and stops the table from warping. The nut and bolt must always be fitted in the table and only removed when removing or fitting a blade.

23. Outfeed Roller (sold separately)

Optional roller that helps with offloading cut material.

24. Flywheel Assembly with Shaft Nut

Secures the flywheel assembly.

25. Dust Port

Port for dust collection hose to extract dust

26. Power Cord

Cord that provides power to the machine

27. Drive Belt Tension Release Nut

Releases Tension from the belt.

28. Motor

The bandsaw is supplied with a motor. It drives the lower flywheel through a drive belt.

Guards

When running, the blade can be very dangerous, and the amount of blade that is exposed must be kept to a minimum. The machine is supplied with a blade guard.

Tilt and tension mechanism

The upper wheel is attached to the tilt and tension mechanism. This mechanism adjusts the wheel so that the bandsaw blade can be adjusted for tracking. This is achieved by a screwed handle at the back of the machine that pushes on the mechanism and adjusts the axis of the wheel so that it runs true with the lower wheel.

The second function is to tension the blade, which is achieved by adjusting the upper flywheel vertically. A blade tension handle is located on top of the machine. The machine has a quick-acting blade release mechanism that is located at the back of the machine and will remove the tension from the blade to speed the removal and fitting of blades. The mechanism has a spring, which helps to keep the tension constant as the blade expands and contracts with the heat generated by the cutting action.

5 Setup

Approximate assembly and setup time: **15 min**

5.1 Unpacking

When unpacking, separate the machine and all supplied parts from the packaging materials. Check that no parts have been damaged. If damage has occurred as a result of transport, contact your supplier immediately.

To unpack your machine, you will need tin snips, knife and a wrench.

TWO PEOPLE ARE REQUIRED FOR UNPACKING AND SETUP & ASSEMBLY.

Note: The machine is heavy, and if you have any doubt about the described procedure, seek professional assistance. Do not attempt any procedure that you feel is unsafe or that you do not have the physical capability of achieving.

Using the tin snips, cut the banding that is securing the machine to the pallet (if fitted).

WARNING: EXTREME CAUTION MUST BE USED BECAUSE THE BANDING WILL SPRING AND COULD CAUSE INJURY.

Your bandsaw will be shipped in custom packaging consisting of a heavy-duty cardboard box and

styrofoam internal packaging.

1. Select an area for the machine that has a strong, level foundation (workbench, stand, or floor) that is located in an area that has ample space (1 m minimum) on all sides of the machine for cutting large or long material.

2. Align the machine so that during use, the material being cut will not face aisles, doorways, or other work areas that bystanders may be in. Do not locate or use the machine in damp or wet conditions.

3. If desired, secure the machine with lag screws (not supplied) using the 4 holes in the machine’s base.

4. For best power and safety, the bandsaw should be plugged directly into a dedicated grounded electrical outlet that is within the supplied cord length of the machine. The use of an extension cord is not recommended. See safety information section.

5. Open the cardboard box and remove any loose parts and styrofoam.

6. Tilt the packing on the side and slide the bandsaw out of the packaging. You will need two or more people, as the bandsaw is heavy.

7. Lift the bottom styrofoam out and remove the parts that may be packaged under the bandsaw and packaging.

5.2 Quick start

This quick start is not an instructional guide. For specific operations, read the entire manual, seek training from experienced operators, and consult additional resources like

"how-to" books, trade magazines, or websites.

To cut a long work piece, use a roll stand to support it.

IF USING A NEW BLADE, SLOWLY MAKE FIRST TWO OR THREE CUTS WITH SLIGHT PRESSURE, DOUBLING THE USUAL CUTTING TIME. THIS WILL BREAK IN THE NEW BLADE. THIS WILL ENSURE THE BLADE'S QUALITY AND LIFESPAN.

An operator completes the typical assembly and cutting operation(s) listed below:

CAUTION! Never leave the bandsaw running unattended. If not in use, unplug it from power and release the blade tension.

1. Assemble the bandsaw and optional accessories correctly.
2. Wear safety gear: Safety glasses, hearing protection, and no loose clothing.
3. Ensure the workpiece is suitable for cutting.
4. Check the blade guard: Ensure it's adjusted just above the workpiece (6,35 mm gap)
5. Inspect the blade: Look for cracks, dullness, or improper tension.
6. Adjust blade tension: Use the tension knob or lever to match the blade width.
7. Set blade tracking: Turn the upper wheel by hand and adjust tracking so the blade stays centered.
8. Adjust upper/lower guides and thrust bearings: Position them close to the blade without touching it. (1,59 mm gap)
9. Adjust fence and guide rail. Ensure the blade and fence are square to the table
10. Ensure the desired speed setting is set.
11. Ensure the bandsaw is on a stable surface and plugged into a 230V grounded outlet.
12. Plug in the power source and power on: Inspect the bandsaw and blade to ensure proper setup and adjustment.
13. Mark your cut line: Use a pencil or marker.
14. Adjust the fence or miter gauge: For straight or angled cuts.
15. Turn on the saw: Let it reach full speed before cutting.
16. Feed the material slowly: Use both hands, keeping fingers away from the blade. Follow the line: Let the blade do the work—don't force it. Use a push stick if neccessary.

a. TIPS: Use the right blade for the material. Make relief cuts for tight curves. Keep the workpiece flat on the table at all times.

17. After cutting, turn off machine and unplug: Wait for the blade to stop completely.
18. Clean the table: Remove sawdust and debris.
19. Loosen blade tension: If storing for a while, to extend blade life.

5.3 Assembly

WARNING Do not install the machine in explosive environments!

- Choose an installation area with at least 1 meter of clearance around the machine, based on the size of the parts to be machined.
- Ensure the floor is level and strong enough to support the machine evenly on all four supports.
- The site must have a nearby power outlet, chip extraction connection, and adequate lighting.

WARNING

DO NOT PLUG THE MACHINE IN UNTIL SETUP AND ASSEMBLY IS COMPLETE!

WARNING

MACHINE IS HEAVY! TWO PEOPLE ARE REQUIRED FOR ASSEMBLY!

WARNING

At the end of assembly, ensure that all bolts and nuts tightened; otherwise, this may cause machine wobble or serious injury to the operator or other persons.

1. When locating a designated area for the mahcine, select an area for the machine that a strong, level foundation (workbench, stand, or floor) that is located in an area that has ample space (1 m minimum) on all sides of the machine for cutting large or long material.
2. Align the machine so that during use, the material being cut will not face aisles, doorways, or other work areas that bystanders may be in. Do not locate or use the machine in damp or wet conditions.
3. Once in place in your shop, level the machine with spacers so that is does not move during use. If possible, secure it with lag screws (not supplied) using the 4 holes in the machine's base.
4. For best power and safety, the bandsaw should be plugged directly into a dedicated grounded electrical outlet that is within the supplied cord length of the machine. The use of an extension cord is not recommended. See safety information section.

Assembling The Stand And Casters

This bandsaw can be purchased with an optional adjustable stand and casters (each sold separately). If a stand was not purchased, skip this section.

Hand tighten all bolts and nuts until instructed to do so.

1. Open the box and remove all components and hardware from the box.
2. Attach the feet to the bottom of the extension legs (Fig.1).
    a. Secure the jam nut on the threads.
    b. Do this to all legs.

Fig. 1

3. Attach the extension leg to the main leg and secure with four bolts and nuts. Tighten with a 13mm wrench. Make sure the threads are pointed inside the leg (Fig. 2).
    a. Do this to all legs.

Fig. 2

4. Attach the upper brace to the outside of two legs with four bolts and nuts (Fig.3, Fig.4).
    a. HAND TIGHTEN THESE NUTS. THIS WILL ALLOW THE LEGS TO ADJUST

Fig. 3

Fig. 4

5. Attach the short spanner brace to the middle of the legs with two bolts and nuts (Fig.5).
    a. Do this to the other legs too.

HAND TIGHTEN THESE NUTS. THIS WILL ALLOW THE LEGS TO ADJUST.

Fig. 5

6. Slide the upper cross bars under the upper brace and above the leg. Attach the upper cross bars to the legs with two bolts and nuts (Fig.6, Fig.7, Fig.8).

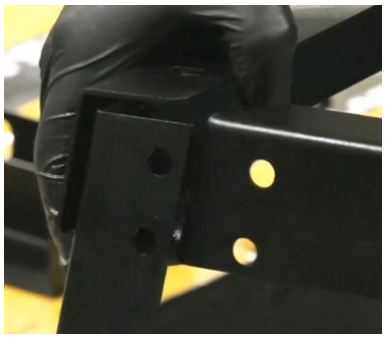


Fig. 6

Fig. 7

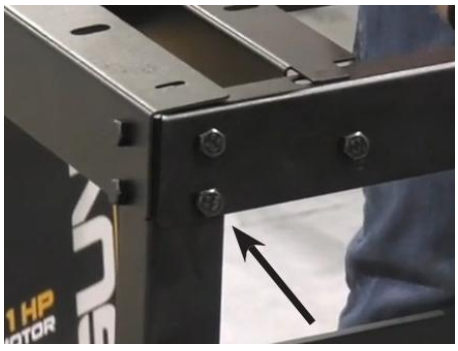


Fig. 8

7. Attach the cross bars to the other side using the same method and secure with the bolts and nuts. The stand should be similar to the figure 9.

Fig. 9

8. Attach the long spanners to the inside of the legs with the bolts and nuts (Fig.10).

Fig. 10

9. Slide the center supports in place and secure with the bolts and nuts on the front and rear of the supports. (Attaching the center supports is recommended but not required) (Fig.12, Fig.13).

Fig. 11

Fig. 12

10. Make sure that all components and hardware are installed (there may be some extra hardware).
11. Use a 13mm wrench and socket and tighten all bolts, nuts, and other fasteners.

For easier installation, it is recommended to place a piece of material under the leg to lift the stand off the ground (Fig. 13).

Fig. 13

12. Remove the bolts from the casters.
13. Position the caster inside the leg, aligning it with the second and third bottom holes (Fig.14).
14. Secure with the bolts and tighten with a 13mm wrench or socket (Fig.14).
15. Repeat these steps for all casters.

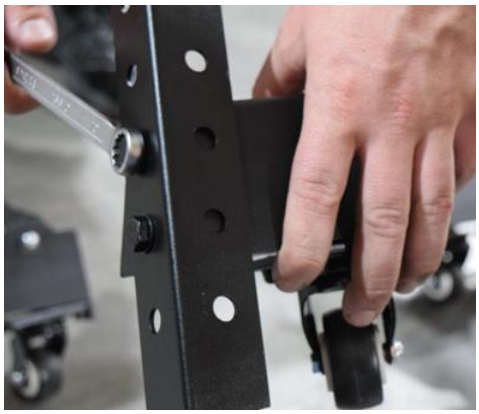


Fig. 14

Fig. 15

16. After all casters are installed, adjust the leveling feet parallel with the wheel when the wheel lock is engaged (lever up) (Fig. 16) The stand should roll freely without the rubber feet touching the ground when the wheel lock is disengaged (lever down).

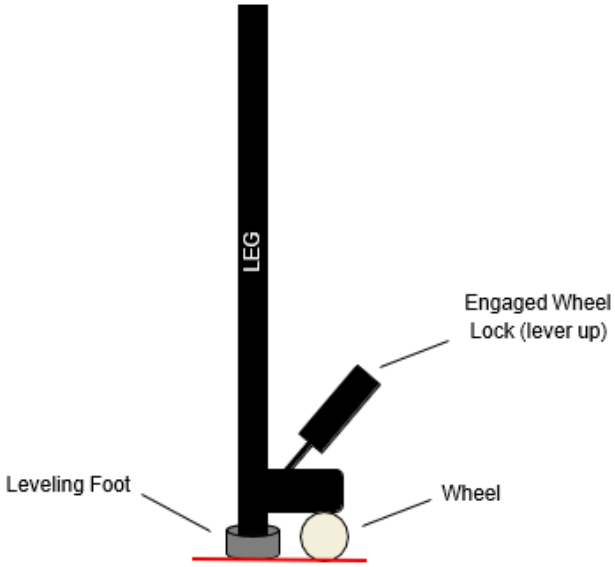


Fig. 16

Make sure that all fasteners are tight and the wheel lock is engaged (lever up) so the stand does not move.

Assembling The saw

TWO PEOPLE ARE REQUIRED TO MOVE THE BANDSAW. THE BANDSAW IS HEAVY! THE BANDSAW WEIGHS 95 POUNDS. USE PROPER LIFTING TECHNIQUE TO AVOID INJURY!

1. Open the box and remove all components and hardware from the box.
2. Take the band saw out of the box. It is recommended to turn the box vertically so that you can slide the band saw out.
3. Remove any coverings and other components.
4. With the help of another person, lift the bandsaw onto the stand, aligning the four corner holes with the stand hole(s).
5. Locate the four bolts that have two washers and two nuts on each of them.
6. Place a washer on top of the bandsaw corner hole and slide the bolt through. (Fig. 17)

Fig. 17

7. From the underside, place a washer and the two nuts on the bottom of the bolt. (Fig. 18)

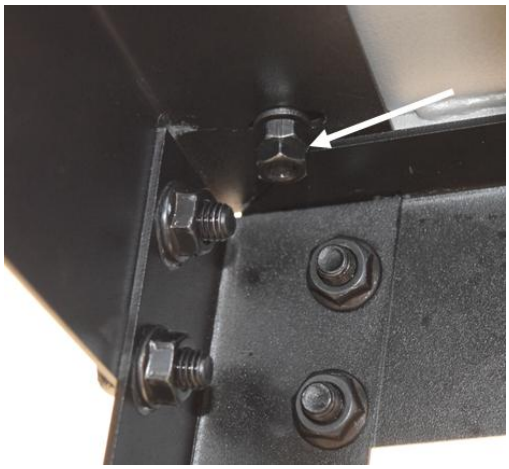


Fig. 18

8. Use a 10 mm wrench and socket to tighten. Ensure that the bottom nut is held so that the top bolt does not rotate freely.

Blade tencion knob

Place the blade tension knob onto the slot on the top of the machine.

Turn clockwise to tighten the blade tension and counterclockwise to loosen the blade tension (Fig.19).

Fig. 19

Istalling the table

The table is shipped with protective grease on the surface. Wipe the table down with a rag and mineral spirits or WD-40 to clean off the protective grease.

1. Remove the red throat plate.

2. Fit the table onto the trunnion, with the slotted end pointing away from the machine. It is recommended that second person hold the table while the other person secures it (Fig.20, Fig.21).

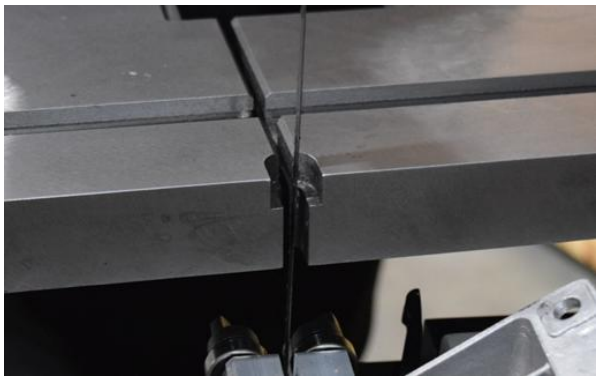


Fig. 20

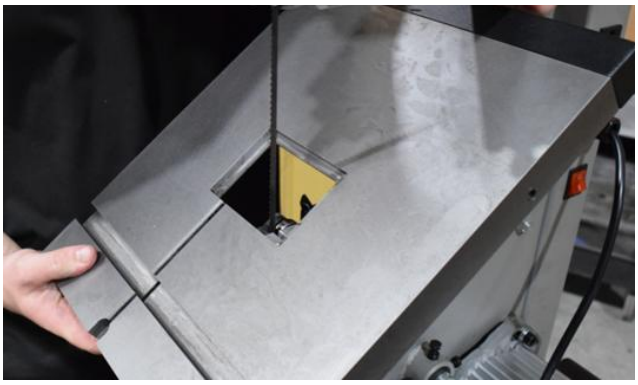


Fig. 21

3. Align the mounting holes on the trunnion.

4. Secure with four bolts and four teeth washers.(Fig. 22)

5. Use a 10 mm wrench or socket to tighten.

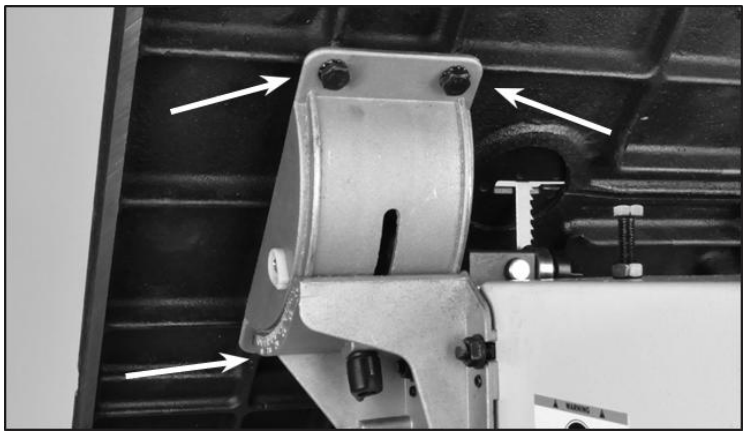


Fig. 22

6. Place the throat plate back in place with the slot towards the front of the saw (Fig. 23).

Use an 3.5 mm Allen key on the corner set screws to make any desired leveling adjustments

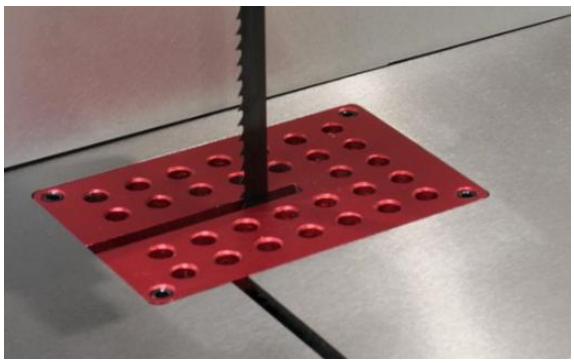


Fig. 23

Istall leveling bolt

The leveling bolt helps keep the two sides of the table level at the slot area.

1. Insert leveling bolt through the front hole in the table and place the washer on the top side (Fig.24).
2. Turn the handle clockwise to tighten.

NOTE: The leveling bolt should be kept in place at all times, and only removed when the saw blade is changed.

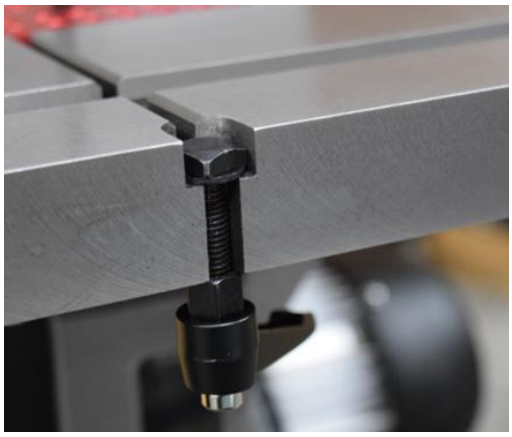


Fig. 24

Istalling the fence and guide rail

The fence acts as a guide so that the operator can make straight, accurate cuts. The guide rail allows for smooth movement and clamping of the fence (Fig. 28).

1. Remove one nut from each of the threads on the guide rail.
2. Screw the remaining nuts on the guide rail all the way against the shoulder of the stud.
3. Slide the fence on the guide rail, positioning it on the inside of the blade (Fig.25). The fence tension knob may need to be loosened.

Fig. 25

4. Position the guide rail on the front edge of the table slide it to the inside of the blade and thread the nuts on the other side (Fig.26).

5. Tighten the nuts with a 10mm wrench (Fig.27).

Fig. 26

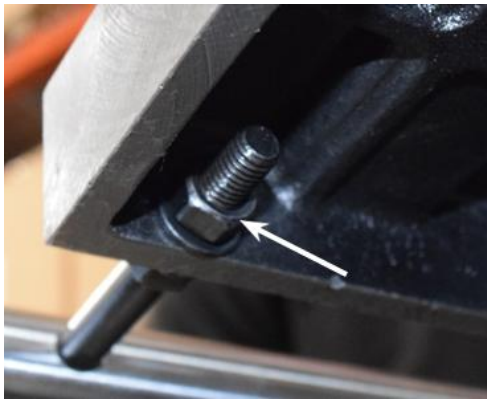


Fig. 27

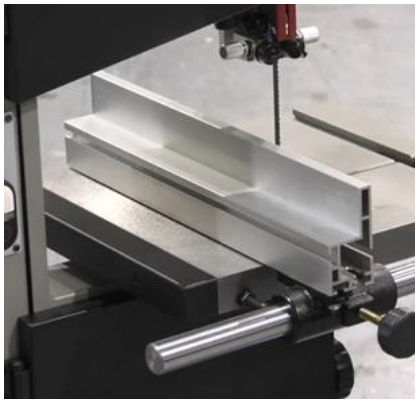


Fig. 28

5.4 Adjustments

Centering the table

If the bandsaw blade is not centered in the table during the initial table-to-trunnion assembly, additional table positioning adjustments may be needed.

1. Loosen the four trunnion nuts that hold the lower trunnion and table to the bandsaw frame.
2. Move the table sideways as required, until the saw blade runs through the center of the table insert.
3. Tighten the trunnion nuts that were adjusted.

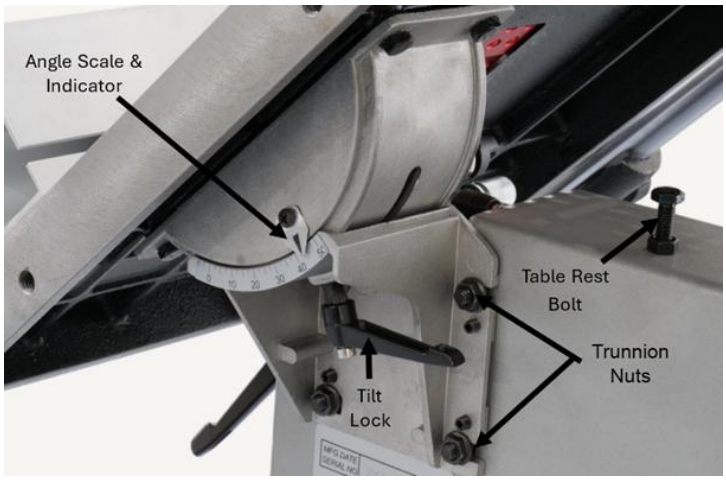


Fig. 29

Tilting the table

The table tilts from 0 to 45 degrees, allowing the operator to cut at different angles. USE CAUTION WHEN CUTTING AT AN ANGLE!

1. Loosen the tilt lock on the table trunnion.
2. Set the table to the desired angle and tighten the tilt lock.

The trunnion has a Stop for precise 45° angles. For critical cuts, verify the angle with an angle guide or trial cuts in scrap wood.

USE THE FENCE ON LOWER SIDE OF THE TABLE IF CUTTING AT AN ANGLE.

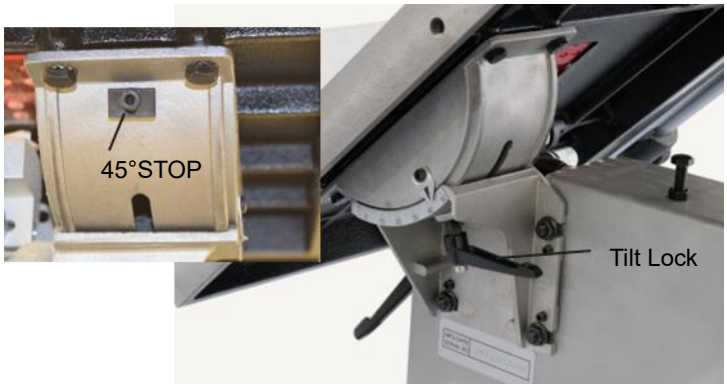


Fig. 30

Adjusting the position of the rip fence

1. To adjust the position of the rip fence, loosen the fence knob counterclockwise.
2. Move the fence to the desired position.
3. Tighten the fence knob clockwise

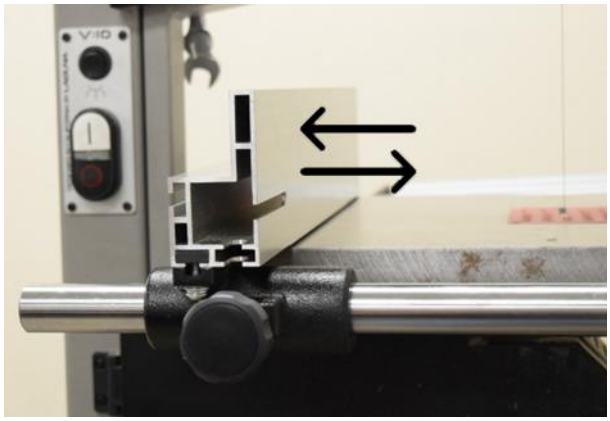


Fig. 31

Adjusting the fence from high to low position

WARNING! THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE OFF POSITION UNTIL ALL ADJUSTMENTS ARE COMPLETE.

To change the fence from high to low position

1. Loosen the two hex screws with a 4mm Allen key (Fig. 32).

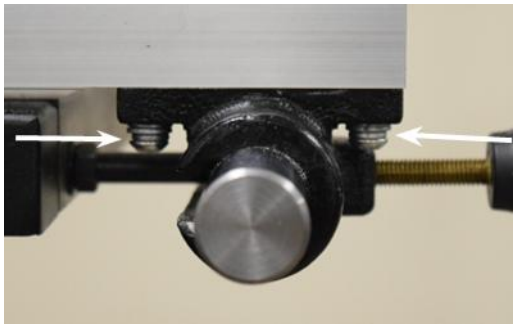


Fig. 32

2. Slide the fence off of the plate, removing it from the carrier knuckle. (Fig.33, Fig.34)

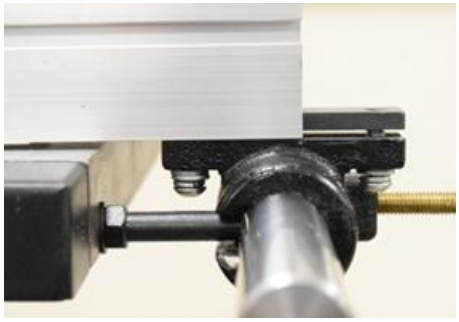


Fig. 33

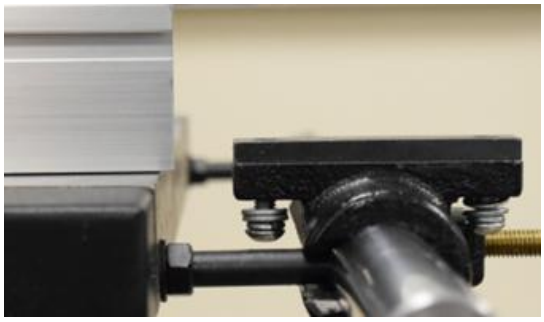


Fig. 34

3. Rotate the fence right 90°, turning it to the low position, and slide it all the way back into the plate (Fig.35, Fig.36).

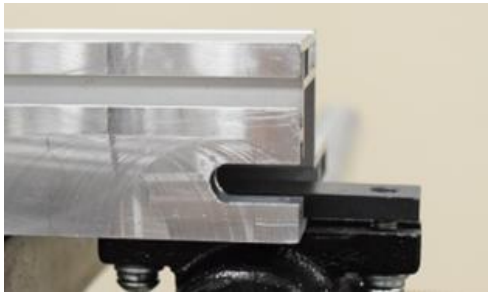


Fig. 35

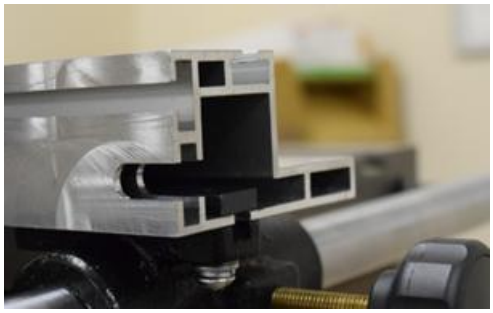


Fig. 36

4. Line up the two holes and re-tighten the two hex screws with the Allen key to secure the fence.
5. Ensure the fence is parallel with the blade and miter gauge slot, adjusting for 'drift' if needed (Fig.37).

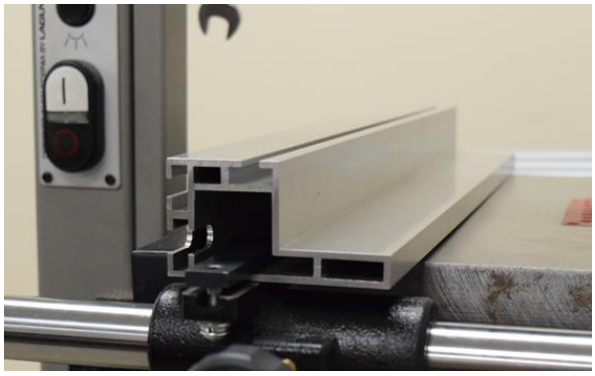


Fig. 37

Squaring the blade to the table

1. Make sure that the table is set at 0° and not tilted left or right.
2. Place a square to the blade and check if the blade is 90° to the table. If there is a gap between the blade and the square as shown (Fig.38), follow the steps below.

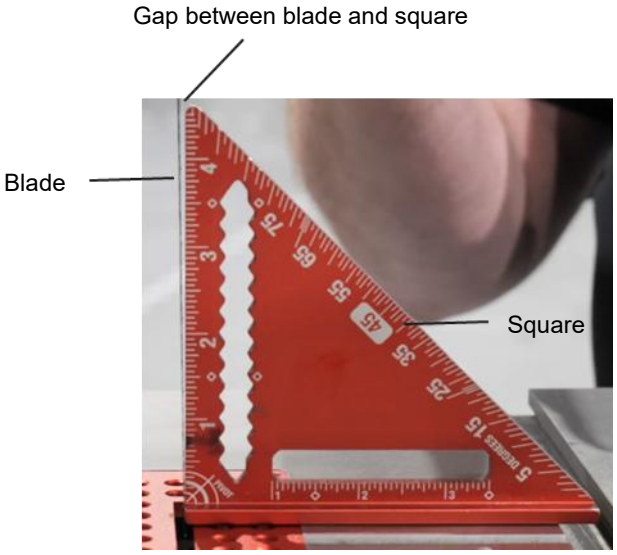


Fig. 38

3. Loosen the 90° table rest bolt's locking Nut and screw the bolt downward, away from the table underside (Fig.39).
   Center the table until it the square is 90° to the blade.
4. Tighten the four flange nuts that were loosened in the "centering the table" section.
5. Check that the Table Angle Indicator reads zero degrees on the lower trunnion scale.
6. Loosen the screw holding the indicator and reset it to zero if necessary.
7. With the table secured at 90°, adjust the table rest bolt up or down until it contacts the table underside (Fig.39).

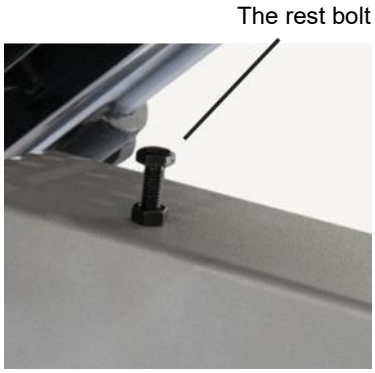


Fig. 39

8. Retighten the table rest locking nut, ensuring the 90° table angle setting is maintained (Fig.40).

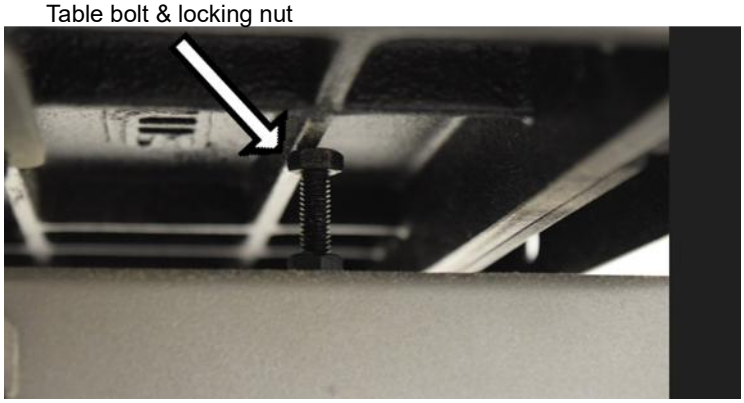


Fig. 40

Squaring the fence to the table

1. Make sure that the table is set at 0° and not tilted left or right.
2. Place a square to the fence and check if the fence is 90° to the table. If there is a gap between the blade and the square as shown (Fig.41), follow the steps below.

Gap between blade and square

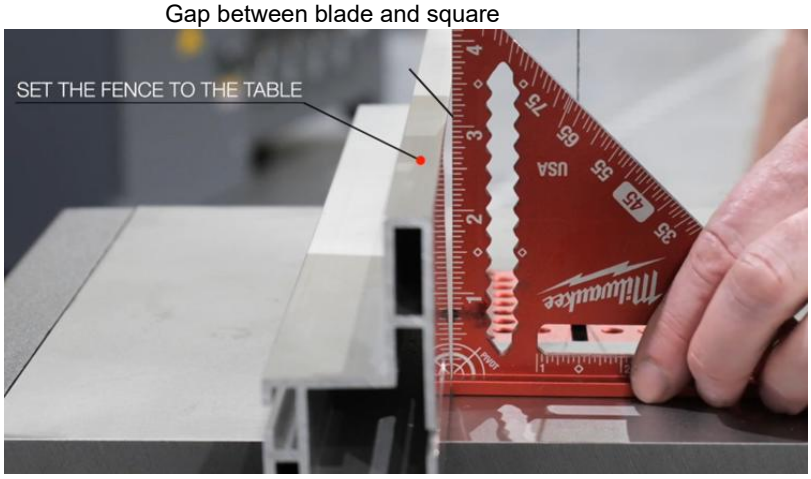


Fig. 41

3. Under the table, loosen one fence guide rail nut. Only loosen one nut at a time (Fig.42).
4. Raise/lower the fence until square and tighten nut.

Nut is located under the table

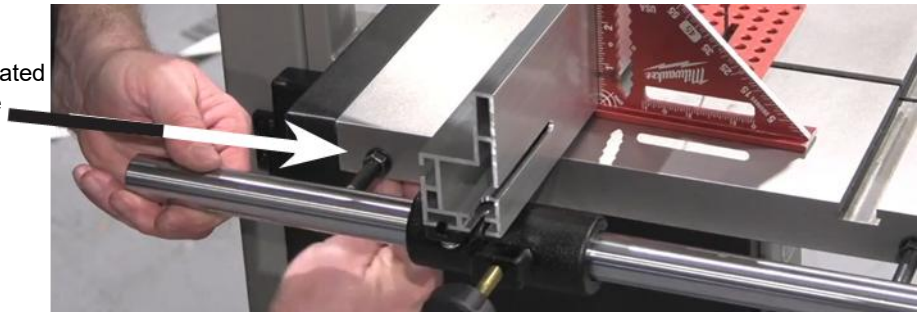


Fig. 42

5. If the fence is still not square, loosen the other nut and repeat step 4.
6. Center the fence until it is 90° to the table.

Squaring the rear of the blade to the table

WARNING! UNPLUG THE MACHINE FROM POWER AND TURN OFF MACHINE. DO NOT POWER ON UNITL AL ADJUSTMENTS ARE COMPLETE.

If needed, the table can be re-set to 90° to the back of the saw blade by adjusting the trunnion adjustment screws:

1. Loosen the four trunnion nuts on the lower trunion
2. mSet a square on the table against the saw blade's back.
3. Use a 3mm Allen key to turn the top 2 set screws or bottom 2 set screws to adjust the table position.

Only adjust the top 2 screws at one time or the bottom 2. This will ensure proper adjustment.

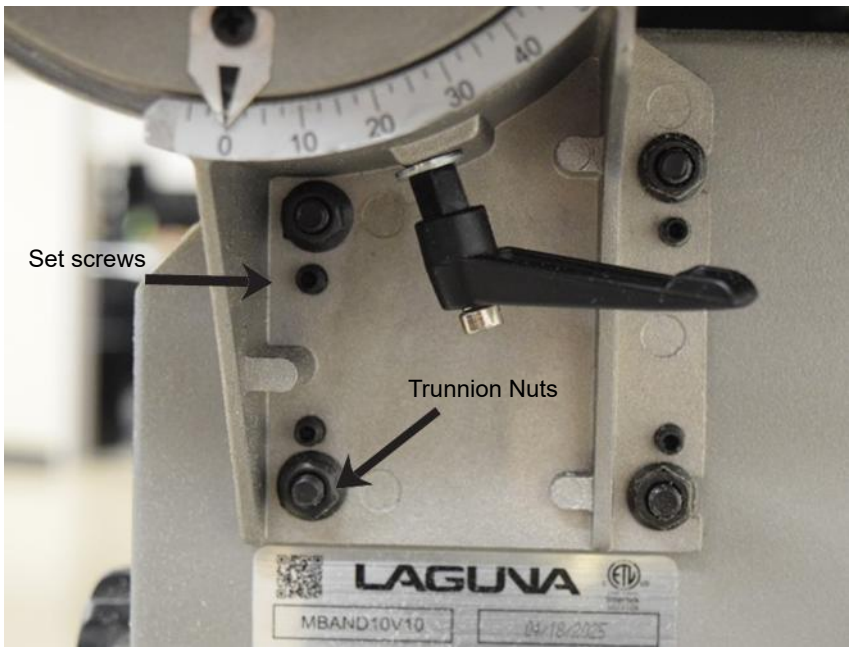


Fig. 43

Turning the set screws clockwise moves the support away from the saw. Turning the set screws counterclockwise moves the support towards saw.

4. Check the table and blade angle for 90°.
5. Tighten the trunnion nuts when set at 90°.

The blade should be centered in the throat plate.

Tracking the saw blade

WARNING! UNPLUG THE BANDSAW. A blade is installed at the factory. It is recommended to check the blade tracking prior to use. Make sure the upper and lower blade guides are adjusted away from the blade.

1. Open both upper and lower doors.
2. Loosen wing nut handle by turning it counterclockwise (Fig.44).
3. Turn the blade tracking knob while carefully rotating the upper wheel by hand (Fig.44).

-Turn the knob clockwise to move the blade away from the door.

-Turn the knob counterclockwise to move the blade towards the door.

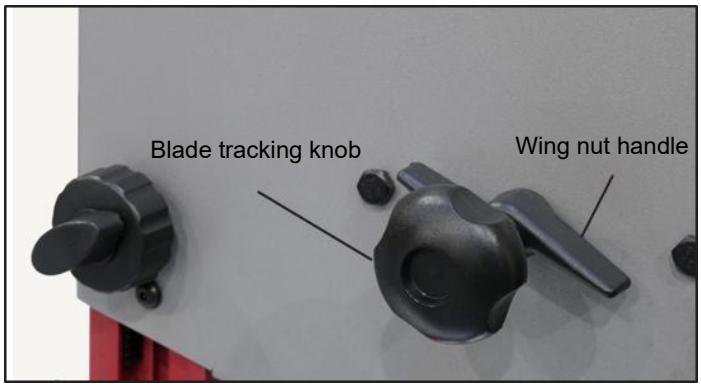


Fig. 44

4. Check the blade tracking through the side window. Rotate the wheel at least three times or until the blade is centered (Fig.45, Fig.46)

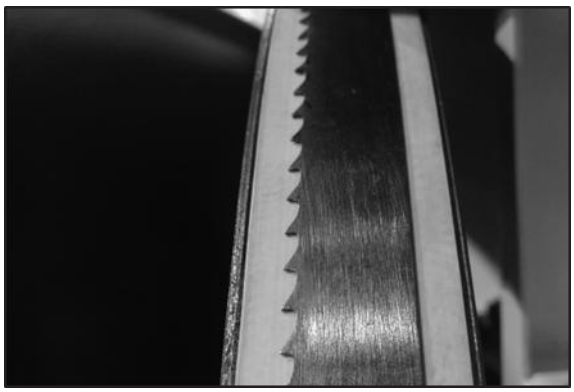


Fig. 45 - Correct

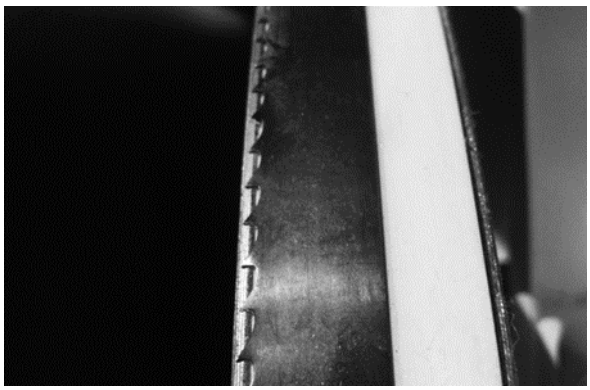


Fig. 46 - Incorrect

5. Once the blade is centered, tighten the wing nut handle and close the doors.

NOTE: 1/8” (3.18mm) blades should be 0,46 mm to 0,51 mm gauge to reduce tracking issues common with this width.

NOTE: The lower wheel has been pre-set at the factory and any changes made to this wheel should be done after reading this entire manual and understanding the instructions. Failure to do so could damage the machine.

Adjusting the blade tension

CAUTION! Always tension the blade with the rear Quick Release Lever in the “ON” position.

Failure to do so could result in lack of blade tension or tension failure. (Fig.48)

NOTE: Release / turn ‘OFF’ the Tension Lever only to change the blade, or to prolong the life of the blade when the saw is not in use for extended periods.

Adjust the blade tension by turning the Blade Tension Knob on top of the saw (Fig.48)

Turn the knob clockwise to tighten the blade tension and counterclockwise to reduce it.

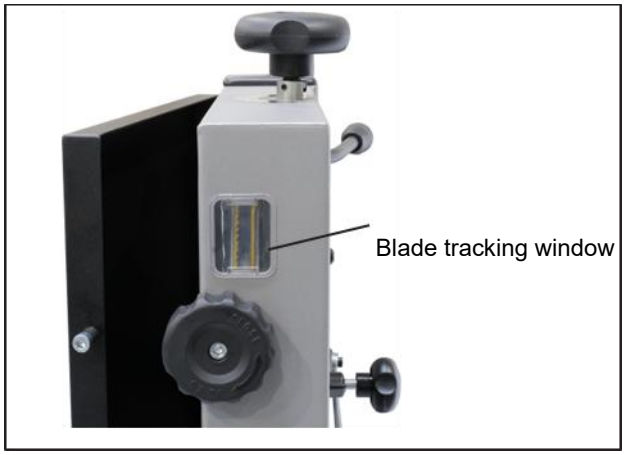


Fig. 47

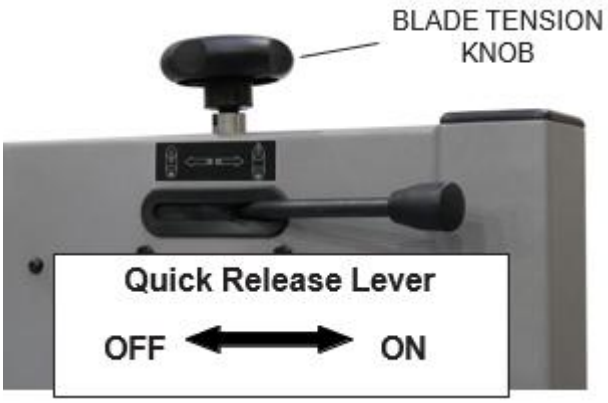


Fig. 48

Adjusting the blade guides

This bandsaw has quick-adjusting ball bearing blade guides for fast and easy setting to the blades. With the bandsaw blade properly centered on the drive wheels, the guide bearings can then be set. To adjust the blade guides:

Upper Guides:

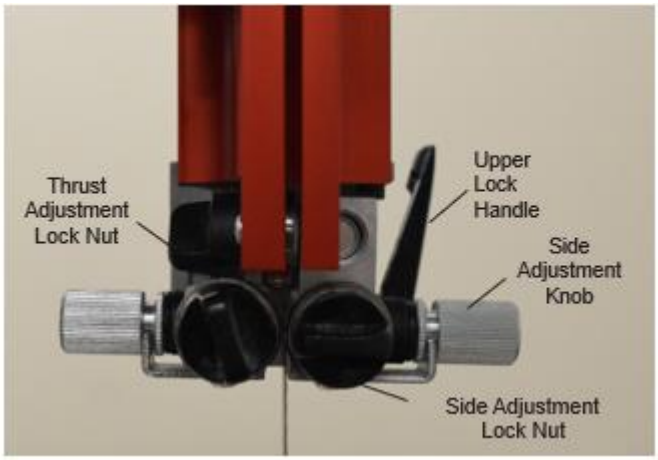


Fig. 49 – Upper Guides (front view)

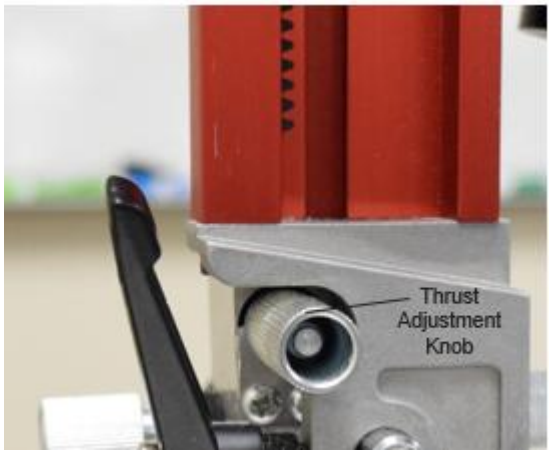


Fig. 50 – Upper Guides (rear view)

1. Loosen the locking handle.
2. Move the guide assembly forwards/ backwards to where side bearing is sitting just behind the blade teeth (about 1,59 mm) (Fig.51)

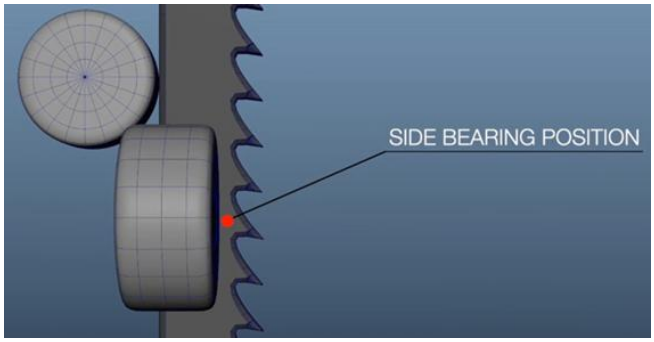


Fig. 51

3. Tighten locking handle when done.
4. Loosen the thrust adjustment lock nut
5. Adjust the thrust adjustment knob to where the thrust bearing is 0,79 mm gap away from the blade. (clockwise=towards blade; counterclockwise=away from blade) (Fig.52)

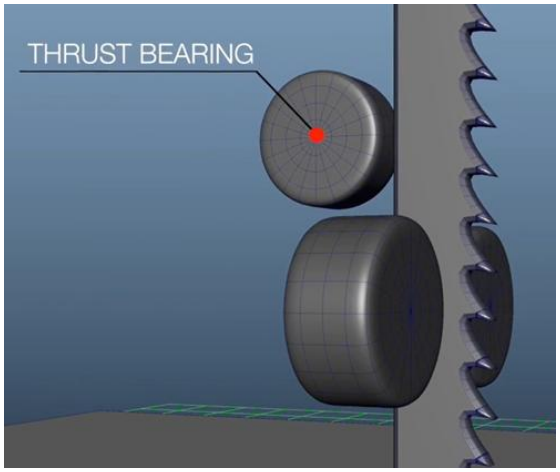


Fig. 52

6. Tighten the thrust adjustment lock nut to lock position.
7. Loosen both side adjustment lock nuts.
8. Adjust the side adjustment knobs to where both bearings are 0,79 mm (about the thickness of a piece of paper) gap away from the blade. (clockwise=towards blade; counterclockwise=away from blade) (Fig.53)

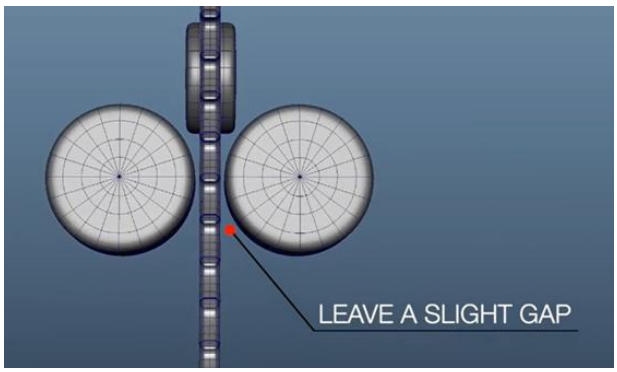


Fig. 53

The bearings should not continuously rotate when operating the bandsaw.

Lower Guides:

1. Loosen the lower lock handle.
2. Move the guide assembly forwards/ backwards to where side bearing is sitting just behind the blade teeth (about 1,59 mm)
3. Lock the handle.
4. Loosen the lower thrust adjustment lock nut.
5. Adjust the lower thrust adjustment knob to where the thrust bearing is 0,79 mm gap away from the blade. (clockwise=towards blade; counterclockwise=away from blade)
6. Tighten the thrust adjustment lock nut to lock position.
7. Loosen both lower side adjustment lock nuts.
8. Move the guides with your hand to where both bearings are 0,79 mm (about the thickness of a piece of paper) gap away from the blade. (clockwise=towards blade; counterclockwise=away from blade)
9. Tighten both lower side adjustment lock nuts to lock position.

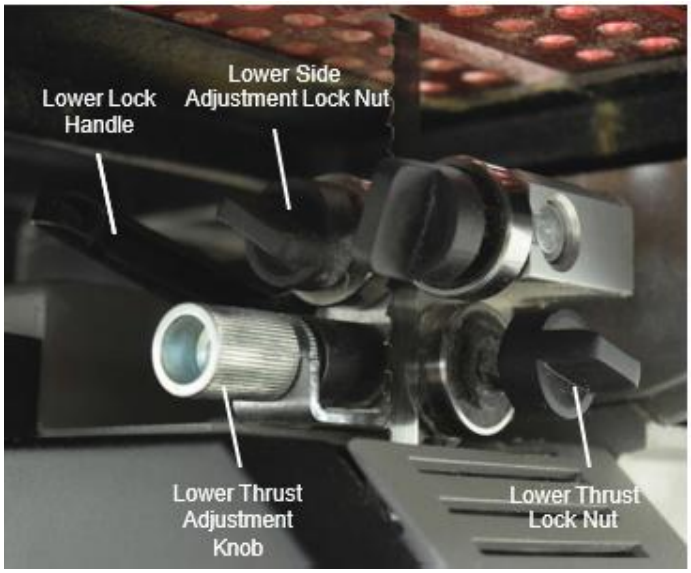


Fig. 54

Adjusting the blade guard

NOTE: Before cutting, set the upper guide approximately 6,35 mm above the top surface of the work piece. This will give the best blade control.

1. Loosen the guide lock knob.

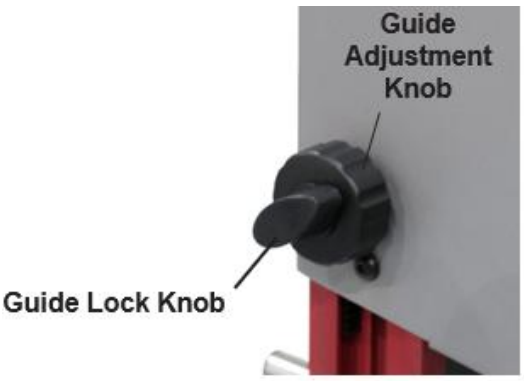


Fig. 55

2. Rotate the guide adjustment knob to raise or lower the guide assembly to the desired height above the table or workpiece (Fig.55).

A 1/4" gap between the guide assembly and workpiece is recommended (Fig.56).

Fig. 56

3. When the guide bearings are properly positioned, tighten the guide lock knob loosened in step one.

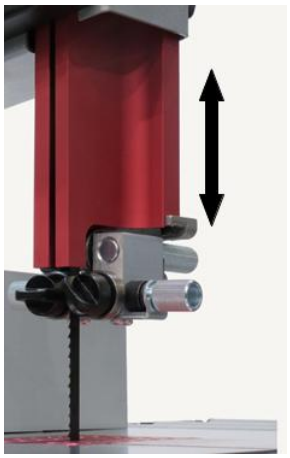


Fig. 57

Changing the blade speed & adjusting the drive belt tension

This Bandsaw has two blade speeds, high speed and low speed. Reference (Fig. 60). This figure is also found on the inside of the lower door.

NOTE: The bandsaw is shipped in the high speed mode.

The lower drive wheel has two pulleys, and the motor shaft has a two pulleys. The belt runs around both pulleys.

For HIGH SPEED, install the belt on the rear pulleys of both the motor and wheel (positions 1 to 2). This setting is ideal for general sawing of wood and composites. The bandsaw is shipped in high speed mode.

For LOW SPEED, install the belt on the front pulleys of both the motor and wheel (positions 3 to 4). This setting is best for cutting hard materials like thicker wood. Use the correct blade type for effective cutting.

Changing blade speeds and adjusting belt tension is done by pivoting the rear motor.

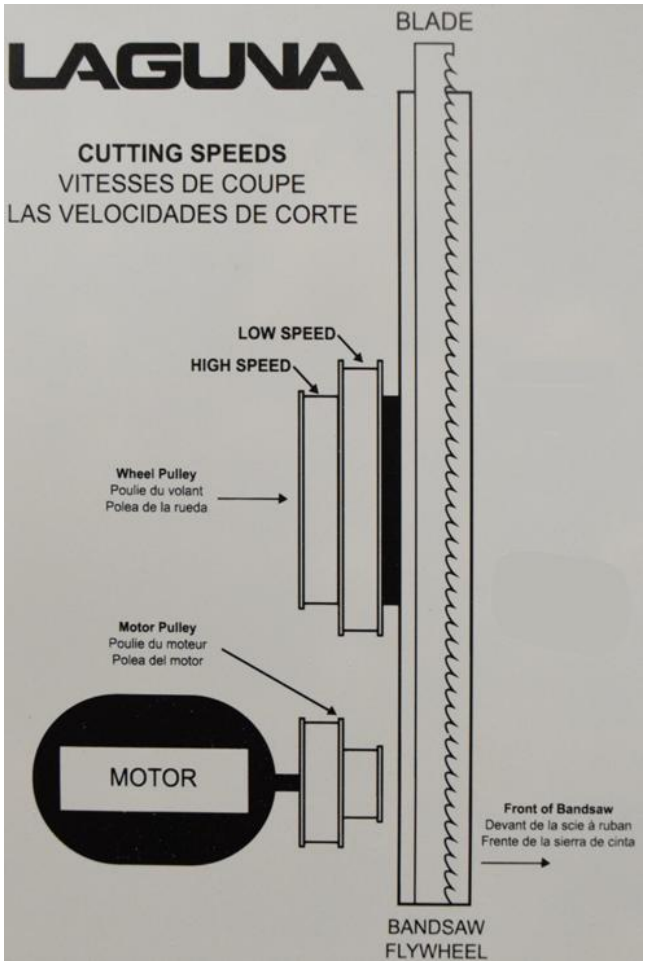


Fig. 58

To change blade speeds:

1. Loosen the top motor mount screw and pivot the motor to release tension on the drive belt (Fig.59)

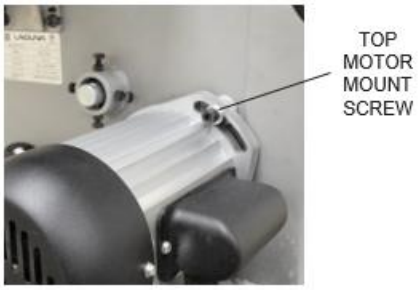


Fig. 59

2. Change the belt position to the desired blade speed.
3. Tension the drive belt to allow 9,53 mm to 12,7 mm deflection. Avoid over-tensioning to prevent damage to the belt, pulleys, and motor (Fig.60).

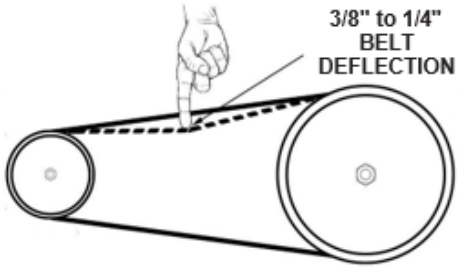


Fig. 60

4. Tighten the motor mount screw to secure the motor and set the drive belt tension.

Changing the motor drive belt

UNPLUG THE MACHINE FROM THE POWER SOURCE BEFORE CHANGING THE MOTOR DRIVE BELT. THE POWER SWITCH MUST BE OFF UNTIL ALL ADJUSTMENTS ARE MADE

To change the drive belt:

1. Release the tension on the bandsaw blade and move the blade off the lower wheel, or remove it completely.
2. Loosen the top motor mount screw and pivot the motor to release tension on the drive belt (Fig.61).

NOTE: Mark the top of the motor near the screw to help identify the belt tension point

3. Remove the old belt from the pulleys.
4. Use C-Clip" or "Snap Ring" pliers (not included) to remove the retaining clip in the middle of the wheel.
5. Carefully spread the retaining clip outwards with the pliers and remove clip. DO NOT BREAK THE CLIP. DO NOT USE A LOT OF FORCE TO REMOVE IT.
6. Slowly pull the wheel off the lower shaft.
7. Install the new belt on the desired pulley and reverse the above steps. For different speeds, go to the above section.
8. Ensure the drive belt ribs are correctly seated in the pulley before reassembling and tensioning the belt.
9. Tension the drive belt to allow 9,53 mm to 12,7 mm deflection

Top motor mount screw

Fig. 61

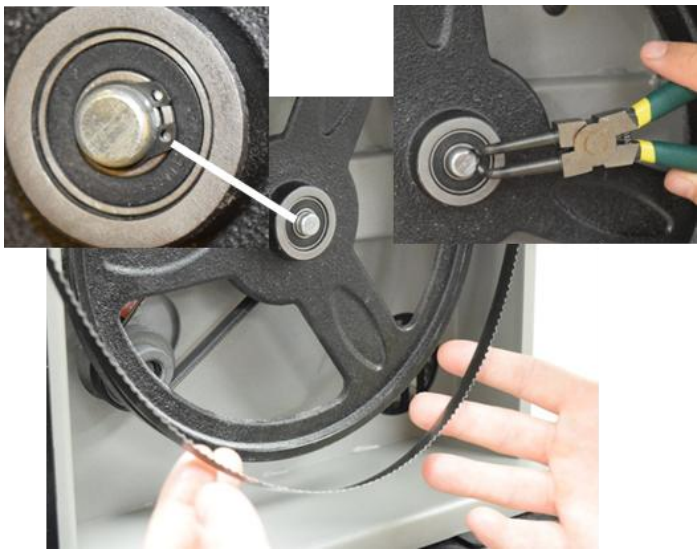


Fig. 62

Changing bandsaw tires

The bandsaw tire is a ring that fits around the wheel that acts as a protective cushion between the blade and wheel. This tire can get worn out with use and may need to be replaced.

To remove the old tire:

1. Loosen the blade tension.
2. Move the blade off the wheel or remove it completely.
3. Use a putty knife to lift the tire away from the wheel.

4. Work the knife around the wheel to loosen the tire.
5. Flip the tire off the wheel using the knife as leverage.
6. Clean the groove with lacquer thinner.

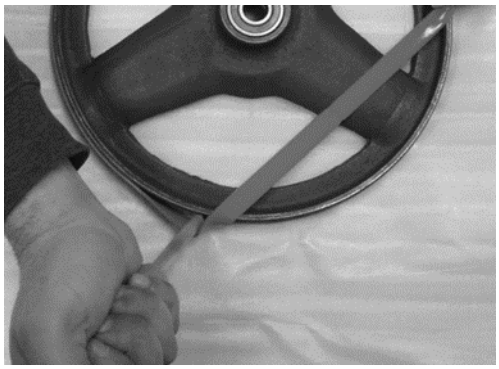


Fig. 63

To Install the new tire:

1. Place the new tire in warm water for 1-5 minutes to make it more pliable.
2. Dry the tire completely and place it on the wheel while still warm.
3. Fit the tire on the wheel groove, starting at the top. A putty knife or round tool may need to be used to fit the tire on the wheel. BE CAREFUL NOT TO CUT THE TIRE. PLACING A CLEAN RAG OVER THE PUTTY KNIFE BLADE MAY REDUCE CUTTING EXPOSURE.

CHANGING THE BANDSAW BLADE

This bandsaw is factory-equipped and set with a general-purpose wood cutting blade. To change the saw blade, the following procedure must be followed:

WARNING! Unplug the machine from the electrical supply so it will not accidentally turn on while changing the saw blade.

1. De-tension the blade using the quick release tension lever.
2. Remove the throat plate.
3. Remove the rip fence and guide rail from the table.
4. Remove the table leveling bolt from the blade slot.
5. Open the top and bottom wheel doors.
6. Move the upper and lower blade guides away from the sides and rear of the saw blade.

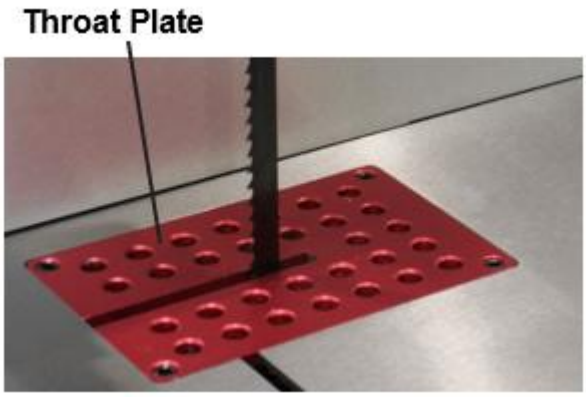


Fig. 64

CAUTION! BLADE IS SHARP, USE CAUTION WHEN HANDLING! WEAR CUT RESISTANT GLOVES FOR SAFE HANDLING

7. Remove the saw blade from the top wheel, then feed it through the upper blade guides, table slot, lower blade guides , left slot in the column and off the bottom wheel.
8. Install the new blade by reversing the steps 1-7. Ensure the blade teeth point downwards and towards you at the table.

9. Center the blade on both wheels.
10. Re-tension the blade by moving the quick release lever to ON
11. Rotate the wheel and check the blade tracking and adjust if needed. Continue rotating wheel until blade is tracked
12. Close and lock both wheel doors.
13. Re-install the Table Leveling Bolt and front Guide Rail.
14. Adjust the blade guides.
15. Tighten the blade tension.
16. Reconnect the power supply.

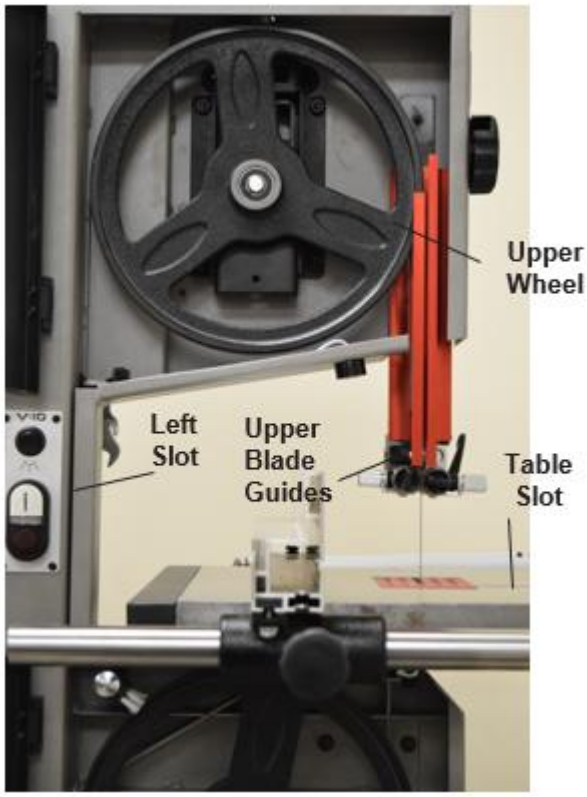


Fig. 65

5.5 Test run

Before starting the machine

Read and understand the manual before operating the saw.

1. If unsure how to use the bandsaw, consult a qualified professional.
2. Ensure proper grounding and code-compliant wiring.
3. Never operate under the influence or when tired.
4. Use eye, hearing, and dust protection.
5. Remove jewelry, ties, and roll up sleeves.
6. Always keep blade guards in place.
7. Blade teeth should face down; adjust guard close to the material.
8. Ensure proper blade tension and tracking.
9. Ensure upper and lower guides are properly adjusted and secure.
10. Ensure desired speed is selected and drive belt is seated securely on pulleys.
11. Ensure that miter gauge is set to 0°.
12. Examine workpiece to make sure it is suitable for cutting.
13. Mark your cut line: Use a pencil or marker.
14. Use the correct blade type and size.
15. Plug in the saw to the power source.
16. Turn on the light on the bandsaw.
17. Turn on the machine by pressing the ON button.
18. Keep hands away from the blade.
19. Hold workpiece firmly; support uneven stock.
20. Use a push stick at the end of cuts.
21. Feed material steadily at a moderate speed.

a. If using a new blade, slowly make first two or three cuts with slight pressure, doubling the usual cutting time. This will break in the new blade. This will ensure the blade's quality and lifespan.

22. Turn off the saw and wait for the blade to stop before backing out of a cut.
23. Turn of the saw and wait for blade to stop before removing scraps.
24. Examine workpiece
25. If there are no issues or adjustments that need to be made, the saw is now ready for use.

5.6 Operation

Using the bandsaw

Bandsaws are great for curves and straight cuts, including ripping. Bandsaw possess these attributes:

- Safer than radial arm saws due to downward cutting force, reducing kickback.
- Ideal for thick stock and minimizing wood waste, especially with expensive materials.
- Surface finish is rougher than other saws, but using a Laguna Resaw King blade improves cut quality, reduces waste, and lasts longer.

Fig. 66

Ripping Techniques

Ripping follows the wood grain; common types include rip, bevel, taper, and resaw cuts. Two methods for straight cuts:

- Single-point guide: Allows compensation for blade drift; useful with practice but not ideal for precision.
- Rip fence: Recommended for accuracy and efficiency, especially for repeated cuts.

Selecting a blade

Using a Radius Chart

When you're new to using a saw, refer to a radius (contour) chart to choose the right blade size for cutting curves. These charts, found in woodworking books, articles, and blade packaging, offer general guidance on how tight a curve each blade can handle. While they vary slightly and aren't perfectly accurate due to differences in saws and operators, they’re useful starting points.

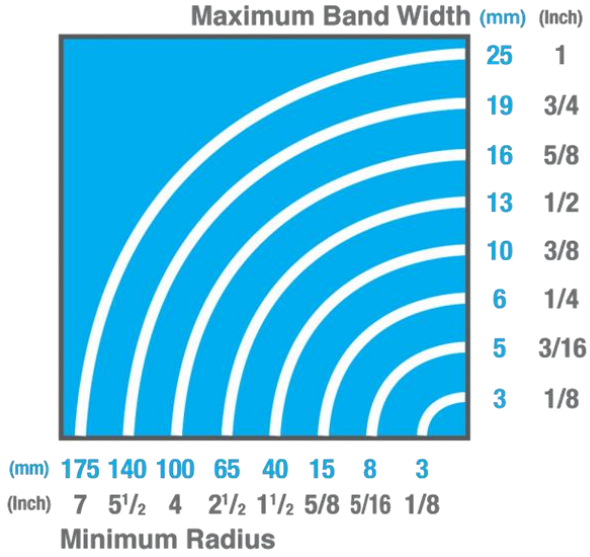


Fig. 67

Different sizes and types of blades are listed below

1. 1/4" 6 TPI. This is a small, aggressive blade that is suitable for tight curves and fast cutting where a good surface finish of the cut is not important.
2. 1/4" 14 TPI. This is a small, fine blade suitable for reasonably tight cuts where the surface finish is important, but speed of cut is less important.
3. 1/2" 3 TPI. This is a general-purpose blade that can cut large radiuses and short sections of straight cuts. The cut is fast, and the surface finish of the cut is poor.
4. 3/4" 3 TPI. This is a general-purpose blade, which will be used for straight cuts and is suitable for large radiuses.
5. 1" 2 TPI. This is a resaw blade, which will be used for straight cuts and is suitable for processing veneers.
6. If you are going to be cutting hardwoods or require superb surface finish, then you should consider purchasing a Resaw King blade from Laguna.

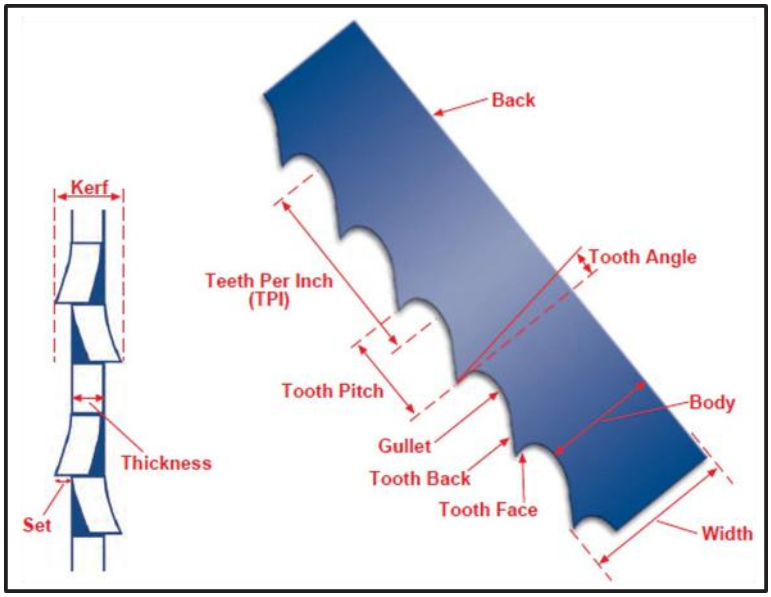


Fig. 68

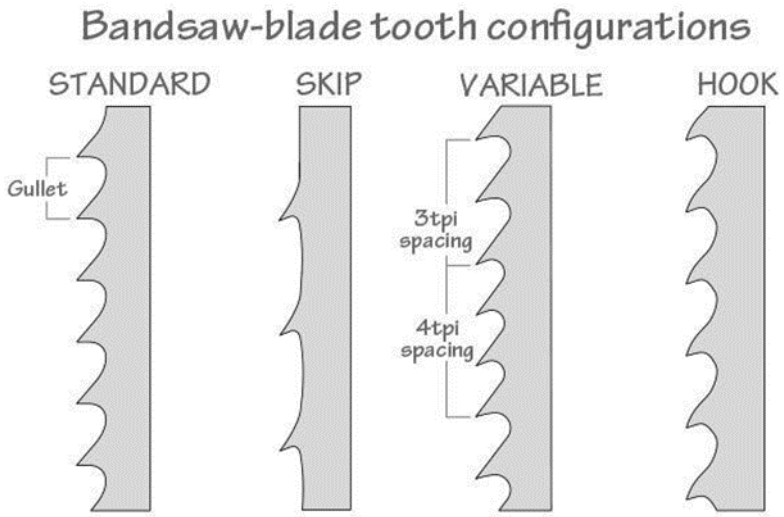


Fig. 69

How to coil a bandsaw blade

Without a doubt it is more difficult to explain how to coil a bandsaw blade than it is to actually do it. Nevertheless, below are easy-to-follow instructions on folding a blade.

Method One

While wearing a jacket or long-sleeved shirt and gloves, hold the blade in front of you in one large loop, with the teeth facing towards you. Place your foot on the blade, holding it on the ground. Grasp the blade with both hands, with your thumbs to the outside, at approximately the 10 o'clock and 2 o'clock positions (Step 1). Slowly twist the top of the blade

away from your body (Step 2). Bring your hands together to form two loops while folding down (Step 3). Continue rotating the blade until you form three loops.

Note. It is recommended that the blade is placed on material that will not damage the blade teeth (wood or cardboard). Your foot is there to give stability and not to clamp the blade, so do not exert excessive force, or the teeth/band may be damaged. The photographs are shown without gloves to enable the hand/thumb position to be shown. Gloves must be worn, as the blade could cause injury.

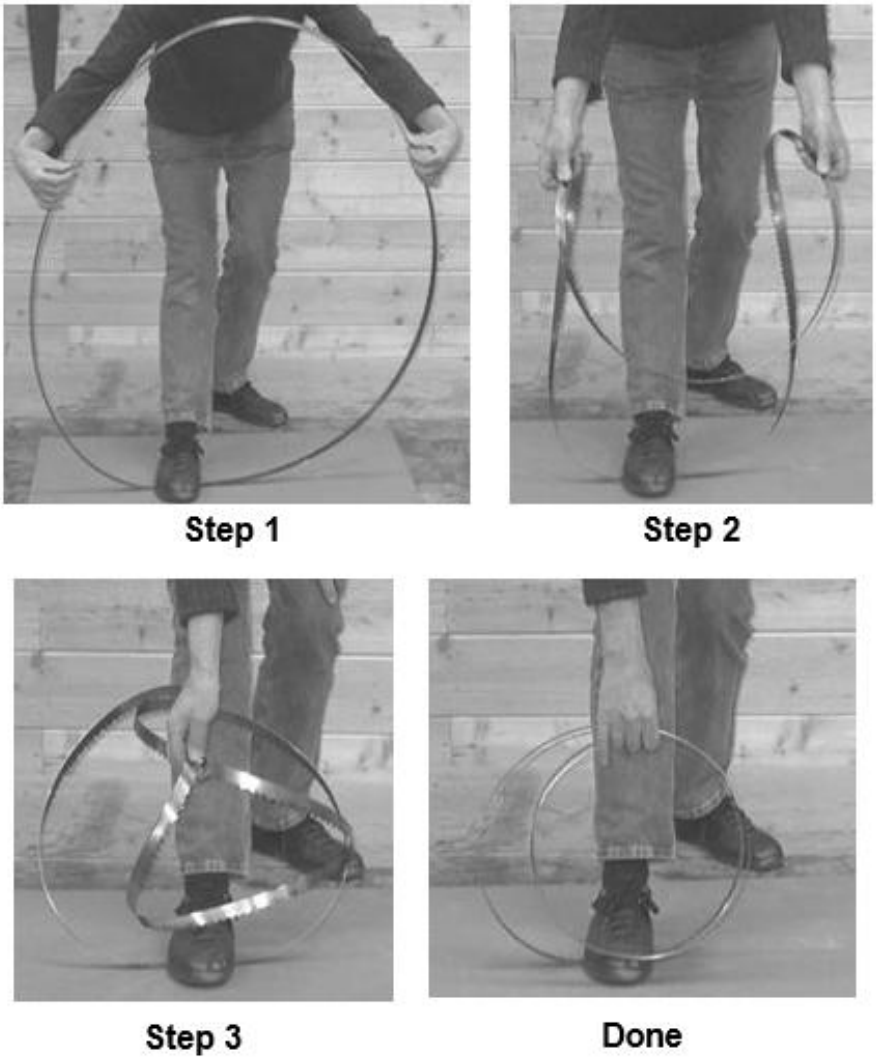


Fig. 70

Method Two

There is another variation of this that works well with small blades but simply is not possible for larger bandsaw blades, unless you're very big and strong. This method works the same as the method above, but rather than holding the blade with both hands, grasp the blade at the top while holding the bottom of the blade with your foot (teeth still facing away from you). Grasp the blade with your hand, twisting your arm such that your elbow is facing away from your body (Step 1). Turn the palm of your hand toward your body about 180 degrees and then continue turning while pushing down on the blade (Steps 2, 3 and 4). The blade will fold down upon itself into three circles, lying flat on the ground (Done).

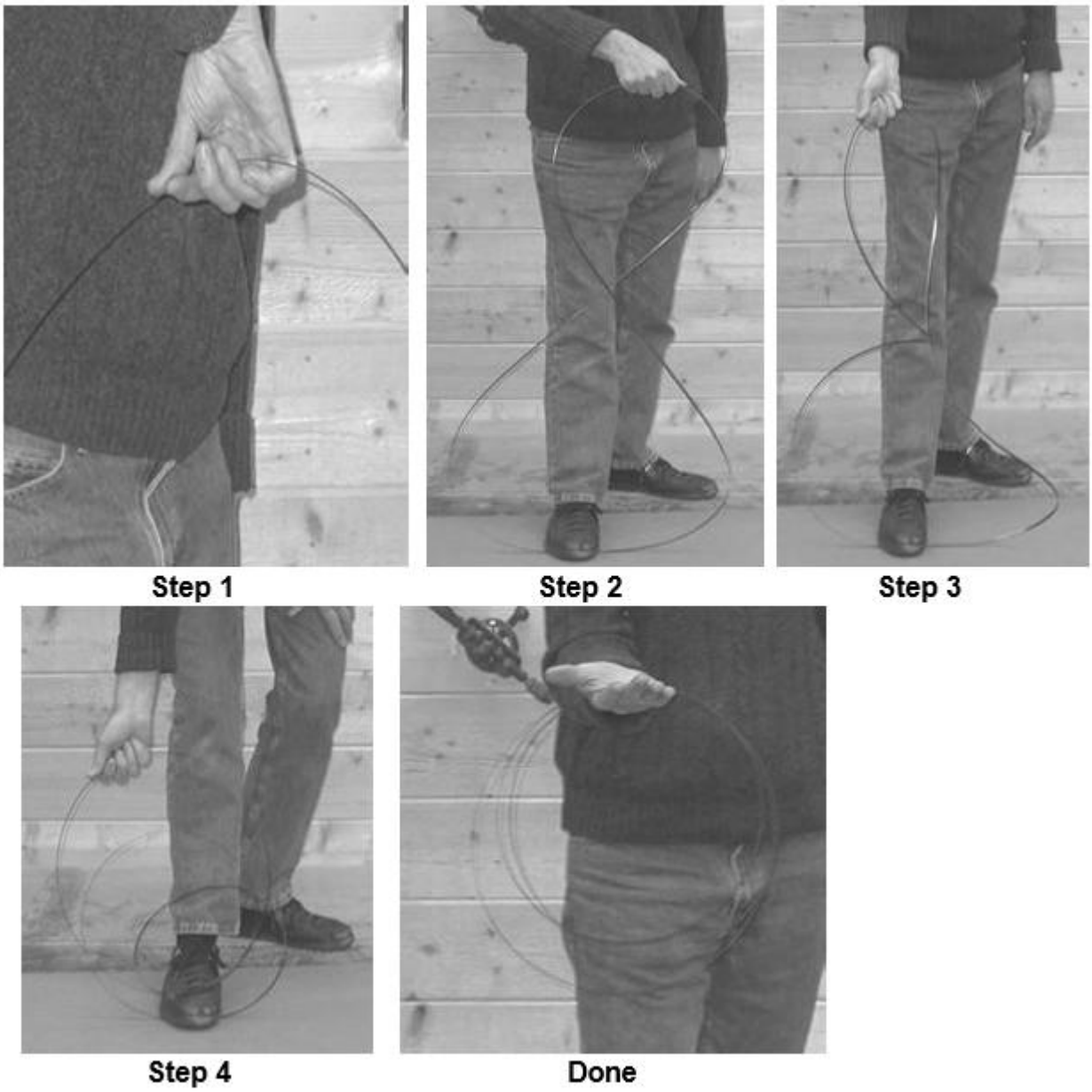


Fig. 71

Method Three

The steering wheel method. Start with the blade in front of you. as if . ou're holding a steering wheel with . our hands at the . o'clock and 3 o'clock positions. Simultaneously twist your left hand up and your right hand down. As the blade starts to fold, move your hands closer together while tilting your left hand to the right and your right hand to the left. The blade will fall into three coils. A variation of this method is to hold the blade as above, but twist both hands inward so you're looking at your knuckles and the blade will again fall into three coils.

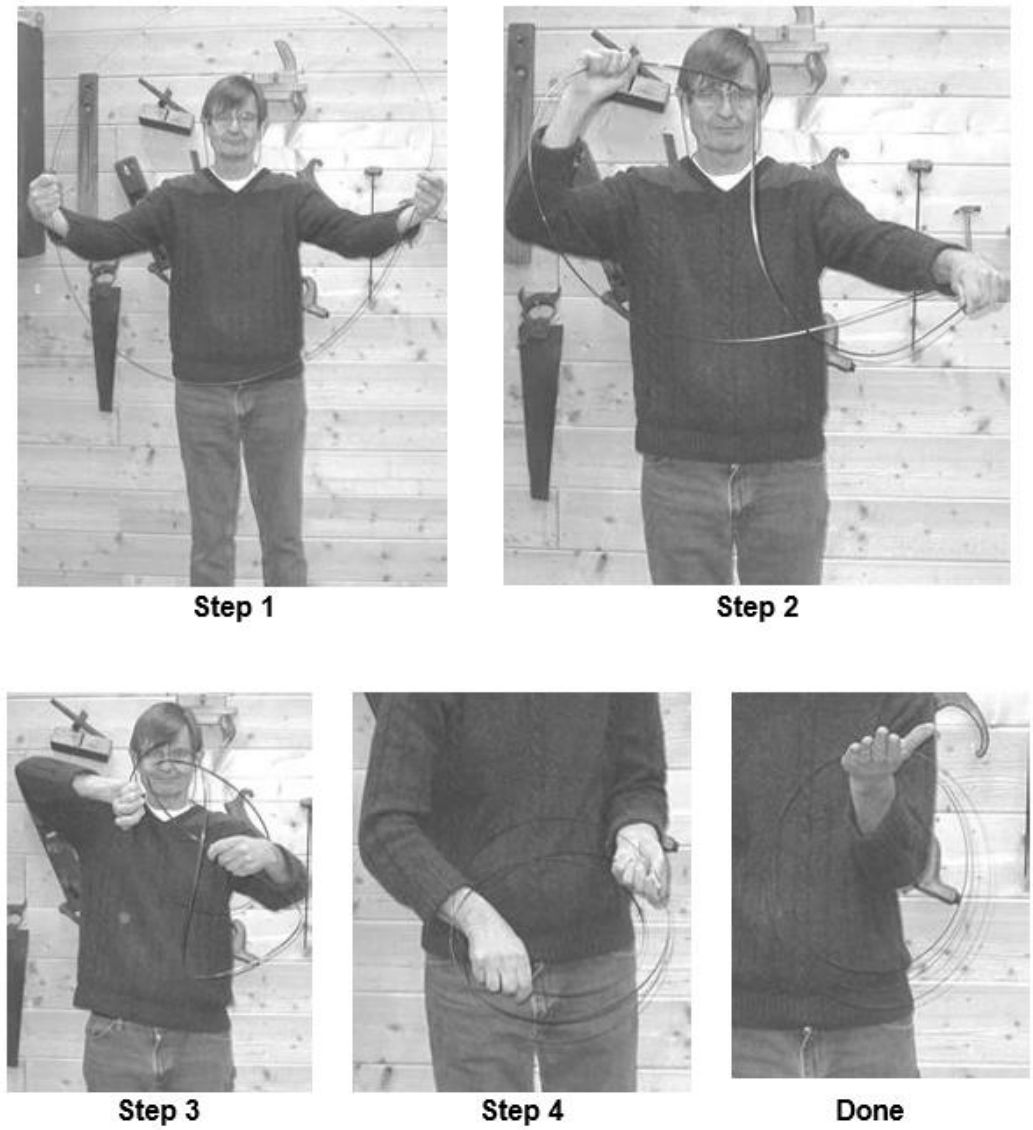


Fig. 72

6 Maintenance and Trouble shooting

Caution! Disconnect the machine from the power supply before maintenance and inspection. Carry out maintenance regularly.

Before each use, check for loose or damaged parts and whether the cord is worn out or damaged. Do not use the machine until all defects have been fixed.
After each use, clean dust and other waste from the machine and surrounding area. Wipe the machine using a dry cloth.

Performing regular maintenance will ensure optimal performance of the machine. Please follow these maintenance procedures.

Failure to follow maintenance procedures will void the warranty.

This maintenance table is based on 30 hours of use:

Maintenance Task	Frequency	Details
Clean the Bandsaw	After each use	Remove sawdust and debris from the table, blade, and wheels.
Check Blade Tension	Before each use	Ensure the blade is properly tensioned for accurate cuts.
Inspect Blade for Wear	Weekly	Look for signs of dullness, cracks, or damage. Replace if necessary.

Lubricate Moving Parts	Monthly	Apply lubricant to the blade guides, bearings, and other moving parts.
Check Wheel Alignment	Monthly	Ensure the upper and lower wheels are aligned for proper blade tracking.
Inspect Electrical Components	Quarterly	Check the power cord, switch, and motor for any signs of wear or damage.
Replace Blade	As needed	Replace the blade when it becomes dull or damaged.
Check and Adjust Blade Guides	Monthly	Ensure the blade guides are properly aligned and adjusted.
Inspect and Clean Dust Collection	Monthly	Check and clean the dust collection system to ensure proper operation.
Check Table Alignment	Quarterly	Ensure the table is square to the blade for accurate cuts.
Inspect Drive Belt	Monthly	Check the drive belt for wear and tension. Replace if necessary.
Clean and Inspect Tires	Monthly	Clean the tires and check for wear. Replace if necessary.
General Cleanliness	Weekly	Keep the entire bandsaw clean to prevent buildup of debris and dust.

Troubleshooting table

Issue	Possible Causes / Actions
Bandsaw will not start	1. Check that the start switch is being fully pulled out. 2. Check that the yellow safety plug is fully engaged. 3. Check power cord connection. 4. Reset the breaker. 5. Ensure correct voltage.
Machine will not stop	*Rare occurrence: machine is designed to be fail-safe. Disconnect from power and seek help.* 1. Stop switch faulty – replace. 2. Internal breaker faulty – replace.
Motor tries to start but will not turn	1. Disconnect power and try turning wheel by hand; check for jams (tight guides, wood stuck). 2. Replace faulty capacitor. 3. Replace faulty motor.
Motor overheats	Motor has overload protection and will auto-reset. If overheating persists: 1. Check for dull blade. 2. Avoid overfeeding. 3. Inspect cooling fan and fins for clogs. 4. Check ambient temperature.
Squeaking noise	1. Check motor cooling fan clearance. 2. Inspect bearings. 3. Check drive belt. 4. Ensure guides are adjusted properly.
Upper guide shaft is tight or loose	1. Clean and lubricate. 2. Adjust rack and pinion. 3. Replace bent rack.
Blade slows down during a cut	1. Re-tension loose drive belt. 2. Replace or resharpen dull blade. 3. Reduce feed rate. 4. Use blade with correct tooth set. 5. Clean or replace dirty/oily drive belts. 6. Align fence properly.
Blade will not track on flywheels	1. Replace bad blade. 2. Dress tires if crown is worn/damaged.
Blade kicks	Bad blade – replace it.
Blade makes a clicking noise	Bad weld – dress the weld or replace blade.
Blade overheats	1. Replace or resharpen dull blade. 2. Use blade with correct pitch. 3. Adjust overly tight guides. 4. Use appropriate blade for wood hardness. 5. Use thinner blade if wheels are too small.
Machine vibrates	1. Re-level the machine.

	2. Replace damaged drive belt.
Blade Dulling Fast	1. Poorly set side guides or rear thrust guide. 2. Poor tracking. 3. Wrong blade selection. If the blade is too narrow, it will flex more easily and decrease the quality of the cut. 4. The tooth pitch is too fine (too many teeth per inch). 5. Certain woods will dull a steel blade very quickly, especially tropical hardwoods (teak, koa, etc.). Other woods with a high silicon content will also dull the blade quickly. 6. On certain exotic woods, the ends have been painted. The paint is very abrasive and will dull the blade. It is recommended to cut the painted ends off your wood.
Causes of Blade Breakage	1. Excessive blade thickness in relation to the flywheel diameter. 2. Defective welding. 3. Incorrect tension, particularly if the blade is over tensioned; the tension spring no longer fulfils its function. 4. After use it is recommended that you slacken the tension, especially overnight (placing a visible notice of this operation). 5. Misalignment of the flywheels. 6. Irregularity of flywheel surface, for instance, an accumulation of sawdust while cutting resinous materials. You can correct these problems by readjusting the machine, changing the way you operate it or by changing the blade. Try only one change at a time.

CAUTION! READ AND UNDERSTAND THESE STEPS BEFORE MAKING ANY ADJUSTMENTS. FAILURE TO DO SO COULD DAMAGE THE MACHINE.

LOWER WHEEL ADJUSTMENTS

Adjusting the lower wheel's alignment with the upper wheel will correct blade position and oscillation (wobble), which are critical for the bandsaw's performance and accuracy.

Release the blade tension completely before adjusting the lower wheel to ensure proper adjustments and prevent machine damage.

If the blade runs off-center on the lower wheel but is correct on the upper wheel, the flywheel assembly will need to be adjusted. Use the clock face positions (12, 3, 6, 9) for easy identification.

Fig. 73

NOTE: Mark a white dot on the bolt’s edge to visually track how much the bolt has been adjusted.

The 12 and 6 o'clock positions adjust the forward and back wheel position to help align the blade

The 9 and 3 o'clock positions adjust the left and right wheel position to help align the blade.

If the blade tracks forward on the lower wheel toward the door, follow these steps below. This is a very common blade tracking issue.

1. Loosen the tension on the saw blade.
2. Loosen the 9 o'clock lock nut to relieve pressure.
3. Loosen the 12 o'clock lock nut and adjust the bolt by half a rotation.
4. Tighten the 6 o'clock lock nut and adjust the shaft bolt until it touches the 12 o'clock adjusting bolt.
5. Tighten and secure lock nuts.
6. Tighten the saw blade and adjust the upper wheel by using the tracking knob.

7. Spin the upper wheel by hand to track the blade.
8. Ensure blade looks like Figure 72 and repeat if further adjustment is needed.
9. For other adjustments, determine the position the wheel needs to be at, and adjust the corresponding bolts.

Fig. 74 - Incorrect

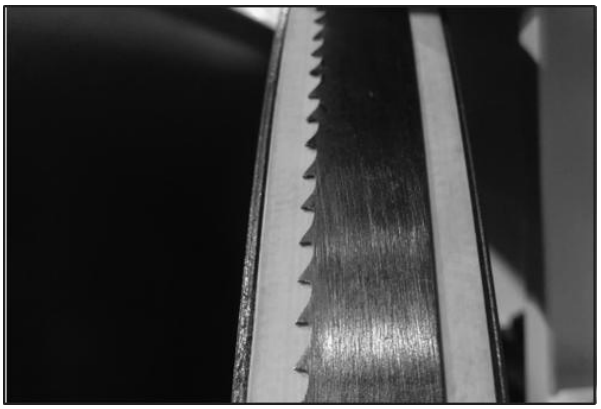


Fig. 75 - Correct

If a bandsaw blade is wobbling, follow these steps:

1. Inspect the blade and ensure it has been welded correctly and lies flat when placed on a table.
2. Loosen the tension on the saw blade.
3. Loosen the 6 o'clock lock nut.
4. Loosen the 9 o'clock lock nut and adjust the bolt half a turn.
5. Loosen the 3 o'clock lock nut and adjust the bolt until it touches the 9 o'clock bolt.
6. Tighten all three lock nuts.
7. Tighten the tension on the saw blade and adjust the upper wheel by using the tracking knob.
8. Spin the upper wheel by hand to track the blade.
9. Start the bandsaw and inspect blade movement and tracking.
10. If movement improves, continue adjusting.
11. If movement worsens, reverse steps 3 and 4.
12. Ensure the blade is in the middle of the throat plate.

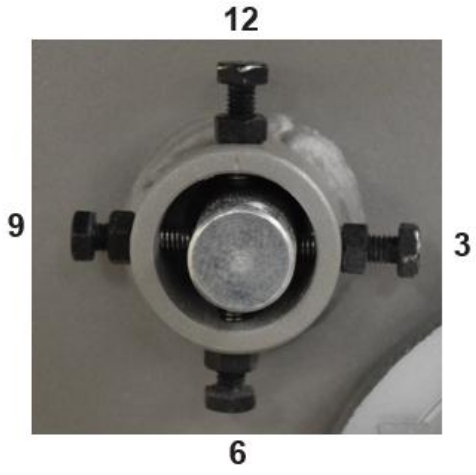


Fig. 76

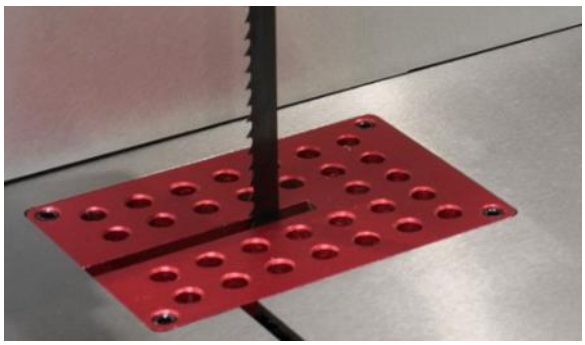


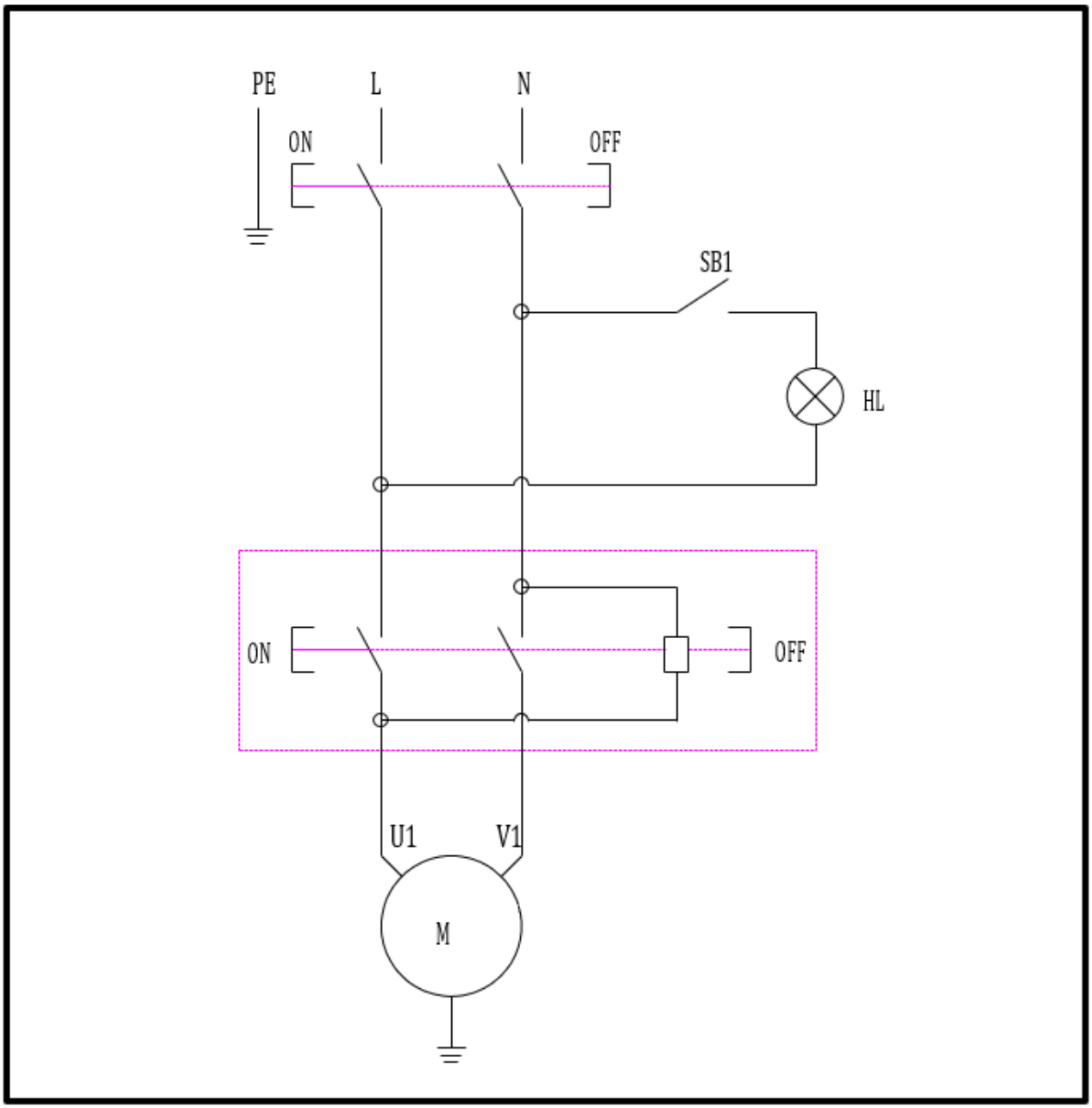
Fig. 77

7 Accessories

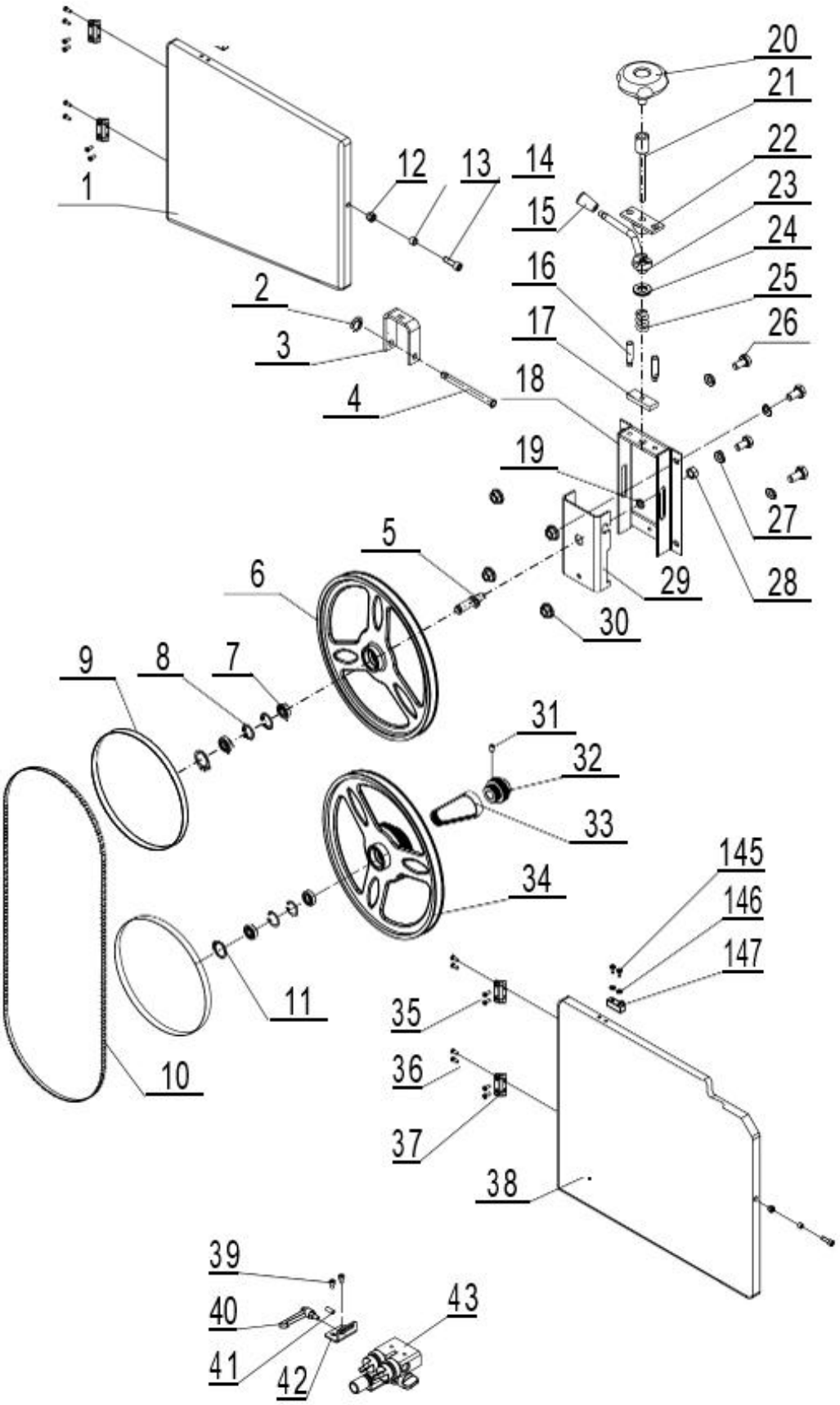
Recommended accessories are listed on the IGM website.

Caution! Installing unapproved accessories may cause damage to the machine and serious injury. Use only accessories recommended for this machine by IGM.

8 Wiring



9 Parts List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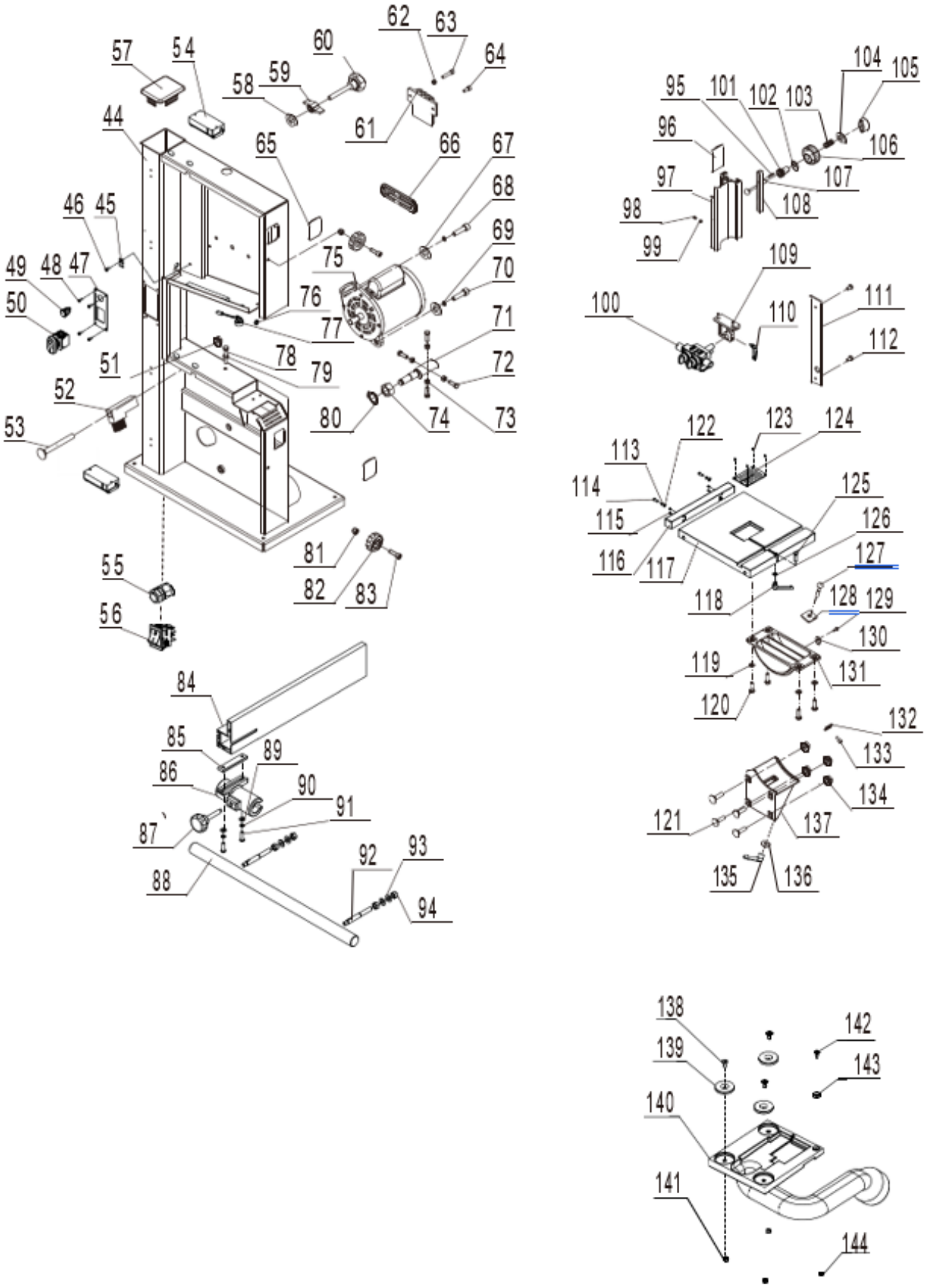
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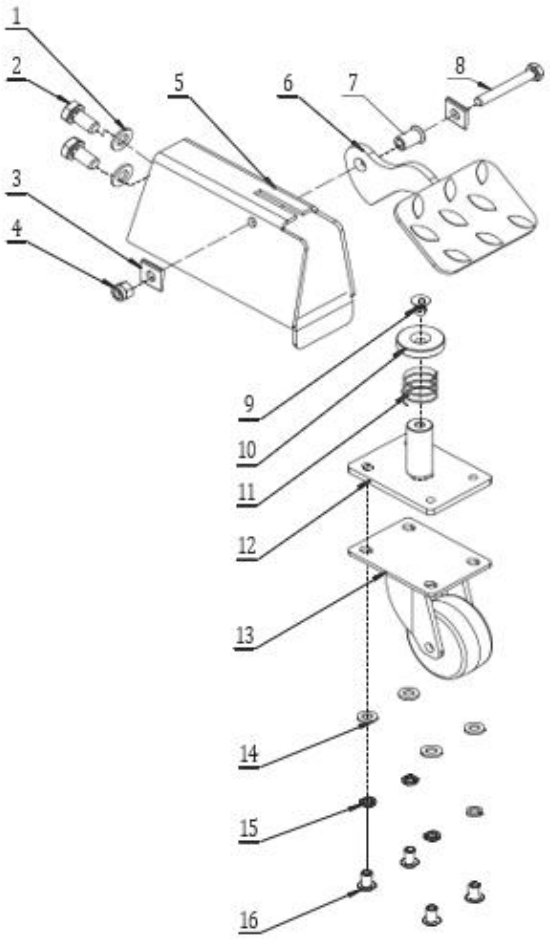
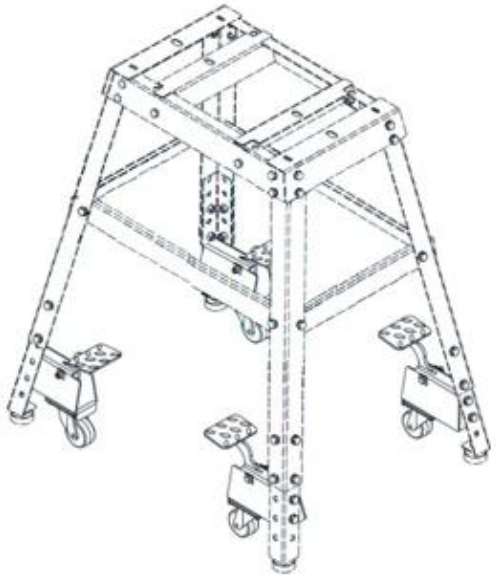
No.	Description	Part No.	Spec	Qty
PBAND10V-1	Upper door	1-JMBS1001013001D-001Z		1
PBAND10V-2	Retaining Ring	1-CLP6GB896B	6	1
PBAND10V-3	U-support	1-JMBS1001041003-001Z		1
PBAND10V-4	Guide bearing	1-JL22021002		1
PBAND10V-5	Upper wheel bearing	1-JMBS1001041001		1
PBAND10V-6	Upper wheel	1-JMBS1001021001A-001Z		1
PBAND10V-7	Bearing	1-BRG6001-2RSGB276	6001	4
PBAND10V-8	Retaining Ring	1-CLP28GB893D1B	28	4
PBAND10V-9	Rubber ring	1-JMBS1001020003		2
PBAND10V-10	Blade	1-JL22020001A		1
PBAND10V-11	Retaining rings for A bearing	1-CLP12GB894D1B	12	2
PBAND10V-12	Hexagonal Lock Nuts	1-M6GB889D1Z	M6	2
PBAND10V-13	Spacer	1-JMBS1001010008		2
PBAND10V-14	Hex Head Cap Screw	1-M6X25GB70D1Z	M6X25	2
PBAND10V-15	Handle Tube	1-JXPT1201020007-001S		1
PBAND10V-16	Positioning bolts	1-JMBS1001041010		2
PBAND10V-17	Locking plate	1-JMBS1001041004		1
PBAND10V-18	Tensioner Welding Assembly	1-JMBS1001041100-001Z		1
PBAND10V-19	Standard Spring Washer	1-WSH10GB93B	M10	1
PBAND10V-20	Tension handle	1-JMBS1001043001-001S		1
PBAND10V-21	Tension bar assembly	1-JMBS1001042000		1
PBAND10V-22	upper cam	1-JMBS1001041201		1
PBAND10V-23	Lower cam assembly	1-JMBS1001041300		1
PBAND10V-24	Bearing	1-BRG1528AXKASGB4605	1528AXKAS	1
PBAND10V-25	Press Spring	1-JMBS1001041002		1
PBAND10V-26	Hex Bolt	1-M6X12GB5783B	M6X12	4
PBAND10V-27	flat washer	1-WSH6GB97D1B	M6	4
PBAND10V-28	Hex Nut	1-M10GB6170B	M10	1
PBAND10V-29	Connecting plate for upper wheel bearing	1-JMBS0901040008-001Z		1
PBAND10V-30	Flange Nuts	1-M6GB6177D1B	M6	4
PBAND10V-31	Hex Socket Set Screw	1-M6X12GB77B	M6X12	2
PBAND10V-32	Motor Pulley	1-JMBS1001020002		1
PBAND10V-33	Poly V-Belt	1-4PJ381GB16588	4PJ-381	1
PBAND10V-34	Lower wheel	1-JMBS1001022101B-001Z		1
PBAND10V-35	Cross Recessed Pan Head Screw	1-M4X10GB818B	M4X10	8
PBAND10V-36	Cross Recessed Pan Head Screw	1-M4X6GB818B	M4X6	8
PBAND10V-37	Hinge	1-JMBS1001013100		4
PBAND10V-38	Lower door	1-JMBS1001014001D-001Z		4
PBAND10V-39	Hexagon round screw	1-M5X10GB70D2B	M5X10	2
PBAND10V-40	Adjustment handle(zinc- aluminum alloy)	1-KTSB-1-B-M6X50X10		1
PBAND10V-41	Hex Socket Set Screw	1-M6X12GB77B	M6X12	1
PBAND10V-42	Lower guide Connecting Plate	1-JMBS1001010006-182Z		1
PBAND10V-43	Lower guide assembly	1-JMBS1001012000B		1
PBAND10V-44	Frame	1-JMBS1001011000D-182Z		
PBAND10V-45	Cable clamp (single head, fine wire)	1-1502014-02		1
PBAND10V-46	Cross Recessed Pan Head Screw	1-M5X10GB818B	M5X10	1
PBAND10V-47	Control plate	1-JMBS1001010012		1
PBAND10V-48	Small Cross Recessed Pan Head Screw	1-M4X10GB823B	M4X10	4
PBAND10V-49	Switch for LED light	1-TH13-D-S88B-A7BA-D		1
PBAND10V-50	Electromagnetic switch	1-LDZ04-2(100-120V) 1-DZ04-2(220-240V)		1

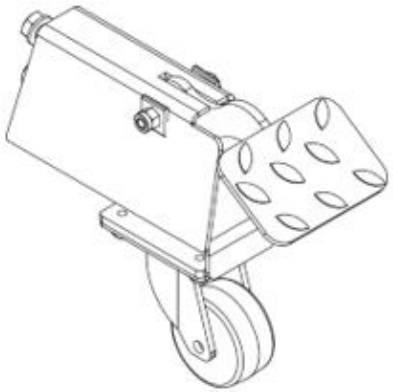
PBAND10V-51	Hexagona Flange Nuts	1-M8GB6177B	M8	1
PBAND10V-52	Cleaning Brush	1-JL22010006		1
PBAND10V-53	Bolt	1-M8X70GB14Z	M8X70	1
PBAND10V-54	Safety switch assembly	1-JL20073002、1-JL20073003、1-KW3-0Z-2B		1
PBAND10V-55	Strain Relief	1-JL20072101/1-JL20072102		1
PBAND10V-56	Simple push switch	1-AN07		1
PBAND10V-57	Top Plug	1-JL22010001A-001S		1
PBAND10V-58	Large Washer (Class A)	1-WSH8GB96D1B	M8	1
PBAND10V-59	Wing Nut	1-JL20010016-001S		1
PBAND10V-60	Plastic round Handle	1-JMBS1403060003-001S		1
PBAND10V-61	tool holder	1-JL26090001		1
PBAND10V-62	Hex Nut	1-M5GB6170B	M5	1
PBAND10V-63	Hex Head Cap Screw	1-M5X25GB70D1B	M5X25	1
PBAND10V-64	Hex Head Cap Screw	1-M5X12GB70D1B	M5X12	1
PBAND10V-65	Windows	1-JMBS1001010004		2
PBAND10V-66	Dust cover	1-JMBS1001010005		1
PBAND10V-67	Large Washer (Class A)	1-WSH8GB96D1B	M8	2
PBAND10V-68	Screw	1-M8X30GB70D1B	M8X30	1
PBAND10V-69	Standard Spring Washer	1-WSH8GB93B	M8	2
PBAND10V-70	Screw	1-M8X30GB70D1B	M8X30	1
PBAND10V-71	Lower wheel bearing	1-JMBS1001020001		1
PBAND10V-72	Hex Bolt	1-M6X20GB5783B	M6X20	4
PBAND10V-73	Hex Nut	1-M6GB6170B	M6	4
PBAND10V-74	Nut	1-M14GB6171Z	M14	1
PBAND10V-75	Motor	2-YYH718054A(100-120V)/ 2-YYH712054(220-240V)		1
PBAND10V-76	Wire cover	1-JL60010004		1
PBAND10V-77	LED Ligh assembly	1-JMBS1001019000		1
PBAND10V-78	Screw	1-M6X35GB5781B	M6X35	1
PBAND10V-79	Nut	1-M6GB6170B	M6	1
PBAND10V-80	Type A Circlip	1-CLP12GB894D1B	12	2
PBAND10V-81	Hex Nut	1-M6GB889D1Z	M6	2
PBAND10V-82	Door Handle	1-JL26010006-001S		2
PBAND10V-83	Hex Head Cap Screw	1-M6X20GB70D1Z	M6X20	2
PBAND10V-84	Fence assembly	1-JMBS1001060009A		1
PBAND10V-85	Locking plate	1-JMBS1601060002		1
PBAND10V-86	Handlebar	1-JL28060009A-001G		1
PBAND10V-87	Locking handle	1-JL82450006		1
PBAND10V-88	Front Guide Rail	1-JMBS1001060001A		1
PBAND10V-89	Flat washer	1-WSH6GB97D1B	M6	2
PBAND10V-90	Spring washer	1-WSH6GB93B	M6	2
PBAND10V-91	Hexagon round screw	1-M6X20GB70D1B	M6X20	2
PBAND10V-92	Support roller	1-JL28060005A		2
PBAND10V-93	Flat washer A Class	1-WSH8GB97D1B	M8	4
PBAND10V-94	Hex Nut	1-M8GB6170B		4
PBAND10V-95	Pin	1-PIN3X10GB879D1B	M3X10	1
PBAND10V-96	Sliding Plate	1-JMBS0901050010A-001S		1
PBAND10V-97	Upper guide sliding Plate	1-JMBS1001050003C		1
PBAND10V-98	Cross Recessed Pan Head Screw	1-M3X5GB818Z	M3X5	1
PBAND10V-99	Screw	1-M3GB6170B	M3	1
PBAND10V-100	Upper guide assembly	1-JMBS1001051000B		1

PBAND10V-101	Gear wheel	1-JMBS0901050005A		1
PBAND10V-102	Adjusting Plate	1-JL40020004		1
PBAND10V-103	Spring	1-JMBS0901050016		1
PBAND10V-104	Flat washer A class	1-WSH6GB96D1B	M6	1
PBAND10V-105	Locking handle	1-JMBS0901050015-001S		1
PBAND10V-106	Lifting Handle	1-JMBS0901050007A-001S		1
PBAND10V-107	square headed bolt	1-M6X50GB12B	M6X50	1
PBAND10V-108	Rise & Fall Rack	1-JMBS1001050001A		1
PBAND10V-109	Support block	1-JMBS1001050002A		1
PBAND10V-110	Adjustment handle(zinc- aluminum alloy)	1-JMBS1001051009-001S		1
PBAND10V-111	position plate	1-JMBS1001010001A		1
PBAND10V-112	Cross Recessed Pan Head Screw	1-M5X10GB818B	M5X10	2
PBAND10V-113	Spring washer	1-WSH6GB93B	M6	2
PBAND10V-114	Hexagon round screw	1-M6X16GB70D2B	M6X16	2
PBAND10V-115	Hex Socket Set Screw	1-M6X5GB77B12D9	M6X16	3
PBAND10V-116	Extension Table Assembly	1-JMBS1001032003-001Z	M6X5	1
PBAND10V-117	Table	1-JMBS1001032001A		1
PBAND10V-118	Adjustment handle	1-KTSB-1-B-M6X50X10		1
PBAND10V-119	External tooth washer	1-WSH6GB862D2B	M6	4
PBAND10V-120	Hex Bolt	1-M6X12GB5783B	M6X12	4
PBAND10V-121	Bolt	1-M6X16GB14B	M6X16	4
PBAND10V-122	Flat washer	1-WSH6GB97D1B	M6	2
PBAND10V-123	Hex Socket Set Screw	1-M6X5GB77B12D9	M6X5	4
PBAND10V-124	Aluminium insert	1-JMBS1001032002A		1
PBAND10V-125	Hex Bolt	1-M8X30GB5781B	M8X30	1
PBAND10V-126	Flat washer	1-WSH6GB97D1B	M8	1
PBAND10V-127	Bolt	1-M6X35GB12Z	M6X35	1
PBAND10V-128	Sliding Block	1-JMBS1001031003		1
PBAND10V-129	Screw	1-ST3D5X9D5GB845B	ST3D5X9D5	1
PBAND10V-130	Pointer	1-1506003		1
PBAND10V-131	Trunnion	1-JMBS1001031002A		1
PBAND10V-132	Block	1-JMBS1001031001-001S		1
PBAND10V-133	Hex Head Cap Screw	1-M4X10GB70D1B	M4X10	1
PBAND10V-134	Flange Nuts	1-M6GB6177D1B	M6	4
PBAND10V-135	Adjustment handle	1-KTSB-1-A-M6X50		1
PBAND10V-136	Flat washer	1-WSH6GB97D1B	M6	1
PBAND10V-137	Trunnion Support assembly	1-JL22030001B		
PBAND10V-138	Hex Socket Countersunk Head Screw	1-M5X12GB70D3B	M5X12	3
PBAND10V-139	Magnet (large)	1-JXPS1201052010		3
PBAND10V-140	Dust port	1-JMBS1001032004		1
PBAND10V-141	Hex Nut	1-M5GB6170B	M5	3
PBAND10V-142	Hex Socket Countersunk Head Screw	1-M4X12GB70D3B	M4X12	1
PBAND10V-143	Magnet	1-JMWL1203010006		1
PBAND10V-144	Hex Socket Countersunk Head Screw	1-M4GB6170B	M4	1
PBAND10V-145	Cross Recessed Pan Head Screw	1-M4X6GB818B	M4X6	2
PBAND10V-146	Flat washer	1-WSH6GB97D1B	M5	2
PBAND10V-147	Top plate	1-JMBS0901010013-001S		1

RETRACTABLE SWIVEL CASTERS - Set of 4







NO.	Description	Drawing Number
1	WSH8GB97D1B	Flat washer
2	M8X16GB5783B	screw
3	WSH6GB852B	washer
4	M6GB889D1BF	locking nut
5	WL1014A122000-001Z	Welded part for wheel kit
6	WL1014A123000-001Z	Pedal assy
7	M6X15GB17880D2Z	Nut
8	M6X45GB5781B	screw
9	M6X16GB70D3B	screw
10	WL1014A120001	Nut
11	WL1014A120002	spring
12	WL1014A121000	Castor frame
13	WL1014A120003	2" All-direction wheel
14	WSH6GB97D1B	Flat washer
15	WSH6GB93B	spring washer
16	M6X10GB70D2B	screw