

## Baileigh BS-127P-1.0

# Baileigh Industrial BS-127P-1.0 Portable Metal Cutting Band Saw

## INSTRUCTION MANUAL

### 1. Introduction

This manual provides essential information for the safe and efficient operation and maintenance of your Baileigh Industrial BS-127P-1.0 Portable Metal Cutting Band Saw. This 110-volt, variable-speed model is designed for small shops and hobbyists, offering versatility for various metal cutting tasks.

Key features of this band saw include:

- 5-inch round cutting capacity.
- Accepts standard 0.5" high x 0.025" wide x 56.69" long blades.
- Miters up to 60° to the right.
- Swivel-head miter adjustment for accurate cuts without compromising vise holding power.
- Variable blade speed from 75 to 246 feet per minute (fpm).

### 2. Safety Information

**WARNING:** Always read and understand all safety instructions before operating the machine. Failure to follow these instructions may result in serious injury or death.

- Wear appropriate Personal Protective Equipment (PPE), including safety glasses, hearing protection, and gloves, when operating the band saw.
- Ensure the work area is clean, well-lit, and free from obstructions.
- Keep hands and fingers clear of the blade at all times.
- Securely clamp all workpieces using the integrated vise to prevent movement during cutting.
- Familiarize yourself with the location and operation of the emergency stop (E-stop) button.

- Disconnect power before performing any maintenance or blade changes.

### 3. Setup

1. **Unpacking:** Carefully remove the band saw from its packaging. Inspect for any shipping damage.
2. **Placement:** Place the band saw on a stable, level workbench or stand capable of supporting its weight. Ensure adequate space around the machine for safe operation and material handling.
3. **Power Connection:** Connect the 110-volt power cord to a grounded electrical outlet.
4. **Vise Adjustment:** The vise is fully adjustable to secure various material sizes. Loosen the vise handle to open the jaws, position your material, and then tighten the handle firmly to hold the workpiece in place.
5. **Blade Tension:** Verify the blade tension is correctly set according to the manufacturer's recommendations for the installed blade type.



Figure 1: Overview of the Baileigh Industrial BS-127P-1.0 Portable Metal Cutting Band Saw. This image displays the complete band saw unit, highlighting its compact, tabletop design, the cutting arm, motor, and the material vise. The control panel and safety features are also visible.

### 4. Operating Instructions

1. **Material Preparation:** Measure and mark your cutting line on the material. Ensure the material is clean and free of debris.
2. **Secure Workpiece:** Place the material in the vise, aligning the marked cut line with the saw blade. Tighten the vise securely.
3. **Adjust Blade Speed:** Use the variable speed control to select the appropriate blade speed (75 to 246 fpm) for the type and thickness of metal being cut. Refer to the speed chart (if available on the machine or in supplementary documentation) for guidance.
4. **Miter Angle Adjustment:** For angled cuts, adjust the swivel head to the desired miter angle (up to 60° to the right). Ensure it is locked in place before cutting.
5. **Control Mode Selection:** The saw features a switch to select between hand control and foot control. Choose the mode that best suits your task, especially for two-handed operations where foot control can enhance safety and precision.
6. **Initiate Cut:**
  - For hand control: Gently lower the saw arm using the handle.
  - For foot control: Activate the saw using the foot pedal (if connected and selected).

Apply steady, even pressure. Do not force the blade through the material. Allow the blade to do the work.

7. **Complete Cut:** Once the cut is complete, release the power control (handle or foot pedal) and allow the blade to stop completely before raising the saw arm.
8. **Remove Workpiece:** Loosen the vise and carefully remove the cut material. Be aware of sharp edges and hot surfaces.

## 5. Maintenance

Regular maintenance ensures the longevity and safe operation of your band saw.

- **Cleaning:** After each use, clean metal shavings and debris from the saw, especially around the blade, vise, and motor vents. Compressed air can be used carefully.
- **Blade Inspection:** Regularly inspect the blade for wear, damage, or dullness. Replace worn blades promptly to maintain cutting efficiency and safety.
- **Lubrication:** Apply appropriate lubricant to moving parts as indicated in the detailed product manual (not provided here) to ensure smooth operation.
- **Electrical Check:** Periodically inspect the power cord and connections for any signs of damage.

## 6. Troubleshooting

Problem	Possible Cause	Solution
Saw does not start	No power, E-stop engaged, faulty switch	Check power connection, release E-stop, inspect power switch.
Poor cut quality / Slow cutting	Dull blade, incorrect blade speed, insufficient pressure	Replace blade, adjust blade speed, apply steady pressure.
Excessive vibration	Loose components, damaged blade, unstable setup	Check all fasteners, inspect/replace blade, ensure stable placement.

For issues not listed here, please contact Baileigh Industrial customer support.

## 7. Specifications

Feature	Detail
Brand	Baileigh
Model Number	1018561
Power Source	AC/DC, 110 Volt
Blade Material	High Speed Steel
Surface Recommendation	Metal
Round Capacity @ 90 Degrees	5 inches
Blade Dimensions	0.5" high x 0.025" wide x 56.69" long
Cutting Angle	Up to 60 Degrees (miter)
Variable Blade Speed	75 to 246 fpm
Item Weight	1.1 pounds <i>(Note: This weight may refer to a component, not the full machine.)</i>
Handle Material	Plastic or Metal
UPC	731325475777

## 8. Warranty and Support

This product comes with a **limited warranty**. For specific details regarding warranty coverage, terms, and conditions, please refer to the warranty card included with your product or visit the official Baileigh Industrial website.

For technical support, parts, or service inquiries, please contact Baileigh Industrial customer service. Contact information can typically be found on the product packaging or their official website.