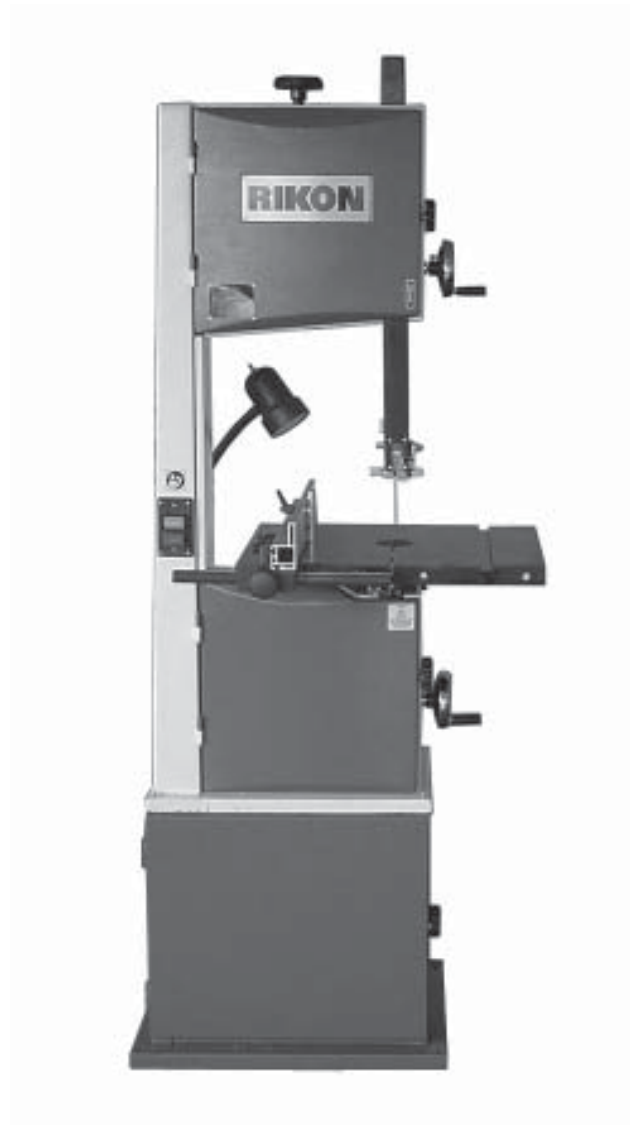


14" Deluxe Woodworking Bandsaw

Model: 10-325

RIKON POWER TOOLS



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

Serial number: _____

Date of purchase: _____

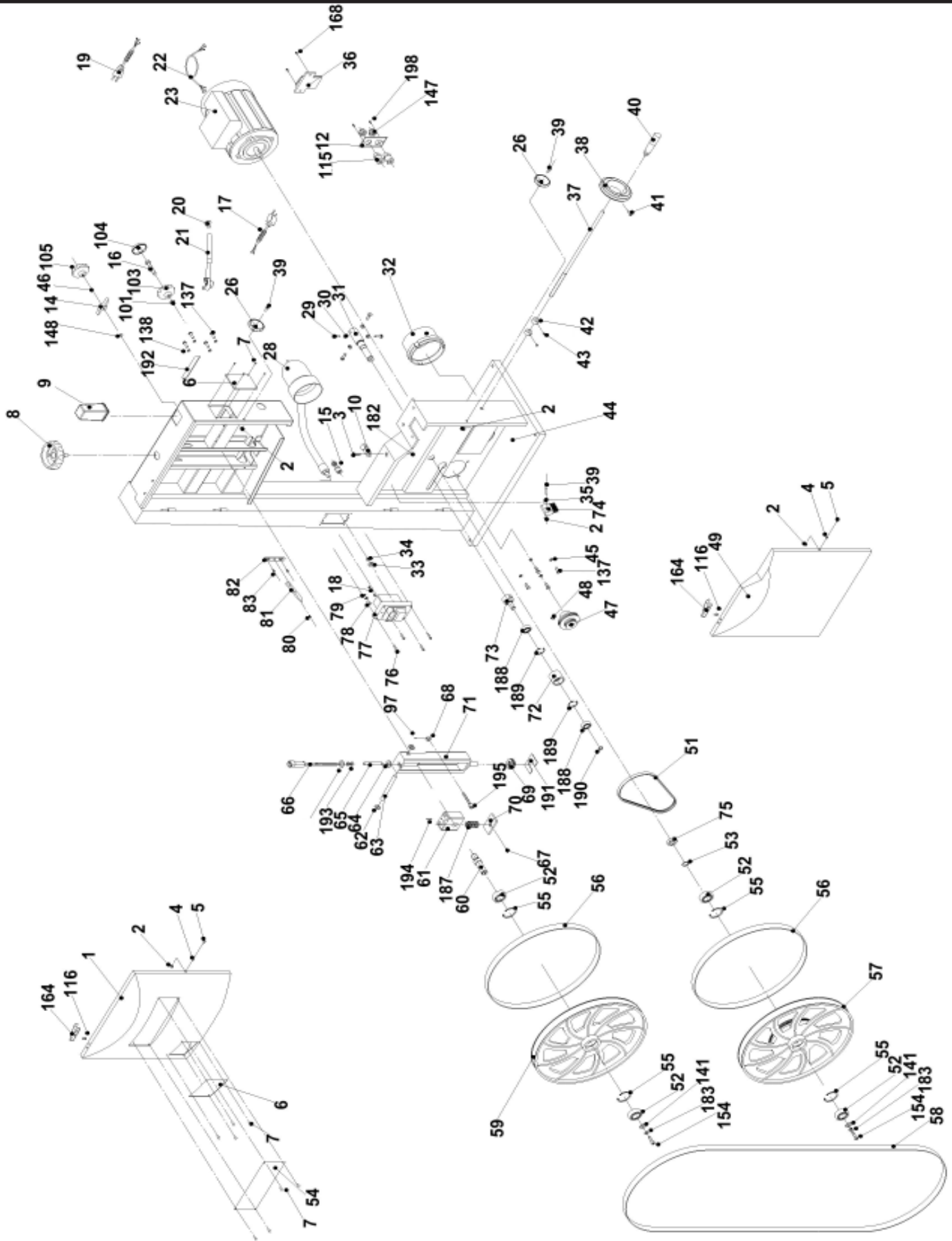
For more information:

www.rikontools.com or info@rikontools.com

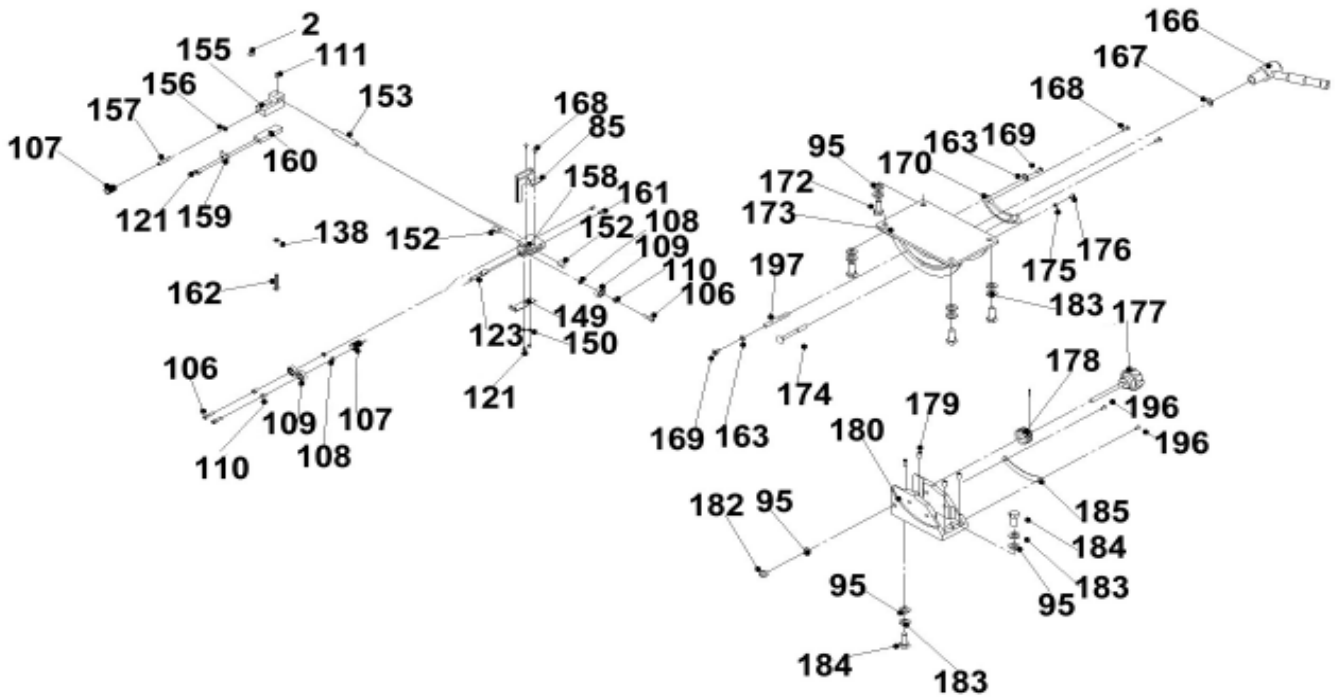
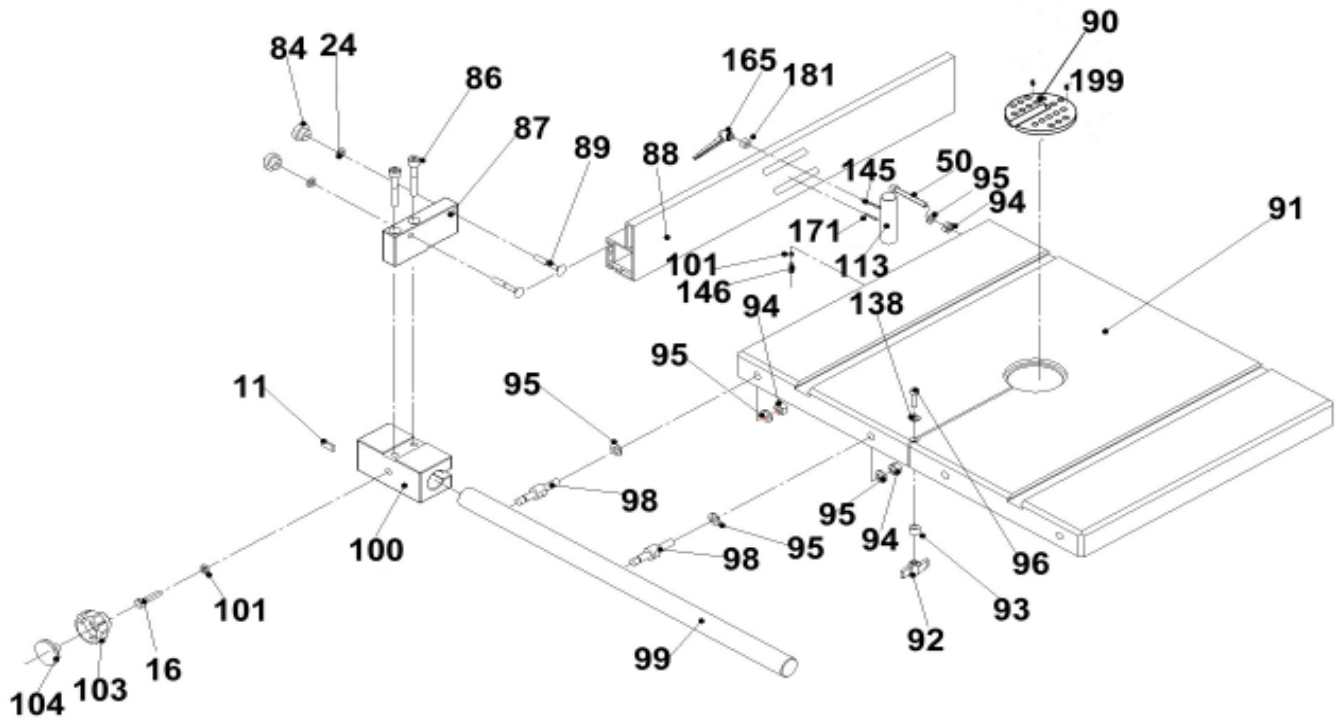
For Parts or Questions:

techsupport@rikontools.com or 877-884-5167

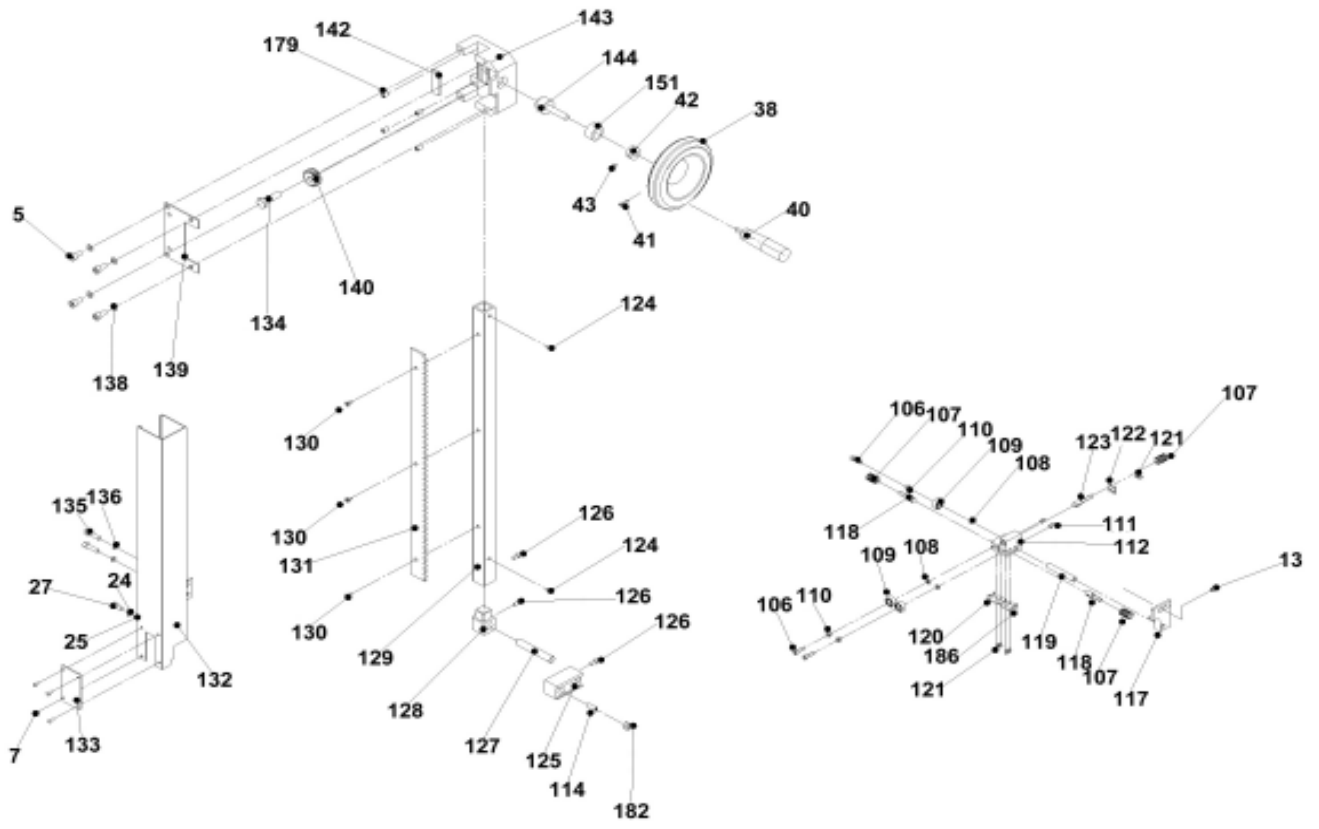
Parts Diagram



Parts Diagram Cont.



Parts Diagram Cont.



Parts List

Key No.	Part No.	Description	Key No.	Part No.	Description
1	1-JL28010001B-049W	Upper wheel cover	51	1-JL20020002	Multi-vee belt
2	1-M6GB889Z	Nylon nut M6-1.0	52	1-BRG180203GB278	Bearing 80203
3	1-JL26010015	Quick stopper	53	1-CLP17GB894D1B	Retaining ring 17
4	1-JL26010007	Bushing	54	1-RK28081001	Logo label
5	1-M6X16GB70Z	Hex socket screw M6x16	55	1-CLP40GB893D1B	Retaining ring 40
6	1-JL26010001	Clear window	56	1-JL21022002A-008S	Tire
7	1-RVT3X7GB12618A	Rivet	57	1-JL21023002B-001G	Lower bandwheel
8	1-JL21025001A001S	Blade tension handwheel	58	1-JL28020001B-001G	Blade
9	1-JL28010003-001S	Guide post cap	59	1-JL21022001B-001G	Upper bandwheel
11	1-JL28060010	Lock shoe	60	1-JL28030004	Upper wheel shaft
12	1-JL26010011-050W	Strain relief plate	61	1-JL27030009	Upper wheel shaft hinge
13	1-M8X10GB80	Set screw M8x10	62	1-JL20021004	Retaining
14	1-JL20010016A-001S	Wing nut	63	1-JL20021002	Upper shaft
15	1-JL21072101	Strain relief	64	1-WSH12GB97D1Z	Washer
16	1-M8X30GB5781Z	Hex. Bolt M8x30	65	1-JL28030001	Tube
17	1-U22182000	Plug	66	1-JL28032000A	Blade tensioner
18	1-WSH4GB97D1Z	Washer	67	1-PIN2X16GB879D2B	Pin roll 2x16
20	1-1904011	Quick release rod	68	1-JL28030006	Tube
21	1-JL28033000	Quick release handle	69	1-BRG51104GB301	Thrust bearing
22	2-U13141200-737	Motor cable	70	1-JL28034000	Block
23	1-H8036604	Motor	71	1-JL28031000	Slide bracket
24	1-WSH6GB96Z	Washer	72	1-JL20014002A	Tension wheel
25	1-M6X15GB/T17880D3Z	Special nut M6x15	73	1-JL20014001	Sliding shaft
26	1-JL26010006-001S	Star knob	74	1-JL26010003	Brush
27	1-M6X12GB70Z	Hex. Socket screw M6x12	75	1-JL20020004	Special Hex, nut
28	1-L350	Light	76	1-M4X20GB818Z	Pan head screw M4x20
29	1-M6X20GB5783Z	Hex. Bolt M6x20	77	1-HY56	Switch
30	1-M6GB6170Z	Hex. Nut M6	78	1-M4X8GB818Z	Pan head screw M4x8
31	1-JL28020002A	Lower bandwheel shaft	79	1-WSH4GB862D2Z	Lock washer
32	1-JL20010007-001S	Dust port 4"	80	1-JL26010010	Special screw
33	1-M16X1.5GB6173Z	Hex. Nut M16x1.5	81	1-JL27010004-002A	Blade tension indicator
34	1-WSH10GB861D1B	Lock washer	82	1-JL27010005	Indicator adjustment plate
35	1-WSH6GB95Z	Washer	84	1-JL20061003-001S	Knob
36	1-JL26090001	Tool holder	85	1-JL20043006A	Lower blade guard
37	1-JL28020003A	Crank	86	1-M8X45GB70Z	Hex. Socket screw M8x45
38	1-JL26020012A-001G	Crank handwheel	87	1-JL28060004	Fence bracket
39	1-M6X25GB5783Z	Carriage bolt M6x25	88	1-JL28060002A	Fence
40	1-JL26020014-001S	Handwheel handle	89	1-M6X35GB12Z	Carriage bolt M6x35
41	1-M6X20GB70Z	Hex. Socket screw M6x20	90	1-JL20031002-001S	Table insert
42	1-JL20010015	Set collar	91	1-JL28070007-001G	Table
43	1-M5X8GB71Z	Set screw M5x8	92	1-JL22020002-001S	Wing nut
44	1-JL28011000D-050W	Frame	93	1-JL21031003	Tube
45	1-WSH6GB93Z	Spring washer	94	1-M8GB6170Z	Hex. Nut M8
46	1-M10GB6172Z	Hex. Nut M10	95	1-WSH8GB97D1Z	Washer
47	1-JL20070001	Motor pulley	96	1-M6X50GB70Z	Hex. Socket screw M6x50
48	1-M6X8GB80B	Hex socket screw M6x8	97	1-PIN3X18GB879B	Pin roll 3x18
49	1-JL28010002-049W	Lower bandwheel cover	98	1-JL28060005	Fence bar bolt
50	1-M8X80GB70B	Hex. Socket screw M8x80	99	1-JL28060003A	Fence bar

Key No.	Part No.	Description	Key No.	Part No.	Description
100	1-JL28060009	Fence seat	150	1-WSH4GB97	Washer
101	1-M8GB6172Z	Hex. Nut M8	151	1-JL27040003	Bushing
102	1-M8X50GB5781Z	Hex. Bolt M8x50	152	1-JL22043004	Bearing mount cylinder
103	1-JL20024002-001S	Lock knob body	153	1-JL22043002	Lower guide shaft
104	1-JL20024001-001S	Lock knob cap	154	1-M8X16GB70Z	Hex screw M8x16
105	1-JL26040015A	Blade tracking handle	155	1-JL21043001C	Lower guide mount
106	1-M5X20GB70	Hex. Socket screw M5x20	156	1-M6GB6172	Hex. Nut M6
107	1-JL21042005	Micro-adjusting knob	157	1-M6X35GB77	Set screw M6x35
108	1-WSH5GB97Z	Washer	158	1-JL21043004	Lower guide body
109	1-BRG80018GB278	Bearing 80018	159	1-JL21043003	Micro-adjusting knob bracket/rear
110	1-JL20042002	Tube	160	1-JL21040001	Lower guide seat
111	1-M6x10GB80	Set screw M6x10	161	1-M5X10GB80Z	Set screw M5x10
112	1-JL21042001C	Upper guide body	162	1-M6X35GB5781	Hex. Bolt M6x35
113	1-JL28061101	Re-saw bar	163	1-WSH4GB96D1Z	Washer
114	1-M8X40GB77B	Set screw M8x40	164	1-JL22010008	Leaf spring
115	1-JL20072101	Strain relief	165	2-JL20042100	Lock handle
116	1-RVT4X8GB12618A	Rivet	166	2-JL27053000	Lock handle
117	1-JL21042002	Upper guide mount	167	1-WSH6GB97D1Z	Washer
118	1-JL21042008	Bearing mount cylinder w/thread	168	1-M5X10GB818Z	Pan head screw M5x10
119	1-JL22043002A	Upper guide shaft	169	1-M4X6GB818Z	Pan head screw M4x6
120	1-JL21042007	Micro-adjusting knob bracket/left	170	1-JL28070004	Rack
121	1-M4X5GB823	Pan head screw M4x5	171	1-JL26061003	Guide screw
122	1-JL21042004	Micro-adjusting knob bracket/rear	172	1-M8X20GB5783Z	Hex. Bolt M8x20
123	1-JL21043006	Bearing mount cylinder w/thread	173	1-JL28070002	Upper table trunnion
124	1-M5X6GB818Z	Screw M5x6	174	1-M6X65GB12Z	Carriage bolt M6x65
125	1-JL28040011	Sliding bracket	175	1-JL28070005	Pointer
126	1-M5X12GB70Z	Hex. Socket screw M5x12	176	1-M3X5GB818Z	Pan head screw M3x5
127	1-JL28040009	Adjust bar	177	1-JL26050006-001S	Table tilting knob
128	1-JL28040005	Upper guide support block	178	1-JL28070003	Gear
129	1-JL28040002A	Guide post	179	1-M6X12GB77Z	Set screw M6x12
130	1-M5X8GB819B	Screw M5x8	180	1-JL28070001-009A	Lower table trunnion
131	1-JL28040001	Rack	181	1-JL21031003	Tube
132	1-JL28041100	Hinged door	182	1-M8GB889Z	Nylon nut M8
133	1-JL28041004	Clear window	183	1-WSH8GB93Z	Spring washer
134	1-JL26040006	Fixed bolt	184	1-M8X30GB5783Z	Hex. Bolt M8x30
135	1-M5x16GB70Z	Hex. Socket screw M5x16	185	1-JL28070006	Table tilting scale
136	1-WSH5GB97D1Z	Washer	186	1-JL21042003	Micro-adjusting knob bracket/right
137	1-M6X16GB5783Z	Hex bolt M6x16	187	1-JL27030011	Spring
138	1-WSH6GB97D1Z	Washer	188	1-BRG80101GB278	Bearing 80101
139	1-JL27040002A	Guide Bracket Cover	189	1-CLP12GB894D1B	Retaining spring
140	1-1501006	Gear	190	1-CLP28GB893D1B	Retaining ring
141	1-JL28030007	Washer	191	1-JL28010004	Steel washer
142	1-JL26040007	Fixed plate	192	1-JL28010005-001S	Rubber cover
143	1-JL27040006	Guide bracket	193	1-JL28030003	Special Hex, nut
144	1-JL27040004	Worm cylinder	194	1-PIN5X35GB879D1B	Pin roll 5x35
145	1-JL26061002	Special screw	196	1-RVT2D5X5GB827C	Rivet
146	1-M8X25GB5781Z	Hex. Bolt M8x25	197	1-JL28070008	Guide shaft
147	1-JL20072102	Strain relief nut	198	1-M6X8GB818Z	Pan head screw M6x8
148	1-WSH10GB97D1Z	Washer	199	1-M5X4GB80B	Set Screw
149	1-JL21043002	Micro-adjusting knob bracket/rear			

How-To's for all Band Saw Blades

Choosing the Correct Blade Width

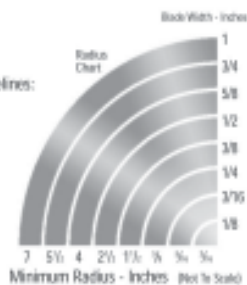
Blade width is measured from the tips of the teeth to the back edge of the blade as shown above. The instructions for the particular machine being used should be followed when selecting blade width.



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

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

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



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

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

When Selecting TPI remember:

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

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

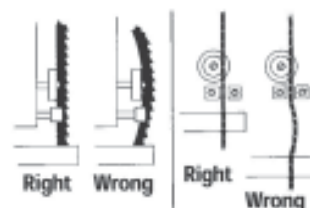
It is important to know the SFM for the various speed settings of your band saw, so that you can select the proper speed for cutting wood or other materials. Check the operator's manual of your band saw to determine the SFM or use the following procedure:

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

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

Installing your Band Saw Blade

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



Diagnosing Problems

1. Premature and Excessive Tooth Wear

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



2. Blade Vibration

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

- Increase tension of band.
- Increase feed pressure.

3. Gullets Loading

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

4. Band Stalls in Work

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

5. Premature Blade Breakage

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



6. Blade Making Belly-Shaped Cuts

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



7. Tooth Stripping

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



8. Band Develops a Negative Camber

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



9. Blade Not Running True Against Saw Guide Backup Bearing

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

10. Cutting Rate Too Slow

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

11. Blade Leading In Cut

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



12. Premature Loss of Set

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

13. Band Develops Positive Camber

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



14. Band Develops Twist

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



15. Finished Cut Surface Too Rough

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



16. Band Scoring (side wear or grooving)

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



17. Burring or Mushrooming of Blade Back Edge

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



Reprinted with permission from The Olson Saw Company, Bethel, CT © 2001

Warranty



2-Year Limited Warranty

RIKON Power Tools/Richen Enterprise, Inc. ("Seller") warrants to only the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship for a period of two (2) years from the date the product was purchased at retail. This warranty may not be transferred.

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

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

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

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

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

To take advantage of this warranty, please fill out the enclosed warranty card and send it to:
RIKON Warranty
110 Cummings Park
Woburn, MA 01801

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

Notes

Notes

RIKON **POWER TOOLS**

**For more information:
110 Cummings Park
Woburn, MA 01801**

**877-884-5167/781-933-8400
techsupport@rikontools.com
www.rikontools.com**