



# Dayton® 9 x 14" Self-feeding Metal Cutting Band Saw

## General Safety Information (Continued)

**▲ CAUTION** *Always follow proper operating procedures as defined in this manual — even if you are familiar with use of this or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury.*

### BE PREPARED FOR JOB

1. Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
2. Wear protective hair covering to contain long hair.
3. Wear safety shoes with non-slip soles.
4. Wear safety glasses complying with United States ANSI Z87.1. Everyday glasses have only impact resistant lenses. They are **NOT** safety glasses.
5. Wear face mask or dust mask if operation is dusty.
6. Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

### PREPARE WORK AREA FOR JOB

1. Keep work area clean. Cluttered work areas invite accidents.
2. Do not use power tools in dangerous environments. Do not use power tools in damp or wet locations. Do not expose power tools to rain.
3. Work area should be properly lighted.
4. Proper electrical receptacle should be available for tool. Plug 115 volt, single-phase plug directly into properly grounded, three-prong receptacle.
5. Extension cords should have a grounding prong and the three wires of the extension cord should be of the correct gauge.

6. Keep visitors at a safe distance from work area.
7. Keep children out of workplace. Make workshop childproof. Use padlocks or master switches to prevent any unintentional use of power tools.

### TOOL SHOULD BE MAINTAINED

1. Always unplug tool prior to inspection.
2. Consult manual for specific maintaining and adjusting procedures.
3. Keep tool lubricated and clean for safest operation.
4. Remove adjusting tools. Form habit of checking to see that adjusting tools are removed before switching machine on.
5. Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended function.
6. Check for damaged parts. Check for alignment of moving parts, binding, breakage, mounting and any other condition that may affect a tool's operation.
7. A guard or other part that is damaged should be properly repaired or replaced. Do not perform makeshift repairs. (Use parts list provided to order repair parts.)

### KNOW HOW TO USE TOOL

1. Use right tool for job. Do not force tool or attachment to do a job for which it was not designed.
2. Disconnect tool when changing blade and removing chips.
3. Avoid accidental start-up. Make sure that the tool is in the OFF position before plugging in.

4. Do not force tool. It will work most efficiently at the rate for which it was designed.
5. Keep hands away from moving parts and cutting surfaces.
6. Never leave tool running unattended. Turn the power off and do not leave tool until it comes to a complete stop.
7. Do not overreach. Keep proper footing and balance.
8. Never stand on tool. Serious injury could occur if tool is tipped or if blade is unintentionally contacted.
9. Know your tool. Learn the tool's operation, application and specific limitations.
10. Use recommended accessories (Refer to page 19). Use of improper accessories may cause risk of injury to persons.
11. Handle workpiece correctly. Protect hands from possible injury.
12. Turn machine off if it jams. Blade jams when it digs too deeply into workpiece. (Motor force keeps it stuck in the work.) Do not remove jammed or cut off pieces until the saw is turned off, unplugged and the blade has stopped.

**▲ CAUTION** *Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.*

## Assembly

### REMOVE SHIPPING BRACKET

Refer to Figure 13.

1. Remove bracket (Ref. No. 69) by removing four hex head bolts and washers (Ref. Nos. 15 and 25).
2. Store bracket and bolts. If saw is moved in the future, bracket must be installed to prevent damage to saw.

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## Assembly (Continued)

### ATTACH ROLLER ASSEMBLY

Refer to Figure 13.

1. Attach one of the brackets (Ref. Nos. 21 and 23) with two hex head bolts and lock washers (Ref. Nos. 24 and 25).
2. Slide one end of the roller (Ref. No. 22) into the attached bracket, slide remaining bracket over the other end of the roller and then attach bracket to table with hex head bolts and lock washers.

### ATTACH COUNTERWEIGHT

Refer to Figure 13.

Slide counterweight and knob onto counterweight lever and secure in position (Ref. Nos. 54 and 55).

### ATTACH C-CLAMP VISE

Refer to Figure 13.

1. Insert guide rod (Ref. No. 5) of C-clamp into miter jaw (Ref. No. 17).
2. Tighten C-clamp onto miter jaw.

### ATTACH BELT GUARD

Refer to Figure 15.

1. Remove two pan head screws and washers (Ref. Nos. 57 and 60) from head (Ref. No. 45).
2. Place belt guard (Ref. No. 58) on head over belt drive.
3. Secure in position with flat washers and pan head screws.

## Installation

**CAUTION** Do not attempt installation if parts are missing. Use this manual to order repair parts.

Before band saw is installed, a suitable location should be chosen. Band saw weighs approximately 555 lbs.

1. Band saw needs to be set on a flat, level surface. If needed, insert provided leveling bolts and nuts (Figure 13, Ref. Nos. 44 and 53) into mounting brackets (Figure 13, Ref. No. 57) to level saw.

**NOTE:** Saw must be level in both side to side and front to back directions.

2. Make sure there is ample room for the workpiece. Minimum required floor space is 34" wide x 50" deep x 65" high.

3. Good lighting and correct power supply are also required for a proper work area.

### POWER SOURCE

Band saw requires a 115/230 volt, 60 Hz power source. Band saw is shipped with a three-prong 115V plug on the line cord and prewired to operate at 115 volts.

**WARNING** All electrical connections must be performed by a qualified electrician.

**WARNING** Do not connect band saw to the power source until all assembly steps have been completed.

The motor is designed for operation on the voltage and frequency specified. Normal loads will be handled safely on voltages not more than 10% above or below the specified voltage.

Running the unit on voltages which are not within the range may cause overheating and motor burn-out. Heavy loads require that the voltage at motor terminals be no less than the voltage specified.

### GROUNDING INSTRUCTIONS

**WARNING** Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock.

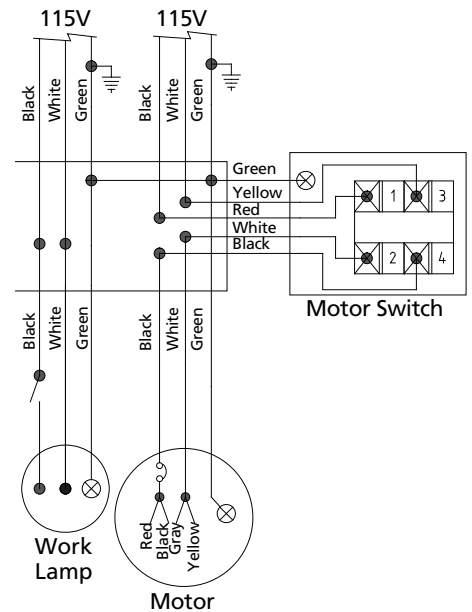


Figure 2 - Electrical Schematic

Check with a qualified electrician if you do not understand grounding instructions or if in doubt as to whether the tool is properly grounded.

This tool is equipped with an approved cord rated at 250V and a 3-prong grounding type plug rated at 125V (See Figure 3) for your protection against shock hazards.

Grounding plug should be plugged directly into a properly installed and grounded 3-prong grounding-type receptacle, as shown (See Figure 3).

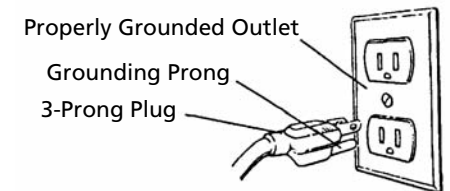


Figure 3 - 3-Prong Receptacle

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## Installation (Continued)

Do not remove or alter grounding prong in any manner. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

**⚠ WARNING** Do not permit fingers to touch the terminals of plug when installing or removing from outlet.

Plug must be plugged into matching outlet that is properly installed and grounded in accordance with all local codes and ordinances. Do not modify plug provided. If it will not fit in outlet, have proper outlet installed by a qualified electrician.

Inspect tool cords periodically, and if damaged, have repaired by an authorized service facility.

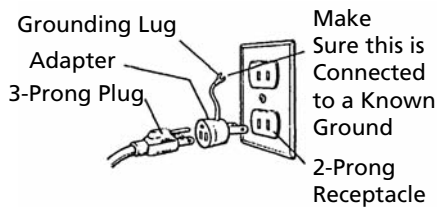
Green (or green and yellow) conductor in cord is the grounding wire. If repair or replacement of the electric cord or plug is necessary, do not connect the green (or green and yellow) wire to a live terminal.

Where a 2-prong wall receptacle is encountered, it must be replaced with a properly grounded 3-prong receptacle installed in accordance with National Electric Code and local codes and ordinances.

**⚠ WARNING** This work should be performed by a qualified electrician.

A temporary 3-prong to 2-prong grounding adapter (See Figure 4) is available for connecting plugs to a two pole outlet if it is properly grounded.

Do not use a 3-prong to 2-prong grounding adapter unless permitted by local and national codes and ordinances.



**Figure 4 – 2-Prong Receptacle with Adapter**

(A 3-prong to 2-prong grounding adapter is not permitted in Canada.) Where permitted, the rigid green tab or terminal on the side of the adapter must be securely connected to a permanent electrical ground such as a properly grounded water pipe, a properly grounded outlet box or a properly grounded wire system.

Many cover plate screws, water pipes and outlet boxes are not properly grounded. To ensure proper ground, grounding means must be tested by a qualified electrician.

### 230V CONVERSION

To use the band saw with a 230V power supply:

1. Have a qualified electrician attach a 230 volt, 20/30A 3-prong plug to band saw line cord.

Recommended Dayton plugs, connectors and receptacles for 230 volts:

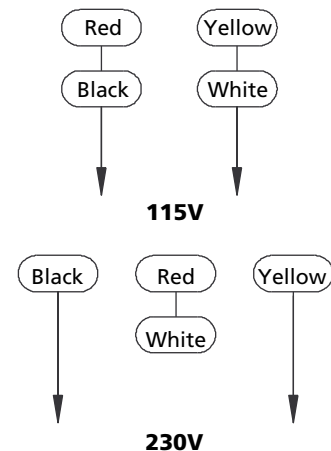
20 Amps Plug	250 Volts Connector	NEMA L6-20 Receptacle
5A081	5A082	5A080

5A081	5A082	5A080
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30 Amps Plug	250 Volts Connector	NEMA L6-30 Receptacle
5A087	5A088	5A086

5A087	5A088	5A086
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2. Rewire saw motor to 230 volts (See Figure 5).



**Figure 5 – Saw Motor Wiring Diagram**

### EXTENSION CORDS

1. The use of any extension cord will cause some drop in voltage and loss of power.
2. Wires of the extension cord must be of sufficient size to carry the current and maintain adequate voltage.
3. Use the table to determine the minimum wire size (A.W.G.) extension cord.
4. Use only 3-wire extension cords having 3-prong grounding type plugs and 3-pole receptacles which accept the tool plug.
5. If the extension cord is worn, cut, or damaged in any way, replace it immediately.

#### EXTENSION CORD LENGTH (115V)

Wire Size	A.W.G.
Up to 25 ft. ....	14
25-50 ft. ....	12

**NOTE:** Using extension cords over 50 ft. long is not recommended.

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## Installation (Continued)

EXTENSION CORD LENGTH (230V)	
Wire Size	A.W.G.
Up to 50 ft. ....	18
50-100 ft. ....	16

**NOTE:** Using extension cords over 100 ft. long is not recommended.

## Operation

Refer to Figures 6-15.

The 9 x 14", Self-feeding metal cutting band saw blade speeds range from 70 to 580 FPM.

Miter saw can turn 0-45° for making angle cuts. Saw can also make contour cuts.

**▲ WARNING** *Always observe the following safety precautions.*

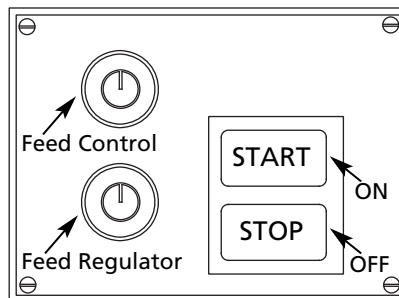
1. Whenever adjusting or replacing any parts on the band saw turn switch off and remove plug from power source.
2. Make sure the stops are positioned.
3. Check that the gear box has the proper amount of lubricant.
4. Make sure the blade guides are positioned correctly.
5. Use the appropriate blade for the workpiece that is being cut.
6. Use a sharp blade. Replace dull blades or blades which are missing teeth.
7. Make sure the blade is tensioned properly and going in the right direction.
8. Use the proper blade speed for the work.
9. For optimum performance, do not stall the motor or reduce the speed. Use the proper feed pressure.

10. Secure the workpiece in a stable position.
11. Check that all guards are attached.
12. After turning the switch on, let the blade come to full speed. Then lower the blade onto the workpiece slowly.
13. Keep hands away from the blade and all moving parts.
14. Always wear eye protection.
15. When cutting magnesium, NEVER use soluble oils or emulsions (oil-water mix) as water will greatly intensify any accidental magnesium chip fire. Consult your coolant supplier for coolant recommendations when cutting magnesium.
16. To prolong blade life, always release blade tension after use.

## OPERATING CONTROLS

Refer to Figures 6 and 13.

Band saw control panel has four functional operations:



**Figure 6 – Band Saw Control Panel**

- OFF** - Red color push button that stops the band saw.
- ON** - Green color push button that starts the band saw.
- FEED REGULATOR** - Dial knob to set band saw feed rate. Set the feed rate suitable to application.
- FEED CONTROL** - Two position ON/OFF knob engages and disengages feed.

**SAW RELEASE LEVER** - Pull up on this lever (Ref. No. 39) to release saw head to begin feeding into workpiece. Push down on lever to return saw head to the uppermost position.

## FEED STOP

Refer to Figure 13.

Feed stop (Ref. No. 74) controls the position of the head at the end of the cut.

**NOTE:** Saw will damage table and vise if feed stop is not properly adjusted. Before operation, check that blade does not contact table or vise when saw head is in the forward position.

Head stop (Ref. Nos. 3, 41 and 76) also controls forward movement of the saw head.

## FEED STOP ADJUSTMENT

Refer to Figure 13.

1. Loosen the knob (Ref. No. 55) on the feed stop.
2. Adjust the feed stop so that red indicator line on the lens (Ref. No. 73) coincides with the width of the blade used on stop scale (Ref. No. 72).
3. Tighten the knob to lock the position.
4. Also adjust head stop (Ref. No. 3, 41 and 76) whenever feed stop is adjusted.

## LUBRICATION

1. All ball bearings are permanently lubricated. They should not require further lubrication.
2. If the tracking wheel or head pivot is disassembled for any reason, wipe off the old grease before assembly.

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## Operation (Continued)

### OIL LEVEL

Refer to Figure 7.

1. The gear box relies on an oil bath to lubricate the sliding surfaces and transfer heat. Insufficient lubrication will cause the gears to heat up and wear at an accelerated rate. The gearbox is designed to take 34 ounces of 70-95 weight industrial gear oil.
2. The oil level should remain constant. If the level changes, a defective gasket or bushing should be looked for and replaced.
3. If the gear box is worked on, the oil should be replaced to avoid contamination.
4. Always add fresh oil and replace the oil every six months, to guard against breakdown.
5. The seals between the gearbox and the cover plates are gaskets. If a cover plate is removed, the surface should be cleaned and new gasket should be applied.
6. After the first fifty hours of use, the gear box should be drained and refilled with industrial gear oil (Model No. 6Y785).

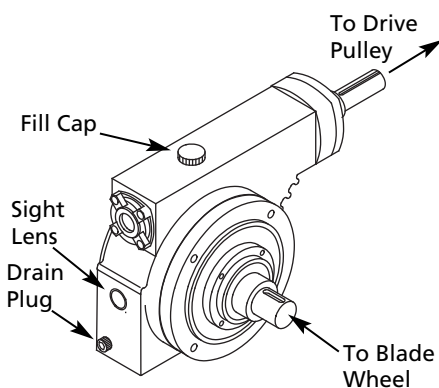


Figure 7 - Gearbox

### CHECKING OIL LEVEL

Refer to Figure 8.

1. Place the head in the horizontal position.
2. Let the oil settle. Allow a few minutes if the head was in motion.
3. Check the fluid level. Look at the oil sight lens and follow the instructions in Figure 8.



Sight lens full of oil: Drain oil by removing drain plug



Sight lens half-covered: The oil level is correct



No oil visible: Remove vent bolt and add oil

Figure 8 - Checking Oil

### ADJUSTMENTS

The blade tracking, tension, and blade guides have been properly adjusted at the factory. However, the adjustments may change while the saw is in transit. It is recommended to verify these adjustments before operating saw.

Before operating the saw, verify 1) the blade guides are properly positioned, 2) the cutting stock is properly positioned and securely clamped, 3) the saw is set at the correct cutting angle, and 4) the speed control dial is set to the desired level.

### TRACKING

Proper tracking is achieved when the drive wheel and tracking wheel are aligned. A blade that is not tracking correctly can come off the blade wheels. Although adjustment is rarely required, tracking should be checked frequently.

### CAUTION

Turn motor off and disconnect power

to check tracking.

### TRACKING ADJUSTMENT

Refer to Figures 14 and 15.

The tracking is adjusted by positioning the idler wheel shaft (Fig. 14, Ref. No. 4).

1. Loosen the two lower socket head bolts (Fig. 15, Ref. No. 16).
2. Start saw. Turn set screw (Fig. 15, Ref. No. 15) to tilt wheel until blade is 1/32" away from wheel flange.
3. Check the blade tension and adjust if necessary.
4. Recheck the tracking.
5. Once the proper position has been found, tighten the two lower bolts securely.

### BLADE TENSION

Refer to Figure 15.

1. The handle (Ref. Nos. 1 and 2) to adjust blade tension is located at top of head.
2. Turn the knob counterclockwise to increase tension. Blade tension should be set at least to 25000 psi. Use tension scale (Ref. Nos. 10 and 14).
3. A properly tensioned blade will ring slightly when back of blade is plucked (like a string on an instrument). Do not exceed the maximum tension as this may cause the blade to come out of the guides and cause damage or injury.

**NOTE:** Re-check tension of new blade after several minutes of operation. Blade may require additional tension.

# Model 2LKU4

## Operation (Continued)

### BLADE GUIDES

Band saw blade has to be twisted relative to the plane in which it rotates. Blade must be properly positioned relative to the work table.

Blade guides hold the cutting portion of the blade in a plane which is perpendicular to both the work table and keeps the blade in line with its natural path around the blade wheels.

Inner guide bearings on the upper and lower guide assemblies keep the blade in line with the blade wheels. Outer guide bearings keep the blade against the inner bearings.

Entire guide assembly is positioned at the factory to produce the proper twist and should not need adjustment, however, the position of blade guides should be checked often.

**NOTE:** Since the blade position is related to both bed and the vise jaws, the relative position of the jaw to the bed is important. When assembled, the stationary jaw must be perpendicular to the surface of the work table.

### ADJUSTING GUIDE BEARINGS

Refer to Figures 14 and 15.

If the blade is not perpendicular to the table or not in line with the blade wheels, adjustment is necessary.

**NOTE:** There should be .000-.001" clearance between the blade and the guide bearings.

The guide bearings are adjusted using an eccentric location system. Both inner and outer guide bearings are mounted to eccentric shafts (Fig. 14, Ref. Nos. 13 and Fig. 15, Ref. No. 43) and can be adjusted.

1. Loosen set screw (Fig. 14, Ref. No. 15 and Fig. 15, Ref. No. 42). Rotate the eccentric shaft to locate bearings in desired positions using screwdriver.
2. Maintain eccentric shaft position and tighten set screw.

### ADJUSTING GUIDE BRACKETS

Refer to Figures 14 and 15.

1. If the blade is not square or is twisted and the bearings have been adjusted properly, one or both blade guide brackets (Fig. 14, Ref. No. 16 and Fig. 15, Ref. No. 40) must be adjusted.
2. The blade must travel through the guide bearings as straight as possible without bending or twisting. There must also be .000-.001" clearance between blade and guide bearings.
3. Loosen set screws (Fig. 14, Ref. No. 15 and Fig. 15, Ref. No. 39).
4. Rotate guide brackets to eliminate any bending of the blade.
5. Tighten set screws to secure the position.
6. Check and readjust the guide bearings.

### BLADE SELECTION

Using the proper blade is important for setting up the correct cutting conditions. Blades are made differently depending on the specific application intended for the blade. Some simple rules can still be applied to almost all blades.

1. Always remember to have at least three teeth in contact with the work during a cut. When three teeth are in contact, the blade cannot straddle the work. This prevents a tooth that enters the cut from encountering more material than it can remove.

2. "Shocking" occurs when blade teeth contact too much material. This can strip the teeth from the blade. When cutting harder materials, the suggested minimum number of teeth in contact is six because "shocking" on harder materials has a more detrimental effect on the blade. Optimum number of teeth in contact with workpiece distributes blade forces among more teeth to increase cutting efficiency and reduces blade wear.
3. Optimum range is from 6-12 teeth in contact for soft materials, up to 12-24 teeth in contact for harder materials.
4. Always have maximum number of teeth in contact with work to prevent gullets of teeth from being clogged.
5. When choosing a blade, overall size of the work is not as important as the thickness average. Thickness average is the average width of material which blade will contact during each cut. Figure 12 describes how thickness average should be calculated.
6. Thickness average should be used when choosing a blade for the optimum number of teeth in contact, however, the three teeth rule should be applied to the minimum thickness, not thickness average.
7. Keeping a selection of sharp blades on hand will yield better cuts. Blades may last longer because they are less likely to be misused when proper blade is available.
8. Every band saw should have at least one replacement blade of each type used. Blade breakage is unpredictable. Consult a blade manufacturer for detailed information about available blades for specific uses.

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## Operation (Continued)

### REMOVING BLADE

Refer to Figures 14 and 15.

**⚠ WARNING** *Disconnect band saw from power source when changing or adjusting blades. Wear leather gloves when handling band saw blades. Never wear gloves when operating saw.*

1. Prop open the blade wheel cover (Fig. 14, Ref. No. 1).
2. Remove three screws, washers and lower wheel guard (Fig. 15, Ref. Nos. 57, 59 and 60).
3. Loosen the outer guide bearings on the upper and lower guide assemblies. No other guide bearings should be moved.
4. Move guide post (Fig. 15, Ref. No. 32) completely up, then loosen knob (Fig. 15, Ref. No. 41) and remove blade guard (Fig. 15, Ref. No. 44).
5. With one hand, pinch the blade and the tracking wheel together to protect against the possibility of the blade popping off when tension is released.
6. Release the tension by slowly revolving the hand wheel (Fig. 15, Ref. Nos. 1 and 2) clockwise.
7. Remove the blade.

### REPLACING THE BLADE

1. Make sure the outer guide bearings are loose.
2. Make sure the teeth are pointing down toward table (See Figure 9). If necessary, turn blade inside out.



Figure 9 – Blade Direction

3. Place the blade around the wheels and between the guide bearings.
4. Hold the blade in position and apply tension. Blade tension generally must be set at 25000 psi for hard back blades, and 35000 psi for bi-metal blades. Use tension scale (Figure 15, Ref. Nos. 10 and 14).
5. Push the blade against the wheel flange.
6. Tighten the blade until it is properly tensioned. A properly tightened blade will ring slightly when the back of the blade is plucked (like a string of an instrument).
7. Adjust the outer guide bearings.
8. Check for proper tracking (See Tracking Adjustment).
9. Replace lower wheel guard and blade guard. Close upper wheel cover.

### BLADE SPEED

Refer to Figures 10 and 15.

**⚠ WARNING** *Disconnect saw from power when changing speed.*

Choosing the proper blade speed is important for extending the life of the blade. The speed determines the available cutting force.

1. Harder materials require more force and are cut at a slower speed.
2. Softer materials are cut with less force at higher speeds to ensure the proper removal of the chips.
3. The speed and corresponding force are related to the power supplied to the blade.
4. Release saw head and let it rest at forward position. Remove screws, washers and belt guard (Fig. 15, Ref. Nos. 57, 58 and 60).

5. Lift motor to release belt tension, reposition V-belt in desired position, then lower motor.
6. Replace belt guard.

### FPM

- 70 . . . . . Tool steel, stainless steel, bearing bronze, alloy steels.
- 140 . . . . . Medium to high carbon steels, soft cast iron, hard brass.
- 280 . . . . . Soft brass and bronze, copper
- 580 . . . . . Soft aluminum, plastic, wood

Refer to speed chart on saw for more detailed information.

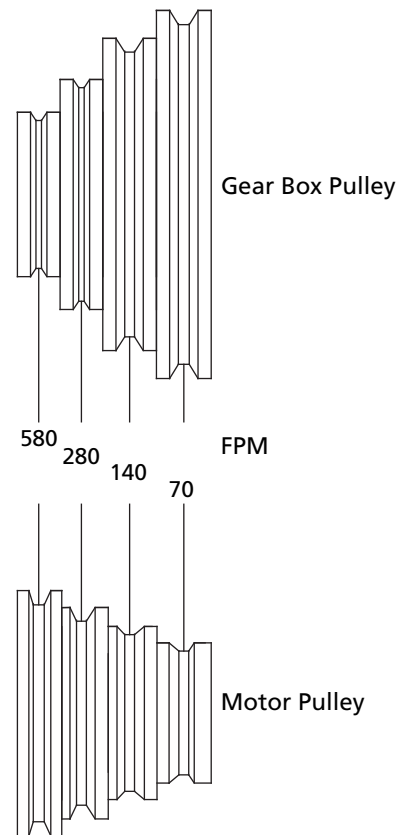


Figure 10 – Speed and Pulley Diagram



# Model 2LKU4

## Operation (Continued)

### FEED PRESSURE

Refer to Figures 11 and 13.

1. Correct feed pressure holds the blade in the cut. Feed pressure is supplied by the weight of the head. Maximum material removal rate corresponds with the proper pressure.
2. Optimum feed pressure ensures that maximum power is used for cutting. If the feed pressure is too low, the blade will not dig into the material properly. Too much feed pressure will cause the blade to dig too deeply, bogging down the motor, and possibly burning it out. In addition, blade "shocking" could result.
3. Extra energy will be used to produce powdered chips rather than smooth shavings; this will produce more heat and dull the blade (see chips in Figure 11).
4. To adjust feed pressure:
  - a. Loosen knob and then reposition counterweight (Ref. Nos. 54 and 55).
  - b. Slide weight towards front of saw to increase feed pressure. Slide weight towards rear of machine to decrease feed pressure.
  - c. Tighten knob to secure counterweight position.

**CAUTION** Do not attempt to increase feed pressure by leaning on head.

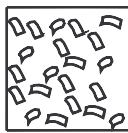
### REGULATING FEED RATE

Refer to Figures 6 and 11.

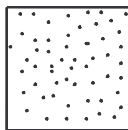
1. Feed pressure is controlled by the feed regulator. The regulator creates a force which counteracts the feed pressure. The force from the feed regulator can be adjusted to create any feed pressure up to the set maximum.



Curled shavings indicate correct feed pressure.



Thick discontinuous chips indicate too much pressure.



Powdery chips indicate too little pressure.

**Figure 11 – Determine Feed Pressure**

2. Having the correct feed pressure will produce the optimum feed rate and the fastest cut. Incorrect pressure, whether too great or too small, will put less power into the cut and reduce the feed rate.
- NOTE:** Wasted power damages the saw.
3. Determining the proper feed is largely a judgement based on experience. The feed is usually determined during the cutting operation. Before the cutting begins, the blade should be off the work and the head should be held in position by placing the feed control knob (See Figure 6) in the OFF position
  4. Once the blade is running, the head is slowly lowered onto the work by turning the feed control knob to the on position, and adjusting the feed regulator knob to the desired feed rate.
  5. After the blade begins the cut, optimum feed rate should be determined.
  6. To determine if the feed is incorrect, examine the chips produced. When the blade is operating at the ideal feed for the speed, the chips will be curled and continuous. If the chips

are thick and not continuous, the feed pressure should be reduced. If the chips are powdery, the feed pressure needs to be increased (Refer to Figure 11).

### CORRECT PIECE POSITIONING

Refer to Figure 12, page 10.

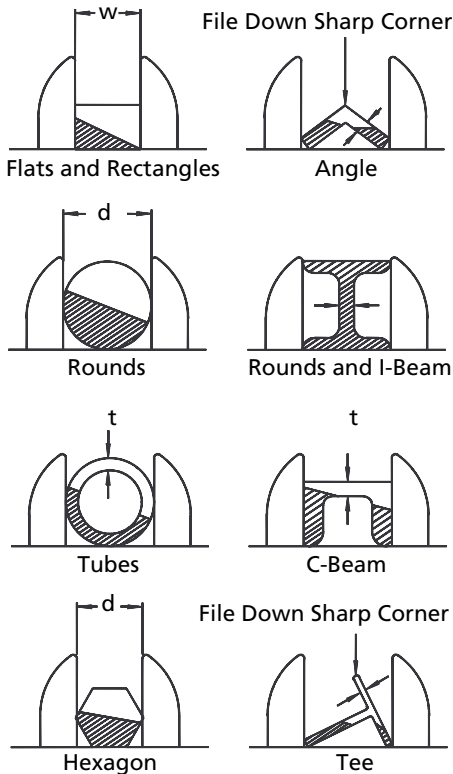
The vise is designed to keep the workpiece steady while it is being cut. The vise should only have to counteract the cutting forces. Using the proper position will help produce a safe and accurate cut. These general rules about positioning apply to most situations:

1. The workpiece should rest flat on the workbed without the need for side support. Some suggested configurations are shown in Figure 12.
2. The entire length of the work should be supported. Do not balance the workpiece on the workbed. Use support stands to prevent the work from falling off after the cut.
3. Avoid positions which will cause the blade to encounter sharp edges. If sharp corners cannot be avoided, file down the point that the blade will contact.
4. Do not allow the blade to rest on the workpiece while the motor is shut off.
5. Flats and rectangles have thickness averages of **w** (See Figure 12).
6. Rounds and many sided regular cross-sections have thickness average of **0.75d**.
7. Tubes and structurals have thickness average of **2.5t**.

**NOTE:** See Blade Selection for more information on thickness average calculation.

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## Operation (Continued)



**Figure 12 – Clamping Configurations and Thickness Average Calculation**

## CONTOUR CUTTING

Refer to Figure 13.

To perform contour cutting, the saw head must be locked in the forward position.

1. Remove the feed stop assembly (Ref. Nos. 55, 73 and 74).
2. Lift feed release lever (Ref. No. 39) and allow saw head to move completely forward.
3. Replace the feed stop assembly behind the bolt on the saw head.
4. Slide the feed stop snug against the bolt and secure it in position.

5. When contour cutting, both hands must be used to keep workpiece flat against table and guided along path.
6. Avoid placing hands in line of blade. If hands contact blade it may cause injury.
7. Stand in front of saw and use both hands over portion of table to right of blade and before cutting area. Do not attempt to cut sharp corners.
8. Cut small corners by sawing around them and removing scrap until shape is produced.

## WISE ADJUSTMENT

Refer to Figure 13.

1. Turn handle (Ref. No. 4) clockwise to tighten C-clamp over workpiece.
2. Miter jaw (Ref. No. 17) can be adjusted to any angle between 45° and 90° to blade.
3. Miter jaw has stop pins (Ref. No. 8) to secure jaw at 90°. To set the jaw at any other angle, turn lock nuts clockwise to remove pins.
4. Loosen bolt (Ref. No. 9), set jaw at desired angle, and then tighten bolt.
5. To remove jaw, remove stop pin assemblies and bolts (Ref. Nos. 8-11). Remove jaw and clamp. Use pliers to remove pivot (Ref. No. 16).

## CHECK THE BLADE PATH

Before the saw is plugged in, check to see that blade path is clear and that:

1. All blade guards are in place.
2. There is no debris inside the blade guard or covers.
3. There is no debris on the blade or blade wheels.
4. All hoses and line cords are out of the blade path.

**⚠ WARNING** Do not operate saw unless all guards are in place and the workpiece is the only object that will encounter the blade teeth.

## OPERATING THE SAW

Refer to Figure 16.

1. Select speed and blade type appropriate for the material to be cut.
2. Make sure blade tension is properly adjusted.
3. Adjust feed stop.
4. Place workpiece in vise jaws. Adjust workpiece to the desired length of cut and tighten vise hand wheel.
5. Make sure guide post is positioned so that the bottom of upper blade glides are 1/4" above workpiece when saw frame is at its lowest point. Loosen knob (Fig. 16, Ref. No. 27), position post and secure in position.
6. Turn feed control off.
7. Push saw frame release lever down to move saw head to rear of machine.
8. Turn feed rate knob to "O".
9. Turn motor ON.
10. Open feed control knob and adjust feed rate knob until saw is lowered at the desired rate of feed.
11. Cut through workpiece.

## HELPFUL CUTTING HINTS

1. Never use a new blade to complete a previous started cut.
2. When possible, do not start a cut on sharp corners.
3. After installing new blade, check tension after a few cuts.

## Model 2LKU4

### Operation (Continued)

4. For correct blade tension, snap your finger against the blade. A slight "ring" will sound if blade tension is correct.
5. The harder the material the slower the cutting speed.
6. Most blade manufacturers have developed charts and specifications to determine the best blade for cutting various kinds and shapes of materials. Use these as a general rule. The thinner the stock, the finer the tooth pitch. Use the coarsest pitch possible consistent with the above. Also, **Remember— A minimum of three teeth must contact material at all times.**

### Maintenance

Refer to Figures 13, 14 and 15.

**⚠ WARNING** *Make certain unit is disconnected from power source before attempting to service or remove any component. If power cord is worn, cut, or damaged in any way, have it replaced immediately by a qualified electrician.*

Steps required to keep the saw in optimum operating condition have been described under Operation. The Safety Precautions should be performed before operation.

For proper maintenance:

1. Keep saw clean and dry. Sweep off spots where chips have collected and wipe off spots where coolant splashed.
2. Lubricate the unpainted surfaces with a light application of medium consistency machine oil to prevent corrosion after cleaning.

3. Check and tighten any loose bolts.
4. Replace dull blades and blades from which teeth have been stripped. A clean saw with a sharp blade will yield the best cut.
5. Clean rubber tires on wheels of any chips daily.
6. Periodically grease the tension lead screw (Fig. 15, Ref. No. 5).
7. Periodically grease rails on which the saw head travels.
8. Periodically, grease all lever pivot points associated with saw release lever (Fig. 14, Ref. Nos. 27 and 57) and (Fig. 13, Ref. Nos. 39 and 48).
9. Periodically remove and clean chip tray (Fig. 13, Ref. No. 45).
10. The gear box should be drained and refilled yearly.

# Dayton® 9 x 14" Self-feeding Metal Cutting Band Saw

## Troubleshooting Chart

Symptom	Possible Cause(s)	Corrective Action
Blade cuts (crooked)	<ol style="list-style-type: none"> <li>1. Work not square</li> <li>2. Feed pressure too great</li> <li>3. Guide bearings not adjusted properly</li> <li>4. Inadequate blade tension</li> <li>5. Blade guides spaced out too much</li> <li>6. Dull blade</li> <li>7. Speed incorrect</li> <li>8. Blade guide assembly loose</li> <li>9. Blade guide bearing assembly loose</li> <li>10. Blade tracks too far away from wheel flanges</li> <li>11. Guide bearing worn</li> <li>12. Head needs adjustment</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust vise to be square with blade</li> <li>2. Reduce pressure by increasing spring tension</li> <li>3. Adjust guide bearings</li> <li>4. Increase blade tension a little at a time</li> <li>5. Move guides as close to work as possible</li> <li>6. Replace blade</li> <li>7. Check page 8 for recommended speeds</li> <li>8. Tighten</li> <li>9. Tighten</li> <li>10. Track blade properly according to instructions under Operation, page 6</li> <li>11. Replace</li> <li>12. Check that guide bearings and brackets have been correctly adjusted. To adjust head, place a square on table at blade. Use the provided open end wrenches to reposition head roller eccentric shafts (Fig. 14, Ref. Nos. 24 and 34).</li> </ol>
Bad cuts (rough)	<ol style="list-style-type: none"> <li>1. Too much speed or feed</li> <li>2. Blade has too few teeth per inch</li> <li>3. Loose or damaged blade</li> <li>4. Metal buildup on wheels</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce speed or feed</li> <li>2. Replace with finer tooth blade</li> <li>3. Tighten or replace blade</li> <li>4. Clean all metal chips from rubber tires on wheels</li> </ol>
Blade is twisting Unusual wear on side or back of blade	<ol style="list-style-type: none"> <li>1. Cut is binding blade</li> <li>2. Blade guides worn</li> <li>3. Blade guide bearings not adjusted properly</li> <li>4. Blade guide bearings not adjusted properly</li> <li>5. Feed pressure too great</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease feed pressure</li> <li>2. Replace</li> <li>3. Adjust guide bearings (see page 7)</li> <li>4. Tighten bearings</li> <li>5. Reduce feed pressure</li> </ol>
Motor will not start	<ol style="list-style-type: none"> <li>1. No electrical power to motor</li> <li>2. Low voltage</li> <li>3. Defective On/Off switch; defective line cord</li> <li>4. Open circuit in motor or loose connections</li> <li>5. Motor protector open (only if your motor is equipped with an overload protector)</li> <li>6. Burned out motor</li> </ol>	<ol style="list-style-type: none"> <li>1. Check electrical wiring to motor for continuity</li> <li>2. Check power line for proper voltage</li> <li>3. Replace defective parts before using band saw again</li> <li>4. Inspect lead terminals on motor for loose or open connections</li> <li>5. Reset protector after motor has cooled</li> <li>6. Any attempt to repair this motor may create a hazard unless repair is done by an authorized qualified technician. Replacement motors are available</li> </ol>

# Model 2LKU4

## Troubleshooting Chart (Continued)

Symptom	Possible Cause(s)	Corrective Action
Motor will not start; fuses or circuit breakers blow	<ol style="list-style-type: none"> <li>1. Short circuit in line cord or plug</li> <li>2. Short circuit in motor or loose connection</li> <li>3. Incorrect fuses or circuit breakers in power line</li> <li>4. Motor overloaded</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect line cord or plug for damaged insulation and shorted wires</li> <li>2. Inspect all lead terminals on motor for loose or worn insulation on wires</li> <li>3. Install correct fuses or circuit breakers</li> <li>4. Reduce load on motor</li> </ol>
Motor fails to develop full power (power output of motor decreases rapidly) with decreased voltage at motor terminals	<ol style="list-style-type: none"> <li>1. Power line overloaded</li> <li>2. Undersized wires or cords too long</li> <li>3. General overloading of power company's facilities</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce the load on the power line</li> <li>2. Increase wire sizes or reduce length of cords</li> <li>3. Request a voltage check from the power company</li> </ol>
Motor overheats	<ol style="list-style-type: none"> <li>1. Motor overloaded</li> <li>2. Air circulation around motor restricted</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor</li> <li>2. Clean motor to provide normal air circulation around motor</li> </ol>
Motor stalls (resulting in blown fuses or tripped circuit breakers)	<ol style="list-style-type: none"> <li>1. Short circuit in motor; connections loose; or shorted terminals or worn insulation on lead wires</li> <li>2. Low voltage</li> <li>3. Incorrect fuses or circuit breakers</li> <li>4. Motor overloaded</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect terminals in motor for damaged insulation and shorted wires</li> <li>2. Correct the low line voltage conditions</li> <li>3. Install correct fuses or circuit breakers</li> <li>4. Reduce load on motor</li> </ol>
Frequent opening of fuses or circuit breakers	<ol style="list-style-type: none"> <li>1. Motor overloaded</li> <li>2. Incorrect fuses or circuit breakers</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor</li> <li>2. Install correct fuses or circuit breakers</li> </ol>
Motor problems in general	Various causes	To troubleshoot and service motor consult qualified technician
Teeth ripping from blade	<ol style="list-style-type: none"> <li>1. Teeth too coarse for work</li> <li>2. Too heavy feed</li> <li>3. Too slow speed</li> <li>4. Vibrating workpiece</li> <li>5. Gullets loaded</li> </ol>	<ol style="list-style-type: none"> <li>1. Use finer tooth blade</li> <li>2. Decrease feed pressure</li> <li>3. Increase speed</li> <li>4. Clamp work securely</li> <li>5. Use coarse tooth blade or use brush to remove chips</li> </ol>
Motor running too hot	<ol style="list-style-type: none"> <li>1. Blade tension too high</li> <li>2. Blade too coarse for work (pipes especially)</li> <li>3. Blade too fine for work (heavier, soft material)</li> <li>4. Gears need lubrication</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce tension on blade</li> <li>2. Use finer tooth blade</li> <li>3. Use coarser blade</li> <li>4. Check oil bath</li> </ol>

# Dayton® 9 x 14" Self-feeding Metal Cutting Band Saw

## Troubleshooting Chart (Continued)

Symptom	Possible Cause(s)	Corrective Action
Excessive blade breakage	1. Material loose in vise	1. Clamp work securely
	2. Incorrect speed or feed	2. Check Machinist Handbook
	3. Teeth too coarse for material	3. Check Machinist Handbook for recommended blade type
	4. Incorrect blade tension	4. Adjust to where blade does not slip on wheel
	5. Teeth in contact with work before saw is started	5. Place blade in contact with work after motor is started
	6. Blade rubs on wheel flange	6. Adjust tracking
	7. Misaligned guides	7. Adjust guide bearings
	8. Blade too thick for wheel diameter	8. Use thinner blade
Premature blade dulling	1. Teeth too coarse	1. Use finer tooth blade
	2. Too much speed	2. Try next lower speed
	3. Inadequate feed pressure	3. Decrease spring pressure
	4. Hard spots or scale in/on material	4. Reduce speed, increase feed of saw
	5. Work hardening of material (especially stainless steel)	5. Increase feed pressure by reducing spring tension
	6. Blade installed backwards	6. Remove blade, twist inside out and reinstall blade
	7. Insufficient blade tension	7. Increase tension to proper level

# Service Record

## Dayton® 9 x 14" Self-feeding Metal Cutting Band Saw

Date	Maintenance performed	Repair components required

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# For Repair Parts, call 1-800-323-0620

24 hours a day – 365 days a year

Please provide following information:

- Model number
- Serial number (if any)
- Part description and number as shown in parts list

ENGLISH

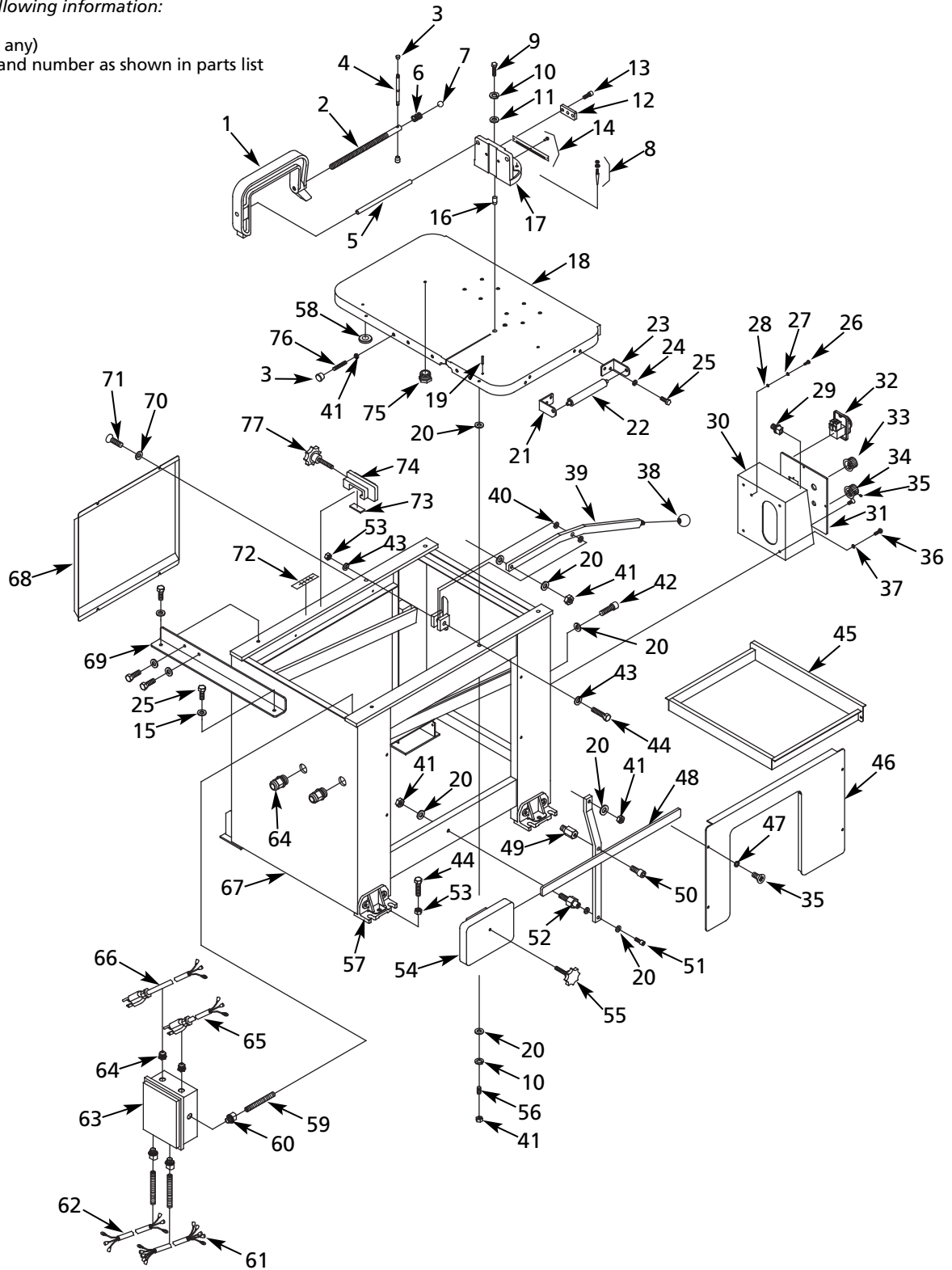


Figure 13 – Repair Parts Illustration for Base



## Repair Parts List for Base

Ref. No.	Description	Part No.	Qty.	Ref. No.	Description	Part No.	Qty.
1	C-clamp	29176.00	1	40	1/2" Flat washer (W)	*	2
2	Lead screw	29177.00	1	41	3/8"-16 Hex nut	*	10
3	Knob	29178.00	3	42	3/8-16 x 3/4" Socket head bolt	*	1
4	Handle	29179.00	1	43	1/2" Flat washer (N)	*	1
5	Clamp rod	29180.00	1	44	1/2-12 X 2 1/2" Hex head bolt	*	5
6	Spring	29181.00	1	45	Chip pan	29201.00	4
7	1/4" Ball bearing	03666.00	1	46	Left panel	29202.00	1
8	Stop pin assembly	29182.00	2	47	1/4" Lock washer	*	1
9	3/8-16 x 1 3/4" Hex head bolt	*	1	48	Counterweight lever	29203.00	1
10	3/8" Lock washer	*	9	49	Pivot	29204.00	1
11	Washer	29183.00	1	50	5/16-18 x 3/4" Socket head bolt	*	1
12	Bracket	29184.00	1	51	1/4-20 x 5/8" Socket head bolt	*	1
13	5/16-18 x 1" Socket head bolt	*	2	52	Pivot	29205.00	1
14	Angle scale with rivets	29185.00	1	53	1/2"-12 Hex nut	*	6
15	5/16" Flat washer	*	4	54	Counterweight	29206.00	1
16	Pivot	29186.00	1	55	Knob	29207.00	1
17	Miter jaw	29187.00	1	56	3/8-16 x 2" Set screw	*	4
18	Table	29188.00	1	57	Floor bracket	29209.00	1
19	5 x 45mm Spring pin	15602.00	1	58	Spacer	29225.00	1
20	3/8" Flat washer	*	11	59	Wire cover	29210.00	3
21	Bracket, LH	29189.00	1	60	Strain relief	30017.00	3
22	Roller assembly	29190.00	1	61	Control cord	29211.00	1
23	Bracket, RH	29191.00	1	62	Motor cord	29212.00	1
24	5/16" Lock washer	*	4	63	Junction box	29213.00	1
25	5/16-18 x 3/4" Hex head bolt	*	6	64	Strain relief	29214.00	2
26	5-0.8 x 5mm Pan head screw	*	2	65	Line cord	29215.00	3
27	5mm Serrated washer	*	4	66	Lamp cord	29216.00	1
28	5mm Flat washer	*	6	67	Base	†	1
29	Strain relief	29192.00	4	68	Right panel	29218.00	4
30	Control box	29193.00	1	69	Shipping bracket	29219.00	2
31	Control box cover	29194.00	1	70	1/4" Flat washer (N)	*	1
32	On/off switch	29195.00	1	71	1/4-20 x 5/8" Flat head screw	*	4
33	Feed regulator knob	15573.00	2	72	Stop scale	29220.00	1
34	5-0.8 x 6mm Set screw	*	2	73	Lens	29221.00	1
35	1/4-20 x 1/2" Flat head screw	*	2	74	Feed stop	29222.00	1
36	#10-24 x 1/2" Pan head screw	*	2	75	Bushing	29223.00	4
37	6mm Flat washer (N)	*	4	76	Bolt	29224.00	1
38	Knob	29198.00	1	77	Knob	30292.00	1
39	Feed release lever	29199.00	1				

(\*) Standard hardware item, available locally.

(†) Not available as repair part.

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24 hours a day – 365 days a year

Please provide following information:

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- Serial number (if any)
- Part description and number as shown in parts list

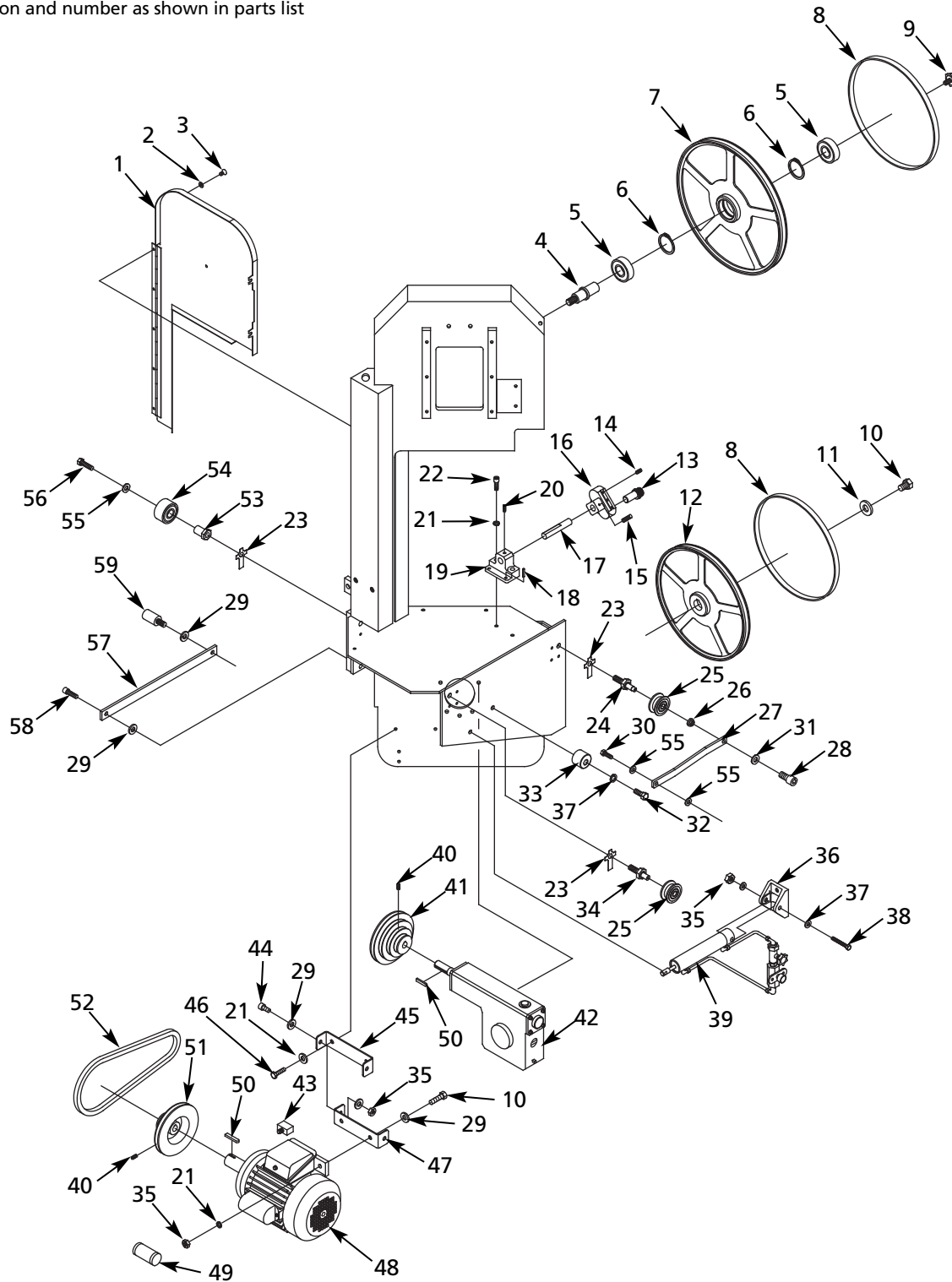


Figure 14 – Repair Parts Illustration for Drive

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# Repair Parts List for Drive

Ref. No.	Description	Part No.	Qty.	Ref. No.	Description	Part No.	Qty.
1	Wheel cover	29227.00	1	34	Eccentric Bolt	29244.00	1
2	1/4" Flat washer (N)	*	6	35	3/8"-16 Hex nut	*	8
3	1/4-20 x 3/8" Flat head screw	*	5	36	Cylinder bracket	29245.00	1
4	Idler wheel shaft	29228.00	1	37	10mm Flat washer	*	2
5	6205ZZ Ball bearing	1L018	2	38	3/8-16 x 2 1/2" Hex head bolt	*	1
6	3AMI-52 Retaining ring	29229.00	2	39	Cylinder assembly	29246.00	1
7	Idler Wheel	29230.00	1	40	6-1.0 x 10mm Set screw	*	6
8	Rubber tread	29231.00	2	41	Gearbox pulley	29247.00	1
9	Bolt	29232.00	1	42	Gear box assembly	29196.00	1
10	3/8-16 x 1" Hex head bolt	*	3	43	Circuit breaker	16611.00	1
11	10mm Flat washer (W)	*	1	44	3/8-16 x 1" Socket head bolt	*	2
12	Drive wheel	29234.00	1	45	Motor mount	29250.00	1
13	Blade guide assembly	29282.00	2	46	3/8-16 x 3/4" Hex head bolt	*	2
14	#5-40 X 3/8" Set screw	*	2	47	Motor mount	29252.00	1
15	5/16-18 x 1/2" Set screw	*	2	48	Motor (includes Ref. Nos. 43 & 49)	29253.00	1
16	Guide bracket	29279.00	1	49	Capacitor	29254.00	1
17	Guide rod	29235.00	1	50	5 x 5 x 40mm Key	07885.00	2
18	5 x 20mm Spring pin	05634.00	2	51	Motor pulley	29255.00	1
19	Lower blade guide bracket	29236.00	1	52	V-Belt	29197.00	1
20	5/16-18 x 3/8" Set screw	*	1	53	Roller shaft	29256.00	1
21	3/8" Lock washer	*	6	54	Smooth head roller assembly	29257.00	1
22	3/8-16 x 1 3/4" Socket head bolt	*	2	55	1/2" Flat washer (W)	*	3
23	Washer	29237.00	3	56	1/2-12 X 2 1/2" Hex head bolt	*	1
24	Eccentric bolt	29238.00	1	57	Handle lever	29258.00	1
25	Flanged head roller assembly	29239.00	2	58	3/8-16 x 1 1/4" Socket head bolt	*	1
26	Spacer	29240.00	1	59	Lever bolt	29259.00	1
27	Counterweight lever	29241.00	1	<b>Recommended Accessories</b>			
28	1/4-20 x 1/2" Socket head bolt	*	1	Δ	Material support stand	6Z765	1
29	3/8" Flat washer	*	13	Δ	1 Gallon industrial gear oil	6Y785	1
30	1/2-12 X 1 3/4" Hex head bolt	*	1	Δ	Blade, 1/2 x 120", 14TPI	4WE43	1
31	1/4" Lock washer	*	1	Δ	Blade, 3/4 x 120", 10TPI	4VV98	1
32	3/8-16 x 1 1/2" Hex head bolt	*	1	Δ	Blade, 3/4 x 120", 5/8TPI	4WA45	1
33	Eccentric bushing	29243.00	1				

(\*) Standard hardware item, available locally.

(Δ) Not shown.

# For Repair Parts, call 1-800-323-0620

24 hours a day – 365 days a year

Please provide following information:

- Model number
- Serial number (if any)
- Part description and number as shown in parts list

ENGLISH

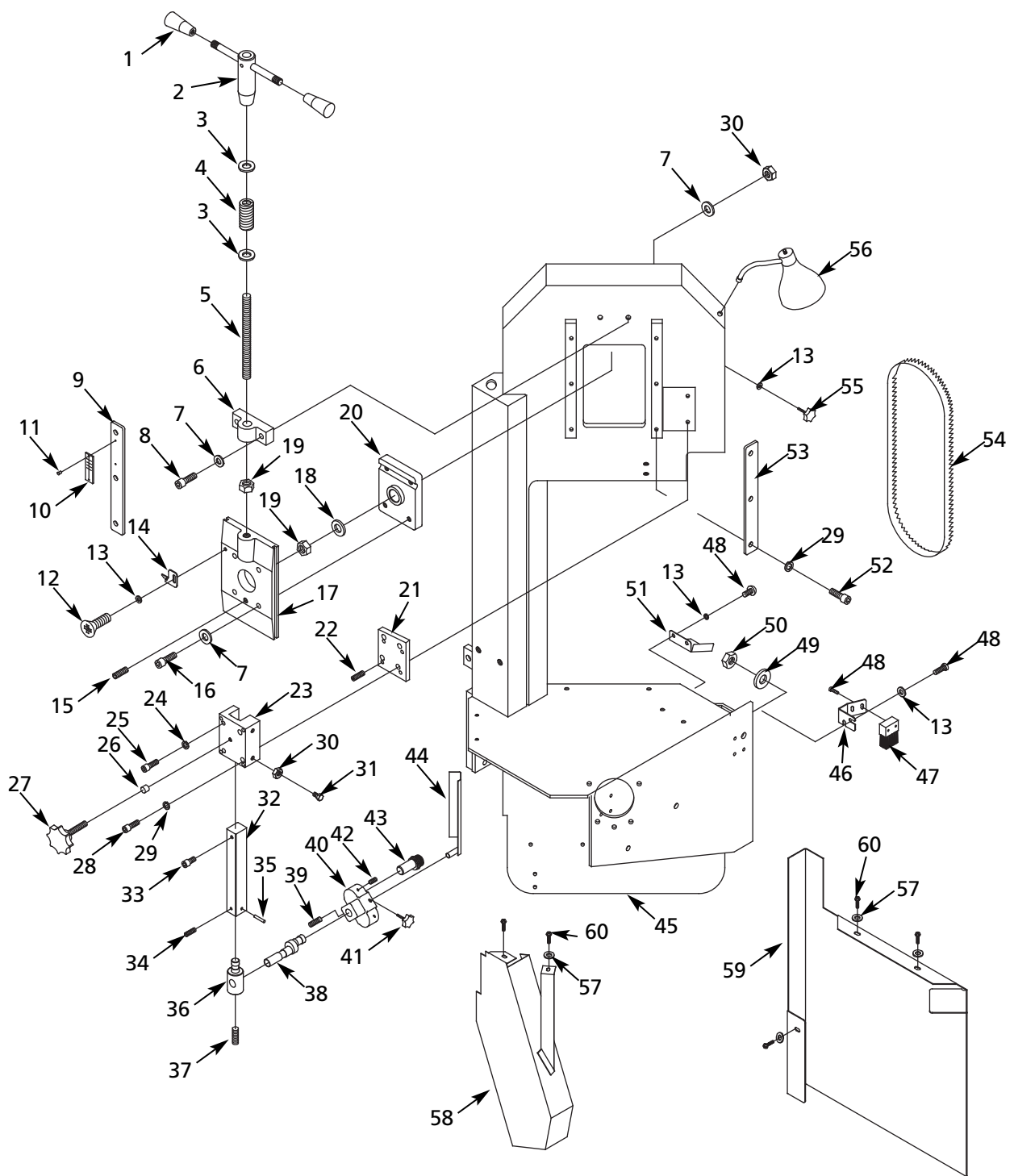


Figure 15 – Repair Parts Illustration for Head

## Repair Parts List for Head

Ref. No.	Description	Part No.	Qty.	Ref. No.	Description	Part No.	Qty.
1	Knob	29260.00	2	33	1/4-20 x 3/8" Socket head bolt	*	1
2	Handle	29261.00	1	34	1/4-20 x 5/8" Set screw	*	1
3	5/8" Flat washer	*	2	35	5 x 25mm Spring pin	04565.00	1
4	Spring	29262.00	1	36	Guide post end	28277.00	1
5	Lead screw	29263.00	1	37	5/16-18 x 3/8" Set screw	*	1
6	Bracket	29264.00	1	38	Eccentric shaft	29278.00	1
7	3/8" Flat washer	*	8	39	5/16-18 x 1/2" Set screw	*	2
8	3/8-16 x 1 1/2" Socket head bolt	*	2	40	Guide bracket	29279.00	1
9	Gib (left)	29265.00	1	41	Knob	29280.00	1
10	Tension scale	29266.00	1	42	#5-40 X 3/8" Set screw	*	1
11	2 x 5mm Rivet	02746.00	2	43	Blade guide assembly	29282.00	2
12	1/4-20 x 5/8" Flat head screw	*	1	44	Blade guard	29283.00	1
13	1/4" Flat washer (N)	*	7	45	Head	†	1
14	Indicator	29267.00	1	46	Brush Holder	29285.00	1
15	3/8-16 x 3/4" Set screw	*	1	47	Brush	29286.00	1
16	3/8-16 x 1 3/4" Socket head bolt	*	4	48	1/4-20 x 1/2" Pan head screw	*	6
17	Slide	29268.00	1	49	1/2" Flat washer (W)	*	2
18	Spacer	29269.00	1	50	1/2"-12 Hex nut	*	2
19	5/8"-11 Hex nut	*	2	51	Chip scraper	29287.00	1
20	Shaft plate	29270.00	1	52	3/8-16 x 3/4" Socket head bolt	*	6
21	Clamp plate	29271.00	1	53	Gib (right)	29288.00	1
22	6-1.0 x 10mm Set screw	*	6	54	Blade	29289.00	1
23	Guide post bracket	29272.00	1	55	Knob	29290.00	2
24	5/16" Lock washer	*	2	56	Lamp assembly	29291.00	1
25	5/16-18 x 2 1/4" Socket head bolt	*	2	57	5mm Flat washer	*	5
26	Pin	29273.00	2	58	Belt guard	29918.00	1
27	Knob	29274.00	1	59	Lower wheel guard	29919.00	1
28	3/8-16 x 2 1/4" Socket head bolt	*	2	60	5-0.8 x 10mm Pan head screw	*	5
29	3/8" Lock washer	*	8	Δ	Hex Wrench set	29292.00	1
30	3/8"-16 Hex nut	*	4	Δ	Open end wrench set	29293.00	1
31	3/8-16 x 1 1/4" Hex head bolt	*	2	Δ	Lamp (115V, 60W)	*	1
32	Guide post	29276.00	1				

(\*) Standard hardware item, available locally.

(†) Not available as repair part.

(Δ) Not shown.





# Dayton® 9 x 14" Self-feeding Metal Cutting Band Saw

## LIMITED WARRANTY

**DAYTON ONE-YEAR LIMITED WARRANTY.** DAYTON® 9 X 14" SELF-FEEDING METAL CUTTING BAND SAW, MODELS COVERED IN THIS MANUAL, ARE WARRANTED BY DAYTON ELECTRIC MFG. CO. (DAYTON) TO THE ORIGINAL USER AGAINST DEFECTS IN WORKMANSHIP OR MATERIALS UNDER NORMAL USE FOR ONE YEAR AFTER DATE OF PURCHASE. ANY PART WHICH IS DETERMINED TO BE DEFECTIVE IN MATERIAL OR WORKMANSHIP AND RETURNED TO AN AUTHORIZED SERVICE LOCATION, AS DAYTON DESIGNATES, SHIPPING COSTS PREPAID, WILL BE, AS THE EXCLUSIVE REMEDY, REPAIRED OR REPLACED AT DAYTON'S OPTION. FOR LIMITED WARRANTY CLAIM PROCEDURES, SEE "PROMPT DISPOSITION" BELOW. THIS LIMITED WARRANTY GIVES PURCHASERS SPECIFIC LEGAL RIGHTS WHICH VARY FROM JURISDICTION TO JURISDICTION.

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