

REX

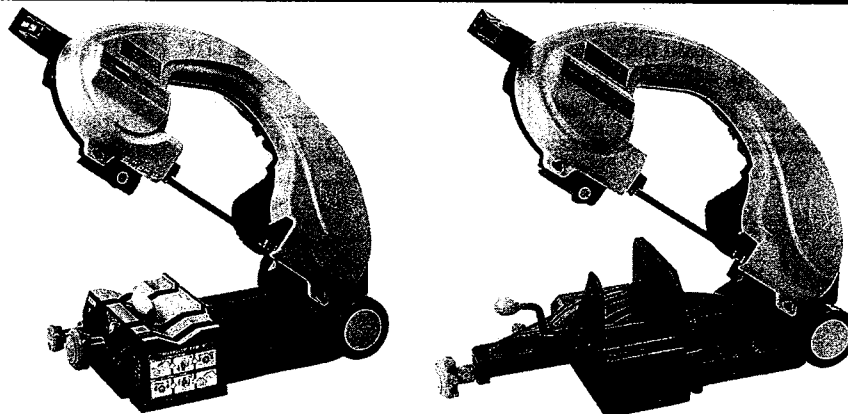
REX Band Saw

MANTIS

MANTIS

XB180/XB180A

Operator's Manual



Be sure to read this manual
before using the machine

- IMPORTANT -

- Be sure to give this Operator's Manual to the user.
- To ensure safe and effective use, read this Operator's Manual carefully before use.
- Be sure to keep the manual readily available so that the user can refer to it whenever necessary.

Date of Purchase:

Year

Month

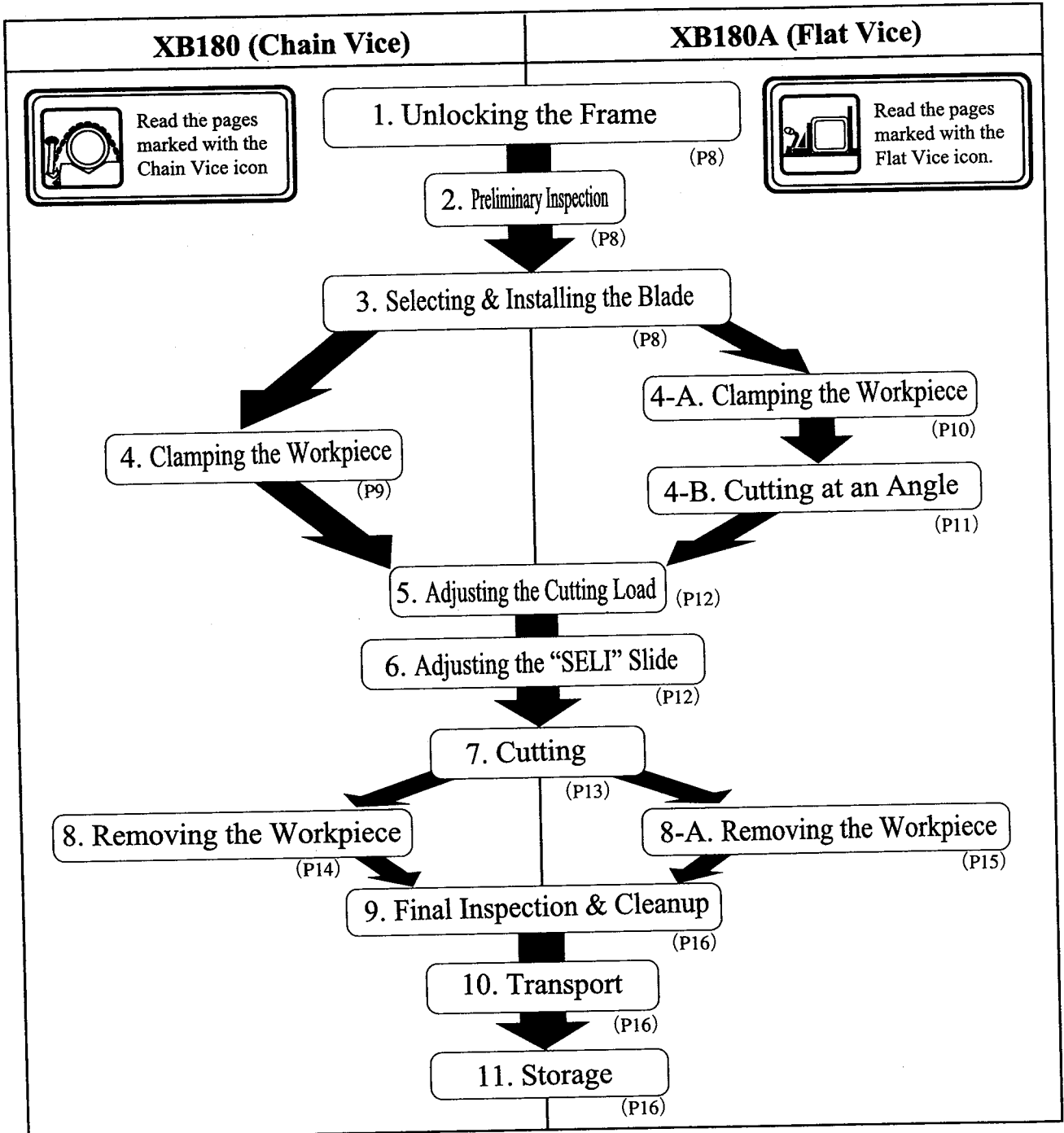
Sales agent:

REX INDUSTRIES CO., LTD.

Thank you for purchasing the REX Mantis series Band Saw.

This manual is used for both models in the Mantis series: the XB180 (Chain Vice) and the XB180A (Flat Vice).

Only the Operation section of the manual is different. This section contains different sections for two steps: step 4 and step 8. Follow steps 4 and 8 if you are using the XB180; follow steps 4a and 4b, and step 8a if you are using the XB180A. For easy reference, the pages in this section are also marked with either a Chain Vice icon or a Flat Vice icon, as shown in the figure below.



CONTENTS

1. Unlocking the Frame	8
2. Preliminary Inspection	8
3. Selecting & Installing the Blade	8
4. Clamping the Workpiece	9
4-A. Clamping the Workpiece (XB180A)	10
4-B. Cutting at an Angle (XB180A)	11
5. Adjusting the Cutting Load	12
6. Adjusting the "SELI" Slide	12
7. Cutting	13
8. Removing the Workpiece	14
8-A. Removing the Workpiece (XB180A)	15
9. Final Inspection & Cleanup	16
10. Transport	16
11. Storage	16
Changing the Blade	17
Troubleshooting	18
Periodic Inspections & Care	20
Servicing & Repair	20

Definitions of **▲ WARNING** and **▲ CAUTION**

In this operation manual, warnings are divided into **▲ WARNING** and **▲ CAUTION**.
▲ WARNING : indicates actions which could possibly result in death or severe injury to the user if the machine is used incorrectly death or heavy injuries of users, in handling the machine incorrectly.

▲ CAUTION : indicates actions which could possibly result in injury to the user, or physical damage, if the machine is used incorrectly.

Even items described as [**▲ CAUTION**], could have serious results under certain conditions.

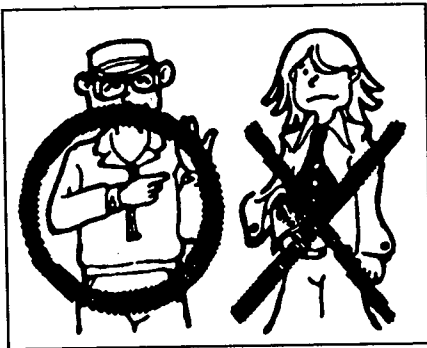
Be sure to observe these warnings carefully as they greatly affect safety.

- If this operation manual is lost or damaged, promptly order a replacement from our agent or sales agent.
 - Parts and specifications are subject to change without prior notice, due to improvements in quality, performance or safety standards. In such cases, the contents, photographs, illustrations, etc. of this manual may be different to the product you have purchased.
-

Safety Considerations

This page describes general safety precautions that must be observed when handling electrical equipment. Some of the diagrams may show products that are different from the product you have purchased.

1 Wear proper clothing.

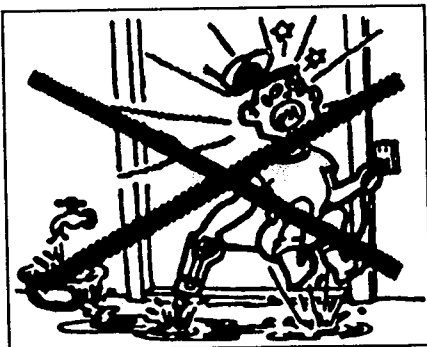


- Do not wear neckties, clothing with open sleeves, knit gloves or other types of clothing that may easily get caught in the unit's moving parts.
- Be sure to wear helmets, work boots, goggles, masks and any other items necessitated by the work environment.

2 Work in a safe place and in a stable position.

- It is dangerous to work in an unstable location or position. Always have both feet firmly on the ground and be sure to maintain proper balance while working.

3 Avoid dampness and be careful of electrical shock.

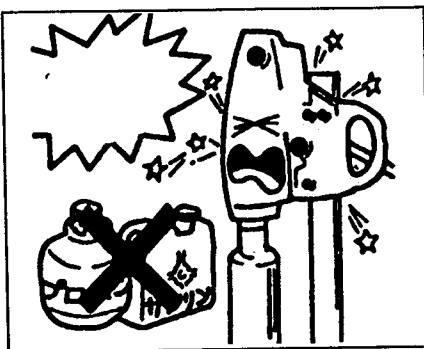


- Do not use this product in the rain or in humid or wet locations, or in any other situations in which water may get into the unit. Failure to observe this precaution may result in electrical shock. Exposure to humidity may also degrade the motor insulation.

4 Maintain safety by keeping the workplace neat and clean.

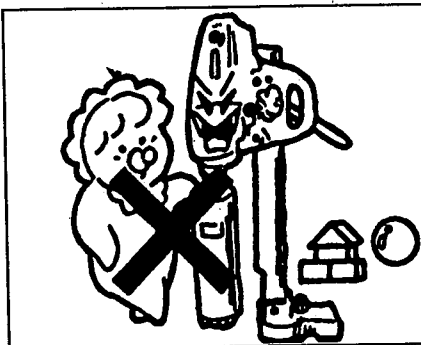
- Make every effort to keep the workbench and work area neat and clean, and make sure the area is well-lit. This will improve safety and increase productivity.

5 Check to make sure the workplace is safe.



- Electrical tools generate sparks during operation. It is **VERY DANGEROUS** to use these tools near gasoline, paint thinner, lacquer, benzene, paint, gases, adhesives, matches, paper, straw and the like. Ensure no such substances are in the work area before you start work.

6 Keep unauthorized personnel away from the work area.

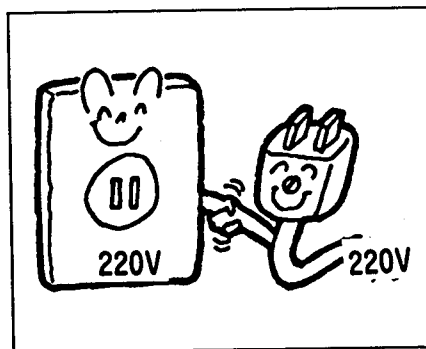


- Make sure that only authorized work personnel enter the work area. Be particularly careful of children entering the area during work operations

7 Use the tool properly.

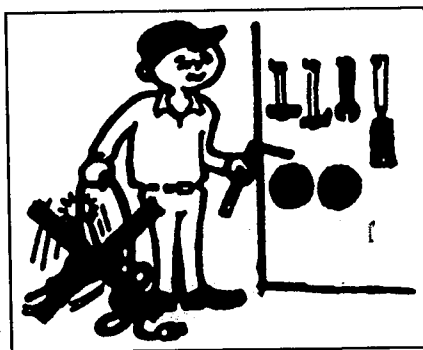
- Do not use this tool for anything other than its intended purpose. Using it for other purposes, or for jobs that exceed its capacity, may result in damage to the tool and injury to yourself or others.

8 Make sure that the voltage is correct.



- Be sure to use a power supply with the proper voltage shown on the label. Using power supplies with other voltages may damage the motor.

9 Treat the cord with respect.



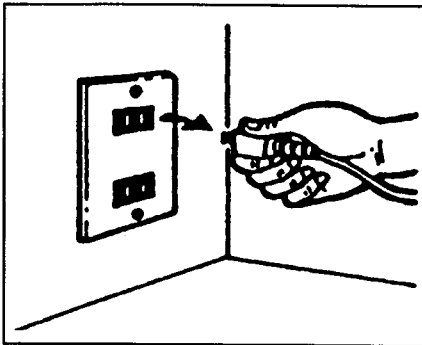
- Never carry the unit by its cord or pull on the cord to remove it from the outlet.
- Make sure the cord does not come in contact with hot items, blades, oil and grease, etc.
- Inspect the power cord and plug before use.

Safety Considerations

10 Check to make sure the ON/OFF button is in the OFF position before plugging the unit in.

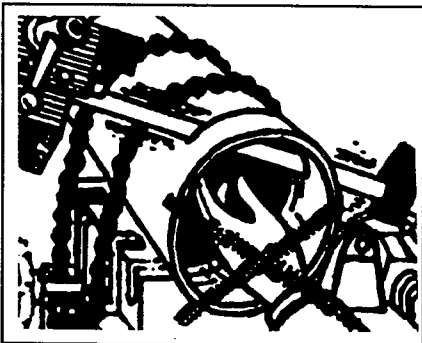
- Plugging the unit in with the ON/OFF button in the ON position will cause the unit to begin operating suddenly, possibly resulting in accident or injury. Always check to make sure that the ON/OFF button is in the OFF position before plugging the unit in.

11 Unplug the unit when not in use.



- After use, be sure to turn off the unit and unplug it. Also be sure to unplug the unit before changing blades or parts; before repairing, inspecting or cleaning the unit; and in the event of a power outage.

12 KEEP AWAY FROM THE BLADE AND MOVING PARTS.



- Be sure to keep away from the blades or moving parts while the unit is operating. Even after the unit has been turned off, the blade will continue to turn through inertia for some time. **DO NOT TOUCH THE BLADE OR MOVING PARTS WHILE THEY ARE IN MOTION.**

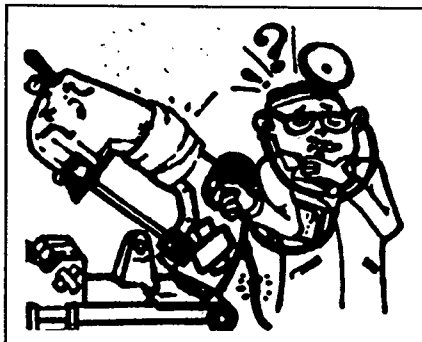
13 In the event of any abnormality, turn the unit off

- Turn off the unit immediately if it seems to be operating strangely or vibrates, or if you detect an unusual noise or odor.
- Use the table in the "Troubleshooting" section of this manual to determine the cause of the problem, then take the appropriate action indicated.

14 Regular care is important.

- Regular care will extend the life of this product. Be particularly careful to wipe away any dust from the motor and around the ON/OFF button.
- Make sure the blades are always sharp. Continuing to use the blades when they are worn, or using them for unsuitable purposes, will place increased stress on the motor and decrease work efficiency.

15 Periodic inspections are the cornerstone of safety.



- Like regular care, periodic inspections are an important means of ensuring proper performance.

16 Contact REX for proper inspection and repairs.

- In the event that the unit requires a thorough inspection or repairs, contact your dealer or a REX sales office.

17 Store the product properly.

- This product should be stored in a dry place out of the reach of children. Avoid humid locations and places where it will be exposed to rainwater (such as under eaves); this will cause rust and degrade the insulation, possibly resulting in current leakage or electrical shock.

Precautions

☆ Wipe away the oil from blades.

- Before shipment from the factory, blades are coated with oil to prevent rust. Be sure to wipe away the oil before attaching blades.
- If there is any oil on the workpiece, be sure to wipe it away as well.
- Do not apply cutting oil or the like to the blade during use.

※ Attempting to use the unit without first wiping away the oil from blades and the workpiece may cause the blade to slip or come loose.

☆ Use a blade of the recommended type that matches the material to be cut.

- Select the blade (type / number of teeth / length) that is appropriate for the material you are attempting to cut.
- Use only the recommended blades.

※ See the blade selection table on page 6.

☆ Use a cutting load setting that matches the workpiece.

- When cutting, set the load to a value appropriate for the workpiece.
- Do not use a load setting that is too high or press the grip against the workpiece while cutting. This may cause diagonal cutting or result in blade chipping or breakage.

※ To select the load setting, see the table on page 6.

☆ Clamp the workpiece securely.

- If the workpiece is not fastened securely in place, it may move during the cutting process. This may cause the tool to vibrate or place excessive stress on the blade, resulting in breakage.

- When cutting several workpieces at the same time, it may not be possible to fasten them securely depending on how they are placed in the vice. After turning the knob to clamp the objects, check to make sure that none of them move before beginning the cutting process.

☆ Make sure the blade is attached securely.

- Do not knock or strike the blade.
- Make sure the blade is attached securely to the pulleys and "SELI" heads.

☆ Check to make sure the unit is OFF before changing the blade or clamping workpieces.

- Be sure to set the ON/OFF button to the OFF position before clamping workpieces.
- Before changing the blade, set the ON/OFF button to the OFF position and unplug the unit.

☆ Install the unit on level ground.

- Avoid installing the unit on an incline. Always install it on level ground.
- To move the unit, set the frame lock dial to the LOCKED position, then pull up on the grip. The caster will come in contact with the ground, allowing the unit to be rolled easily.

☆ Make sure the frame does not drop suddenly.

- Make sure the frame does not drop unexpectedly, as this may damage the blade.

Precautions

☆ **Keep away from the blade when it is rotating.**

- Even after the unit has been turned off, the blade will continue to turn due to inertia. NEVER TOUCH THE BLADE OR MOVING PARTS WHILE THEY ARE IN MOTION.

☆ **Do not wear gloves while operating the unit**

- If gloves are worn during the cutting operation, they may become caught in the moving parts. Avoid wearing gloves while operating the unit.

☆ **Do not touch the workpiece with bare hands immediately after it has been cut.**

- Immediately after being cut, the workpiece will be very hot. You may be burned if you touch it with bare hands.

☆ **Do not drop or hit the unit.**

- This product contains precision parts that may be damaged if the unit is dropped, hit or otherwise subjected to shocks. Be particularly careful during transport.

☆ **Make sure the frame cover is in place.**

- To ensure safety during the cutting operation, always make sure the frame cover is in place when cutting.

☆ **Turn off the unit immediately in the event of an abnormality.**

- Turn off the unit immediately if it begins acting strangely or if you notice any other abnormality during operation.

☆ **Never open the controller cover.**

- Touching the board inside the unit will not only damage the board but may also result in electric shock. NEVER OPEN THE CONTROLLER COVER

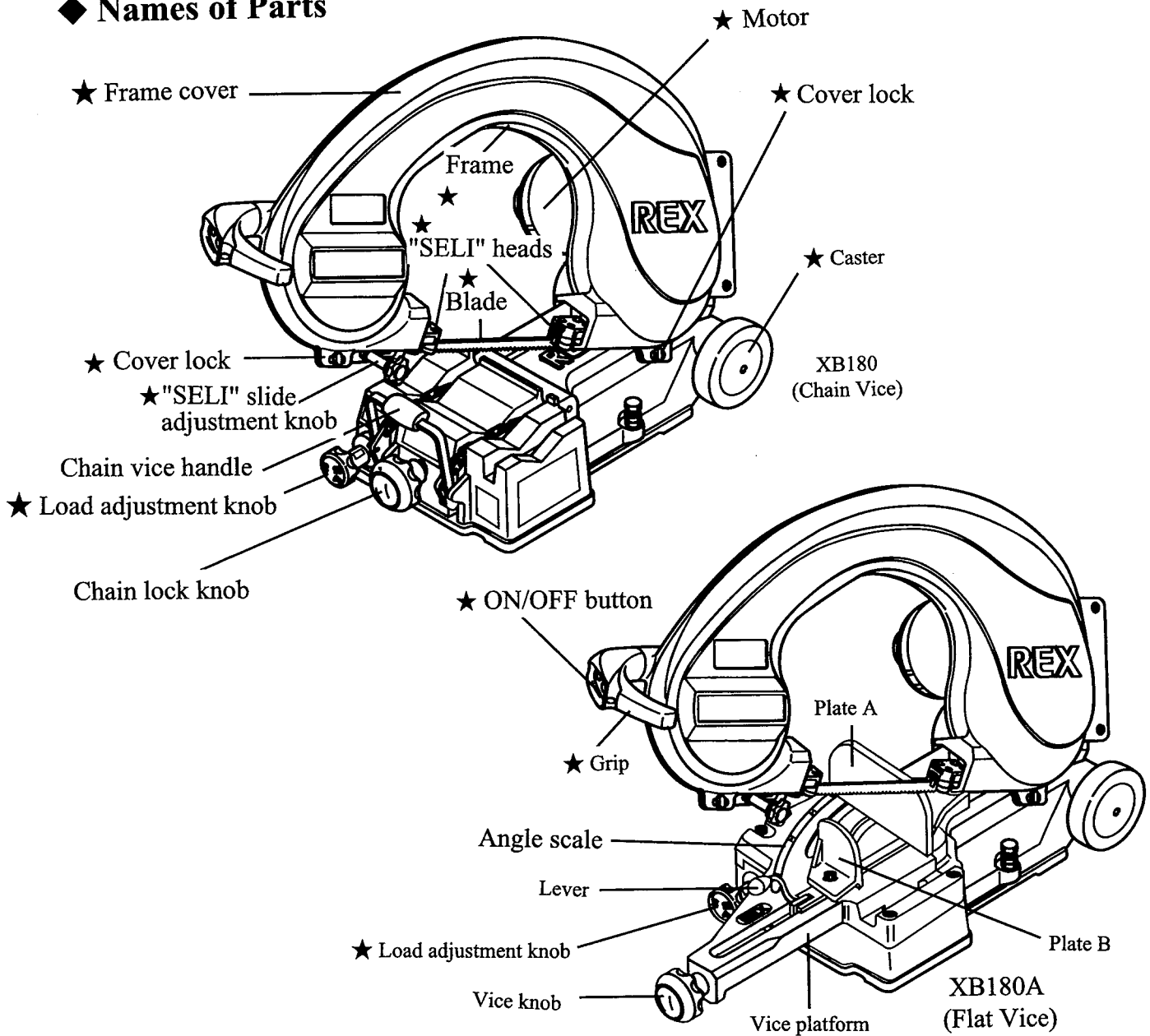
 **WARNING**

DO NOT OPEN!

Hazardous voltage may cause death or serious injury.
Do not touch the board inside this compartment.

Names of Parts and Specifications

◆ Names of Parts



◆ Specifications

Model	XB180	XB180A
Type	Chain vice type	Flat vice type
Cutting capacity	ϕ 180 · □ 150	
	For 45° angle cut = ϕ 80 · □ 80	
Motor	Single-phase capacitor starter type induction motor 250 W	
Power supply	Single-phase 50/60 Hz 220V	
Cycle speed	37/47 meters / min (50Hz/60Hz)	
Blade size (mm)	1625 (L) x 13 (W) x 0.65 (D)	
Unit size (mm)	905 (L) x 375 (W) x 395 (H)	
Weight	41kg	46kg
Standard accessories	- High-speed steel blade (14-tooth): 1 (installed in unit) - Hex wrench (5mm): 1 (stored inside frame cover)	

Special Accessories

Blades

Blade Type		Code No.	Suitable For Cutting:				
			Steel pipe	Steel pipe	Stainless steel pipe	Material	Asbestos pipe
Alloy	8 teeth per inch (set of 10 blades)	475200			Thickness 10mm ↑		
	10 teeth per inch (set of 10 blades)	475201	25A ↑		Thickness 8mm ↑		
	14 teeth per inch (set of 10 blades)	475202	15A ↑		Thickness 6mm ↑		
	18 teeth per inch (set of 5 blades)	475203	6A ↑		Thickness 4mm ↑	Thick steel	
	24 teeth per inch (set of 10 blades)	475204	6A ↑	13SU ↑	Thickness 4mm ↓	Thin steel	
High-speed steel	10 teeth per inch (set of 5 blades)	475210	25A ↑	Thickness 7mm or greater ↑	Thickness 8mm ↑		
	14 teeth per inch (set of 5 blades)	475211	15A ↑	Schedule 40 ↑	Thickness 6mm ↑		
	18 teeth per inch (set of 10 blades)	475212	6A ↑	20SU ↑	Thickness 4mm ↑	Thick steel	
Grit saw (set of 5 blades)		475220					○

Setting the Cutting Load

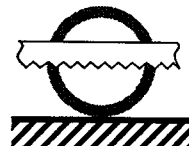
Use the table below to select the blade and cut weight that are appropriate for the material being cut.

Material	Blade Type No. of Teeth	Alloy					High-Speed Steel			Grit Saw
		8 teeth/inch	10 teeth/inch	14 teeth/inch	18 teeth/inch	24 teeth/inch	10 teeth/inch	14 teeth/inch	18 teeth/inch	
Carbon steel pipe (gas pipe) and lined pipe (external diameter in inches)	1.1/2 or less			(L)				(L)		
	2~4			(M)	(M)			(M)	(M)	
	5~6			(H)				(H)		
Electrical pipe	Thick steel			(L)				(L)		
	Thin steel					(L)				
Steel (round bars / sections) Thickness ()	2.9 or less					(L)			(L)	
	3.1~6			(M)	(M)			(M)	(M)	
	6.1~7.9			(H)				(H)		
	8~9.9		(H)				(H)			
	10 or more	(H)					(H)			
Stainless steel Thickness ()	1.2 or less					(L)				
	1.3~4.0						(L)	(L)		
	4.1 or more						(L)	(M)		
Cast iron pipe		(M)	(H)			(M)	(H)			
PVC pipe			(L)	(M)			(L)	(M)		
Asbestos pipe									(M)	

Cutting Load: (L) = light (M) = medium (H) = heavy

Notes

1. The figures in the table are examples only. Select the blade and cutting load to match the actual material being cut.
2. Select "M" when cutting several workpieces simultaneously.
3. When selecting the proper number of teeth in the blade, use the following guideline: thickness of material = 2 teeth.



4. Do not use this tool to cut heat-sensitive plastic materials. The heat generated from cutting may melt the material, causing it to get inside the unit and damage the motor.

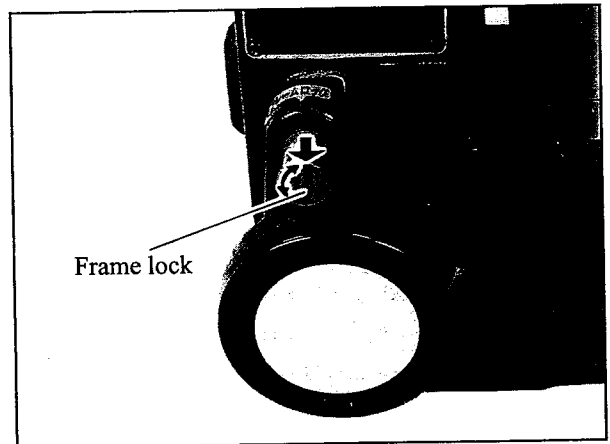


1. Unlocking the Frame

- After unpacking the unit, unlock the frame so it moves freely up and down.
- To unlock the frame, use the red knob above the caster on the rear of the unit.

★ Procedure ★

- During shipment or storage, set the knob to the "LOCKED" position to fasten the frame to the base. To use the saw, set the knob to the "FREE" position so the frame can move.
- To adjust the knob, pull it outward and simultaneously turn it 90° clockwise or counterclockwise.



2. Preliminary Inspection

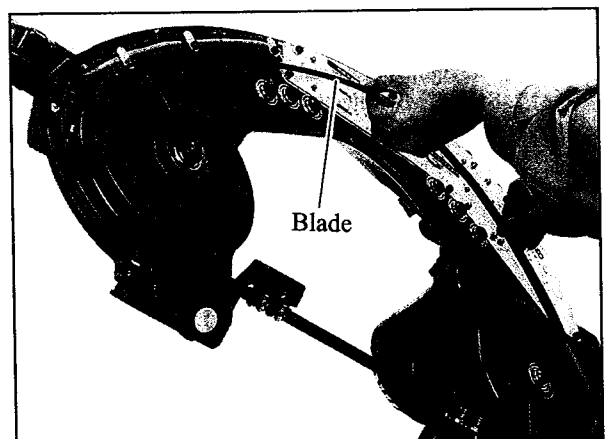
To prevent accident and injury, check the following before use:

Installation site	Install on level ground. Avoid sandy or dusty areas, as sand or dust may get into the pulleys and cause the blade to slip or come loose.
Surroundings	Make a visual inspection of the unit and the power cord and plug. Check for damage, dents, cracking etc.
Blade	Check blade for chipping, cracks, scratches etc.
Power supply	Be sure to use the correct voltage. If the voltage is too low, the lamp on the switch will start flashing.
Power check	After plugging in the saw, switch on and make sure the machine is idling. Check to make sure that the unit beeps when the unit is plugged in and when the button is changed to either the ON or OFF position. ※ Check there are no vibrations, there is no abnormal noise or odor, or any abnormal noise when the blade rotates. If the motor fails to operate and the lamp blinks, the motor interlock may have been triggered. See "Troubleshooting." [(page 19)]
Function check	
- Chain coiling function	Make sure chain comes out and coils back properly. If it does not move in and out smoothly, check to see if the chain lock knob is set to "LOCKED."
- Weight adjustment function	If the weight adjustment knob moves freely when the frame is in the lowered position, the unit needs inspection.
- Stopper function	Pushing the frame up to its highest point and then moving it down slowly will engage the stopper. Moving the frame to the highest point again and then down again slowly will release the stopper.

3. Selecting & Installing the Blade

⚠ WARNING: ALWAYS UNPLUG THE UNIT BEFORE CHANGING THE BLADE.

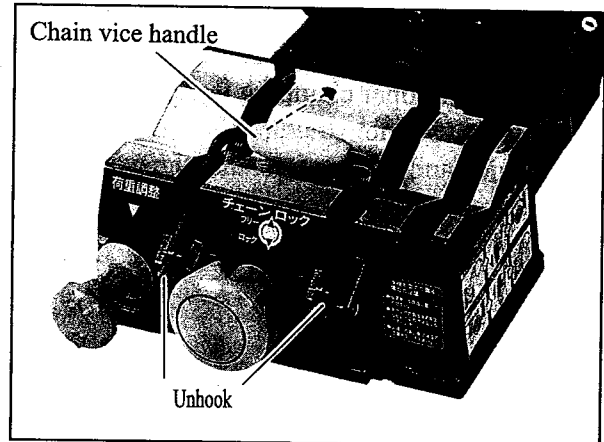
- (1) Select the blade. Select a blade of the recommended type that matches the material to be cut. (See table on Page 7.)
- (2) Install the blade. See "Changing the Blade" on Page 17.





4. Clamping the Workpiece

- (1) Unhook the chain vice handle and move the handle to the rear of the vice.

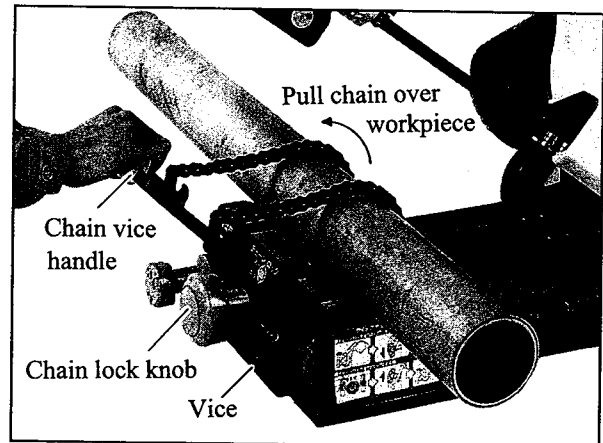


- (2) Place the workpiece in the V-shaped groove on the vice.

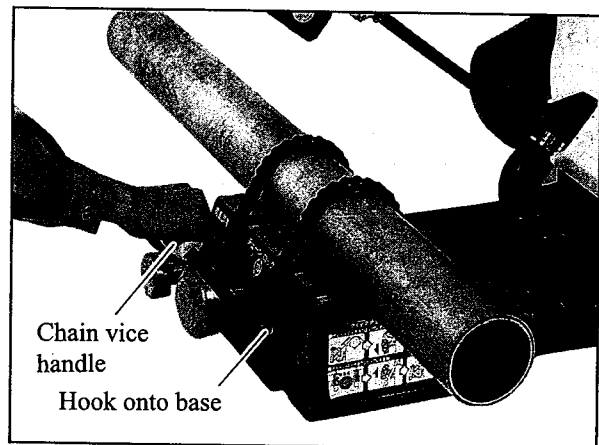
※ Long heavy pipes may place a lot of tension on the knob, making it difficult to set it to the "FREE" position, so use a pipe support.)

- (3) Pull the chain vice handle so the chain is over the workpiece.

※ If the chain does not move smoothly, check to see if the chain lock knob is in the "FREE" position.)

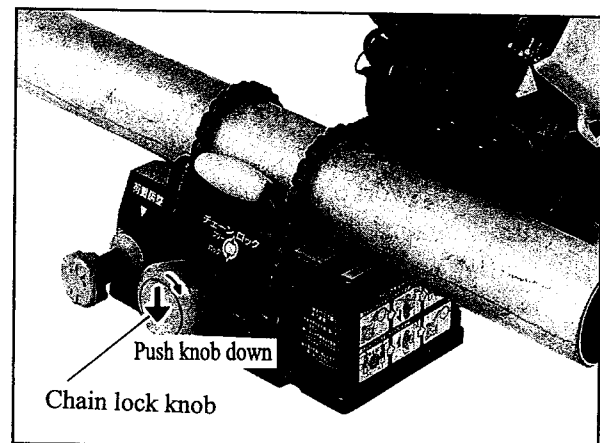
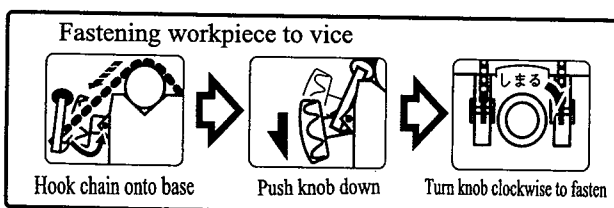


- (4) Hook the chain vice handle onto the base.



- (5) Push the chain lock knob down and turn it clockwise to lock.

- (6) Check to make sure that the workpiece is fastened securely.



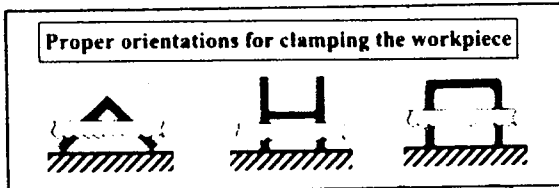
Operation



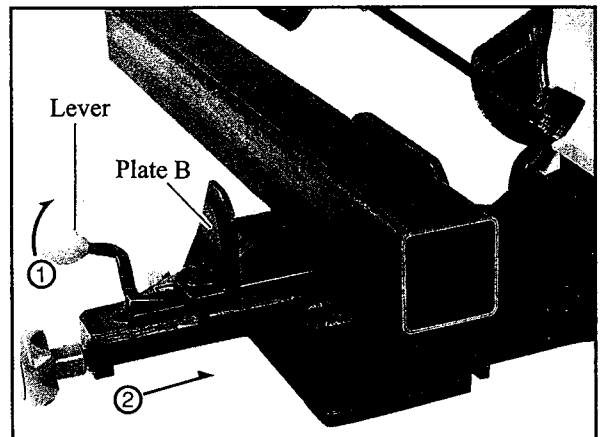
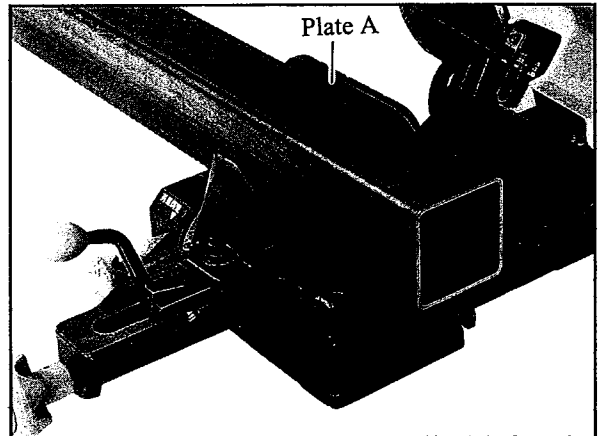
4-A. Clamping the Workpiece (model XB180A /Flat Vice)

- (1) Place the workpiece on the vice platform so it is along the edge of Plate A.

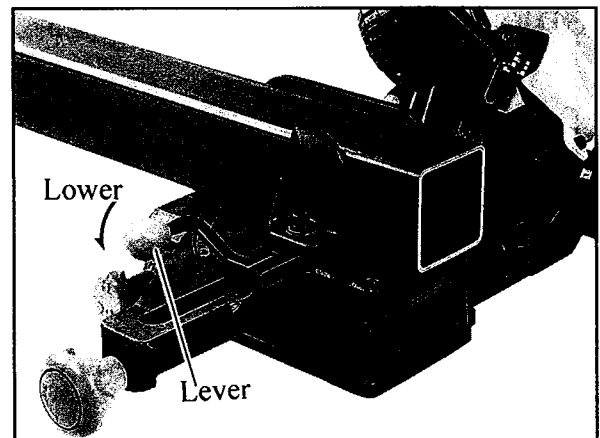
Note: Improper clamping is one of the causes of cuts that are not straight. Use the diagram below as a guide and be sure to clamp the workpiece securely so the load on the blade saw does not fluctuate violently.



- (2) Raise the lever and push Plate B toward the workpiece.



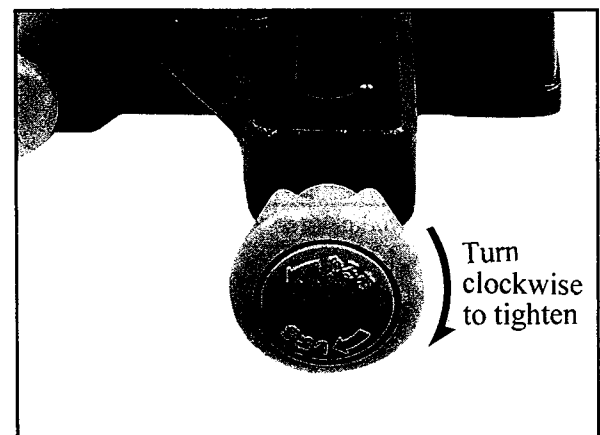
- (3) Lower the lever at the point where Plate B is lightly touching the workpiece.



- (4) Turn the vice knob anti-clockwise to fasten the workpiece in place.

- (5) Check to make sure the workpiece is fastened securely.

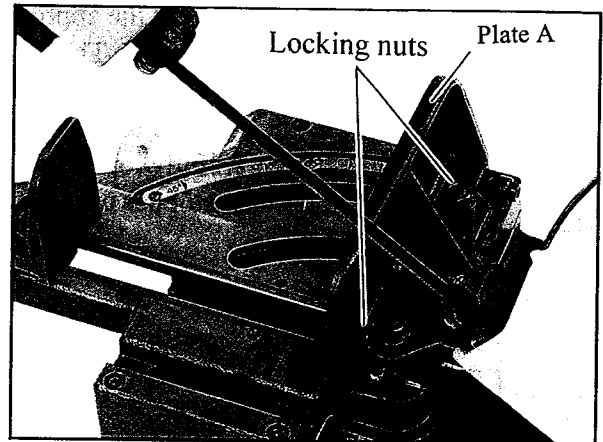
Note: The workpiece should be fastened so it is firmly against the surface of the vice platform. Cutting accuracy will be impaired if the workpiece is sticking up.



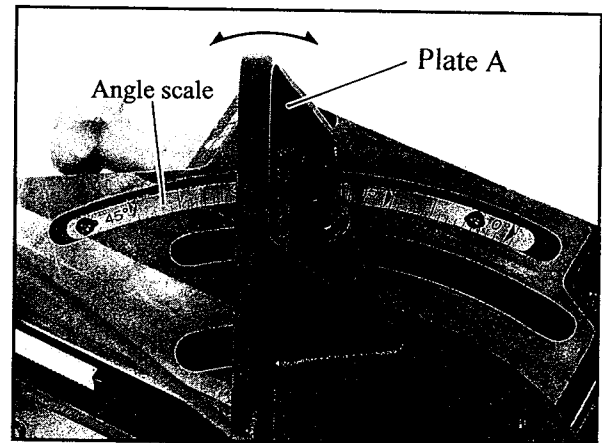


4-B. Cutting at an Angle (model XB180A only / 0 ~ 45°)

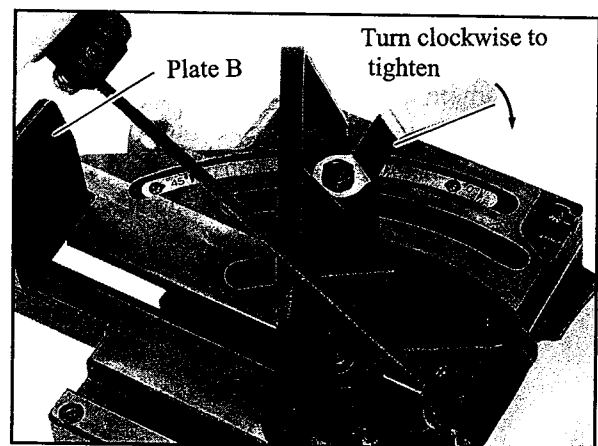
- (1) Using the wrench included with the unit, loosen the two locking nuts on Plate A 1 - 2 turns.



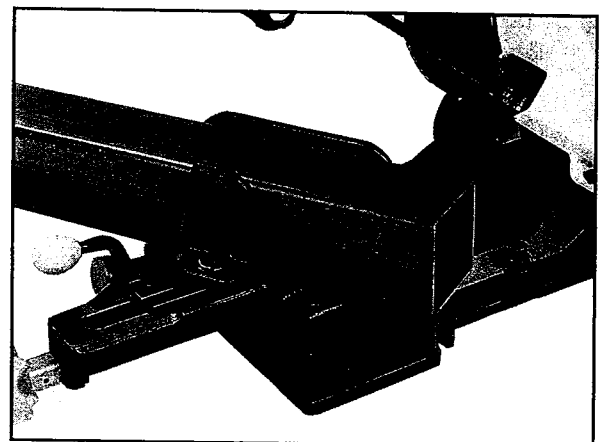
- (2) Set the edge of Plate A to the desired cutting angle on the angle scale.



- (3) Tighten the two locking nuts securely to fasten Plate A in place. The angle of Plate B can be adjusted freely, so push it against the workpiece.



- (4) Clamp the workpiece using steps 1 to 4 in section 4A "Clamping the Workpiece."
(5) Check to make sure the workpiece is fastened securely.



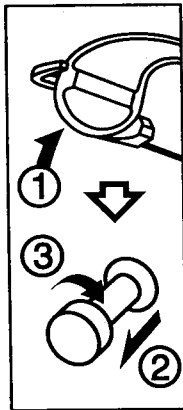
Operation



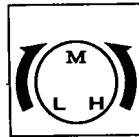
5 Adjusting the Cutting Load

Consult the table on Page 7 to find the appropriate cutting load for the material to be cut. Then lift the frame to its highest point. Holding it there, pull the load adjustment knob outward and turn it to set the appropriate weight. Then carefully lower the frame.

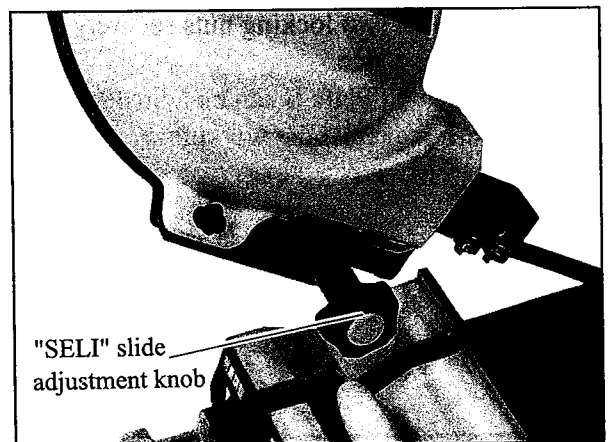
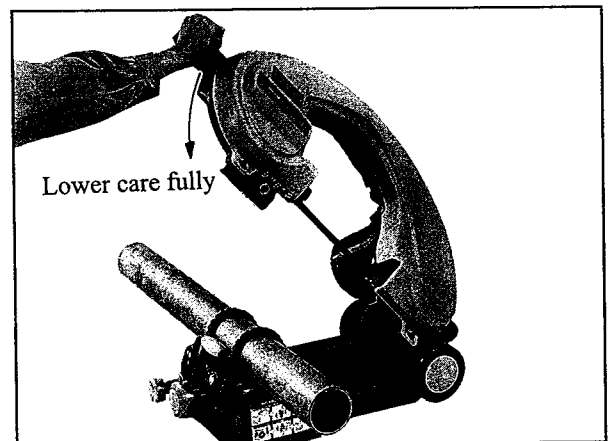
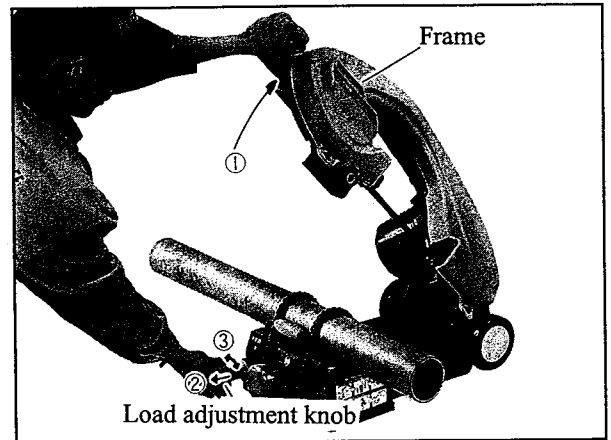
※ Do this carefully, as the stopper may be disengaged.)



Adjust cutting load



See cutting load adjustment table



6 Adjusting the "SELI" Slide

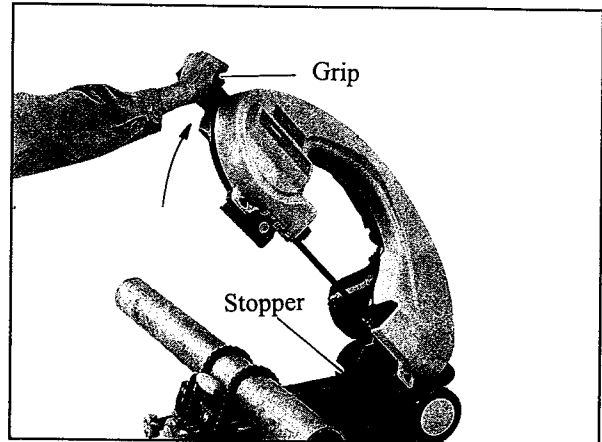
Adjustment of the "SELI" slide is performed using the black knob with the yellow center (located at the base of the "SELI" arm on the grip side of the frame). Slide the knob left or right to match the size of the workpiece, then tighten it securely in place.

※ This adjustment must be performed, as it eases the load on the blade. Adjust the "SELI" slide to match the size of the workpiece.



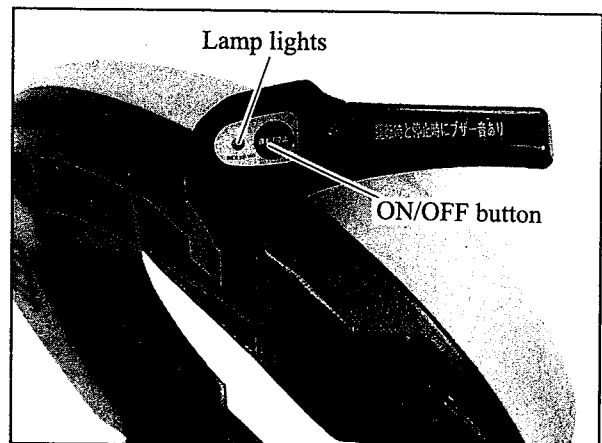
7. Cutting

- (1) Pull up on the grip and lift the frame to its highest point to disengage the stopper.



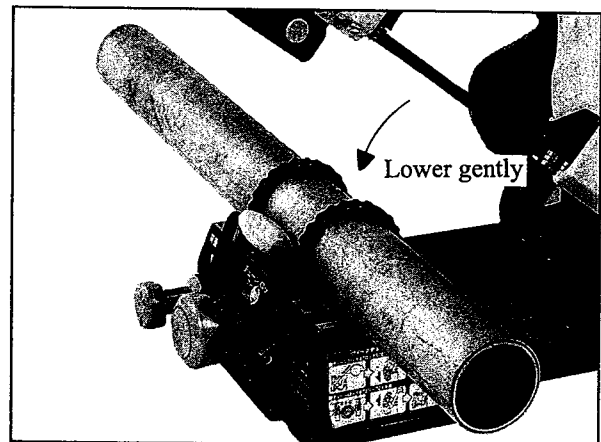
- (2) Set the ON/OFF button to the ON position before placing the saw against the workpiece.

- ※ The ON/OFF button is located on the grip.
- ※ When the ON/OFF button is pressed, the lamp lights up and the unit beeps. This is normal.



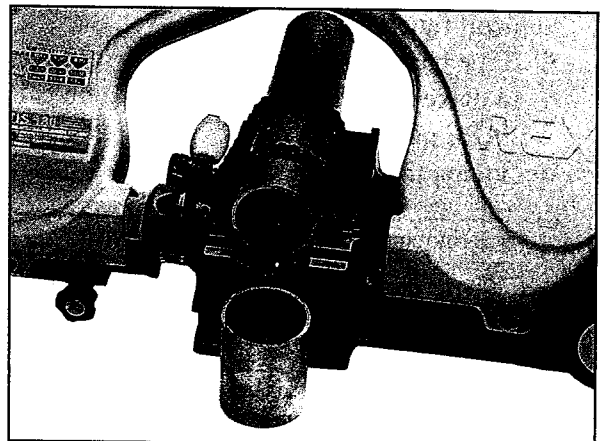
- (3) When the blade is moving fast enough, carefully lower the frame and place the blade against the workpiece.

- ※ Always press the ON/OFF button to turn on the unit BEFORE placing it against the workpiece. Failure to do this may damage the blade.
- ※ Do not let the blade fall suddenly onto the workpiece. This may damage the blade or result in slanted cuts. [IN FIGURE: Place saw against workpiece carefully]



- (4) The saw performs the cut automatically. When cutting is complete, the saw automatically turns off and stops operating.

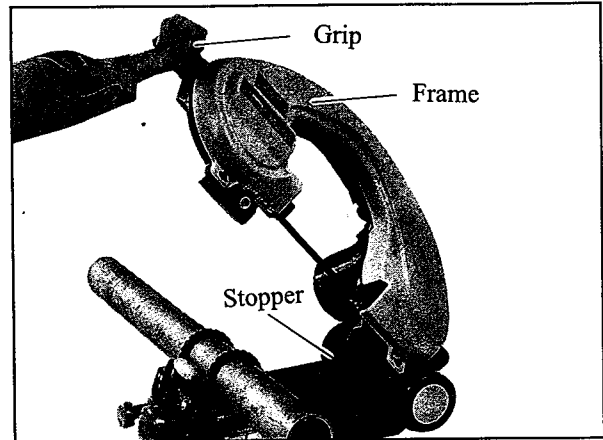
- ※ The unit beeps when the saw stops operating. This is normal.



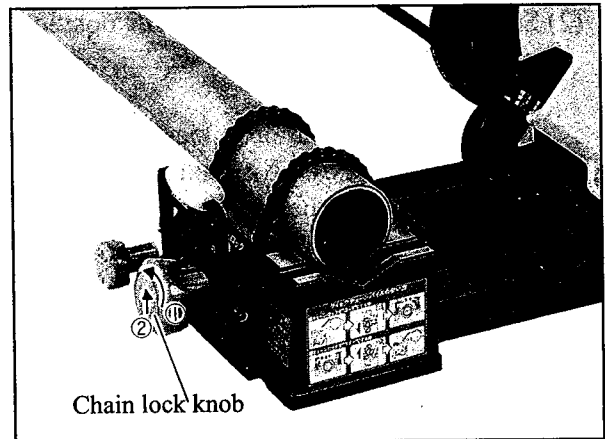


8-A. Removing the Workpiece (model XB180A / Flat Vice)

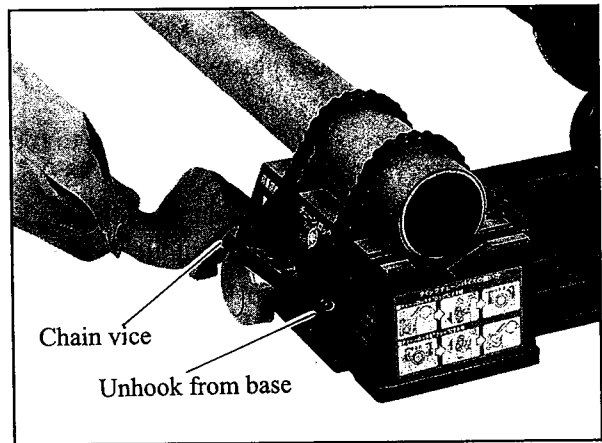
(1) Pull up on the grip and lift the frame to engage the stopper.



(2) Turn the chain lock knob counterclockwise to loosen the chain tension, then lift the knob up to set it to FREE.



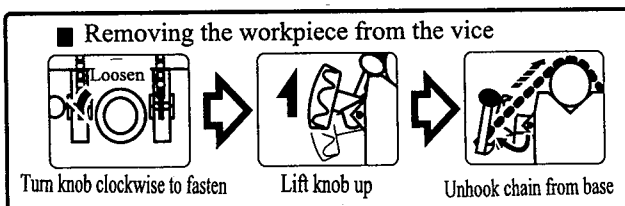
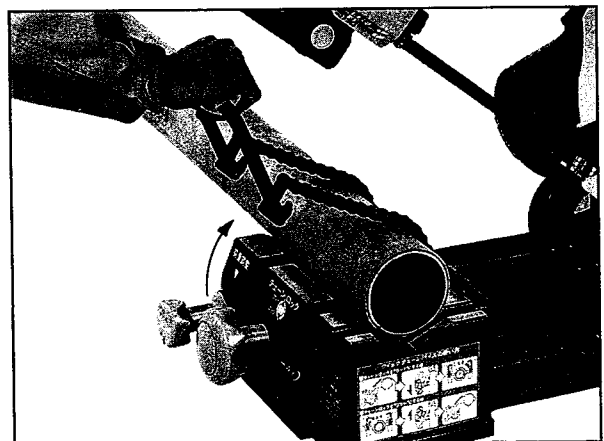
(3) Unhook the chain vice handle from the base.



(4) The chain will coil automatically due to the autocoil function.

※ If the chain does not move freely, check again to make sure that the chain lock knob is in the FREE position.

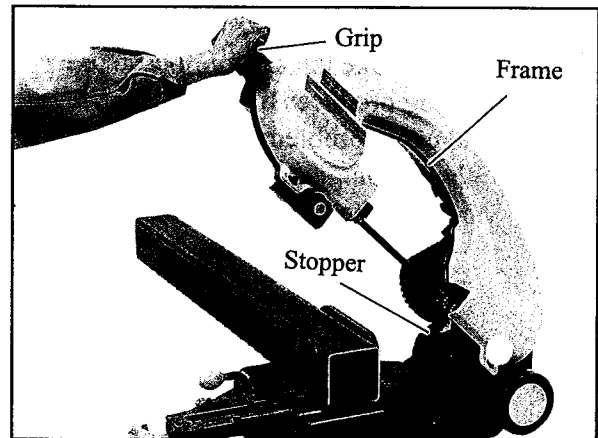
(5) Removing the workpiece.



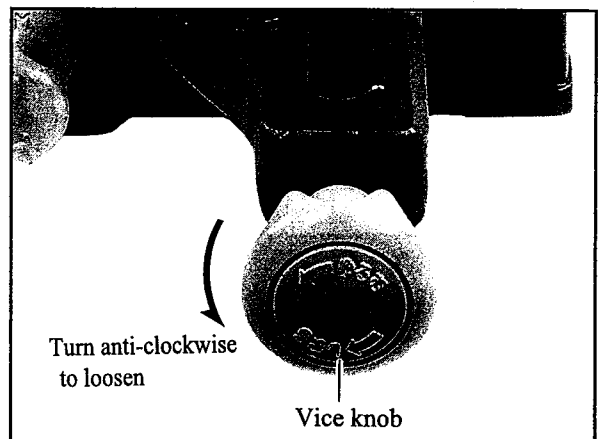


8. Removing the Workpiece (model XB180A / Flat Vice)

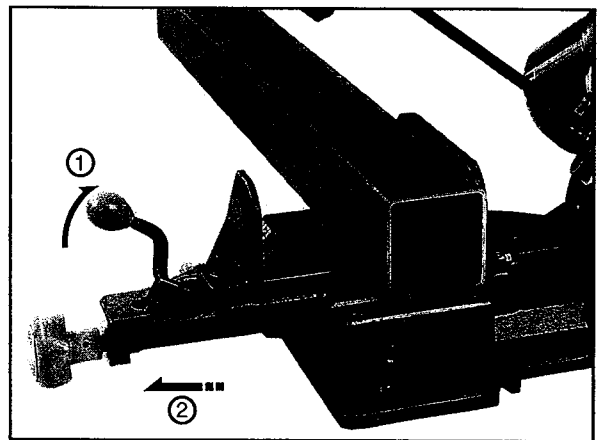
(1) Pull up on the grip and lift the frame to engage the stopper.



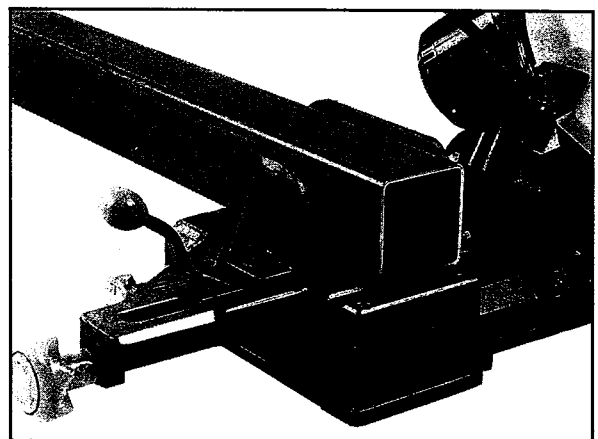
(2) Turn the vice knob anti-clockwise to loosen the vice.



(3) Raise the lever and pull Plate B forward.



(4) Remove the workpiece from the vice platform.





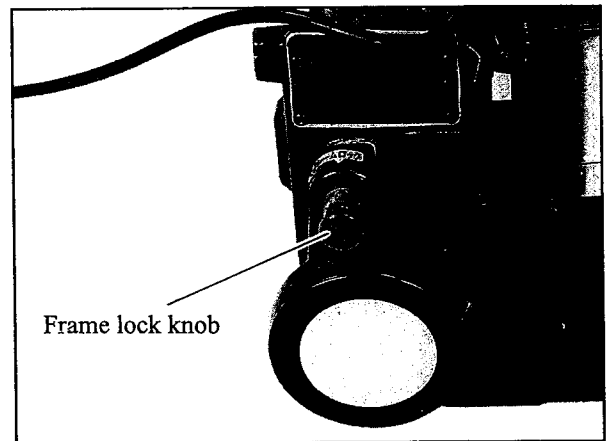
9. Final Inspection & Cleanup

Clean and inspect the unit to ensure that it is ready for use next time.

- (1) If there were any abnormalities during operation, consult the "Troubleshooting" table (Page 19) and take the appropriate steps.
- (2) Cutting produces tiny chips which, if not cleaned up, may get into the motor and moving parts and cause problems. Be sure to wipe away any dust and chips.
- (3) When unplugging the power cord from the outlet, grasp the plug and not the cord. Also, coil and bind the cord so you do not accidentally step on it while moving the unit.

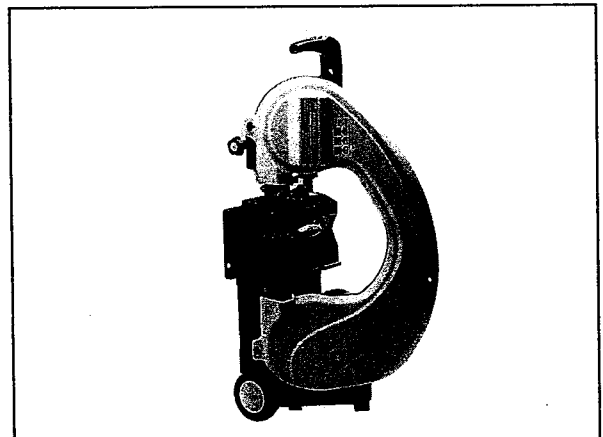
10. Transport

- (1) Set the frame lock knob to the LOCKED position.
- (2) Pull up on the grip. The caster will come in contact with the ground, allowing the unit to be rolled easily.
 - ※ While rolling the unit along the ground, be careful not to bump the unit or step on the cord.
- (3) Although the unit can be rolled over small level differences, choose a route with a smooth surface. Be particularly careful to avoid sandy or dusty places, as these can adversely affect the unit.
- (4) If the unit is carried, it should be held firmly by two or more persons. Be careful not to drop it.



11. Storage

- (1) The unit can be stored in an upright position, but to avoid accident and injury be careful of the following:
 - Choose a level place. Avoid unstable locations.
 - Do not store it where a lot of people pass by.
 - Do not store the unit on a truck bed or other unstable location.
 - Before storing the unit, clean it to remove chips, etc.
- (2) To prevent power leakage and electric shock, do not store the unit in areas with high humidity or in locations where it will be directly exposed to rain or snow (under eaves, etc.).
- (3) When storing the unit for an extended period of time, loosen the tension lever to release the blade tension.

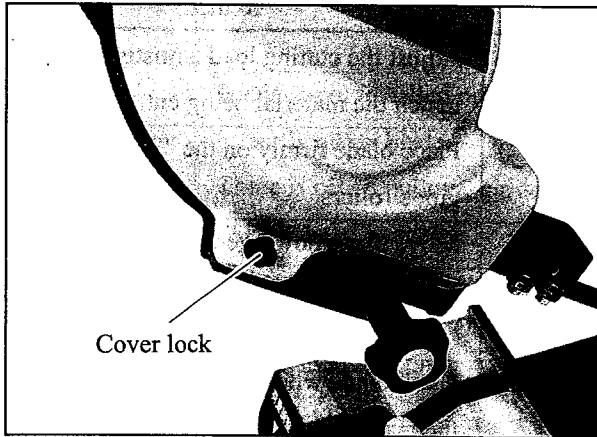




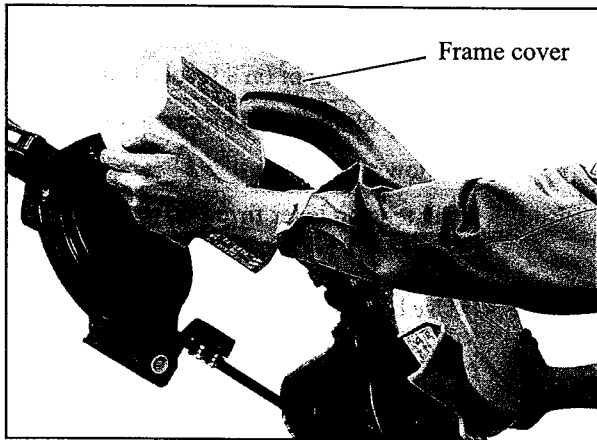
Changing the Blade

※ Before changing the blade, set the ON/OFF button to the OFF position and unplug the unit.

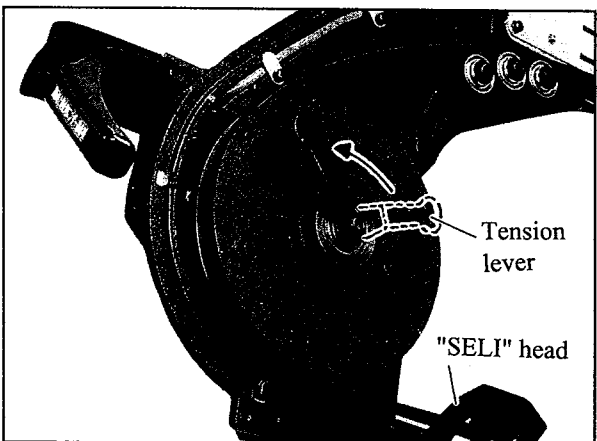
- (1) Turn the cover locks at the base of the frame to unlock the frame.



- (2) USING BOTH HANDS, lift off the frame cover.

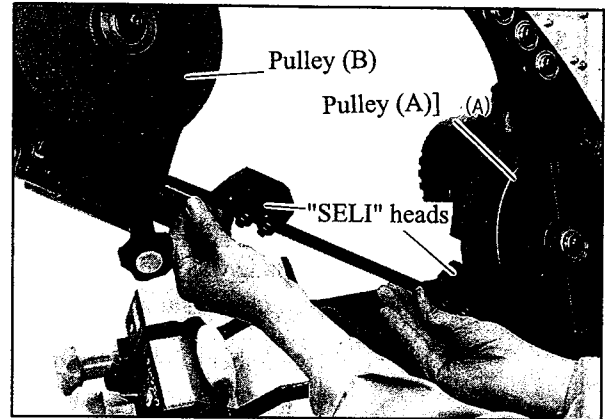


- (3) Turn the tension lever anti-clockwise to release the blade tension.

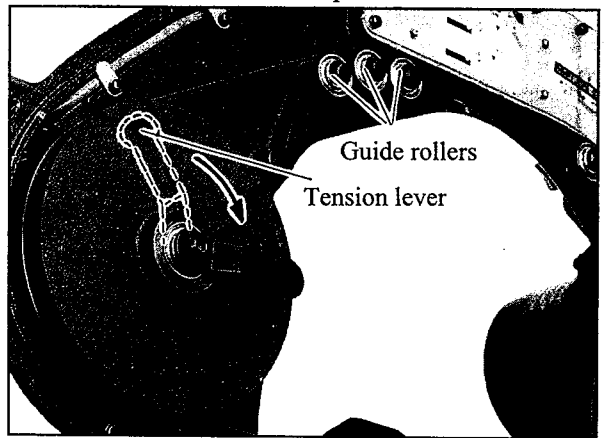


- (4) Remove the "SELI" heads and then the pulleys in that order to remove the blade.

- (5) Place the new blade on the pulleys (A) (B) and the guide rollers.
- (6) Insert the blade all the way inside the "SELI" heads.



- (7) Turn the tension lever clockwise to make the blade is taut. While tightening, check to make sure the blade is positioned correctly on the guide rollers and the rubber ring of Pulley (A). When the blade is fastened securely, turn the pulley by hand to make sure the blade remains in place.



- (8) Replace the frame cover. Make sure the arrow on the cover (▼) is aligned with the arrow on the frame (▲) then turn the cover locks to fasten it in place.



⚠ CAUTION

- ※ Wipe all of the oil (applied to prevent rust) from new blades before installing them.
- ※ After installing a new blade, set the cutting load to L (light) and run the unit for 1-2 blade revolutions. Doing this will extend the blade life.
- ※ Use blades of the recommended type that match the material to be cut.
- ※ When removing the frame cover to change the blade or inspect the unit, be careful that the blade does not pop out unexpectedly.

Troubleshooting

In the event of a problem, use the table below to determine the cause and take the proper steps. If the suggested remedy fails to resolve the problem, contact your dealer.

Problem	Cause	Remedy
Saw cuts at an angle	Cutting load is not adjusted properly.	Adjust the cutting load adjustment knob to match the material being cut.
	Blade is not installed correctly.	Place blade firmly on the "SELI" heads and guide rollers.
	Blade is lowered too suddenly.	Move blade down gently.
	Blade was being used improperly or is worn.	Replace blade.
	Number of blade teeth does not match material being cut.	Use a blade whose number of teeth match the material being cut.
	"SELI" head bearings are worn.	Replace bearings (contact your dealer or REX).
	Workpiece moved during cutting.	Make sure workpiece is fastened securely in the V-groove or on a level surface.
	Workpiece is not clamped properly.	Clamp oblong workpieces so their height is as low as possible.
	Tension lever is not set properly.	Set tension lever firmly to the LOCKED side.
Cutting takes a long time	Blade is not one of the recommended type.	Use blades of the recommended type.
	Cutting load is set too light.	Set the load adjustment knob to match the material being cut.
	Number of blade teeth and cutting load do not match material being cut.	Consult the tables for number of blade teeth and cutting load (Page 7) and select the proper values
	Blade is worn.	Replace blade.
Blade becomes chipped	Cutting load is set too high.	Set load adjustment knob to match the material being cut.
	Workpiece moved during cutting.	Make sure workpiece is fastened securely in V-groove or on level surface.
	Blade was placed too suddenly against workpiece.	Move blade above workpiece and then release grip carefully so blade is placed gently on workpiece.
	Number of blade teeth is unsuitable.	Change blade to one with a suitable number of teeth for the material being cut.
Saw vibrates while cutting	Tension lever is not set to the "LOCKED" side.	Set tension lever to "LOCKED" side.
	Workpiece is not clamped securely.	Clamp workpiece securely.

Troubleshooting

Problem	Cause	Remedy
Blade comes loose	Number of blade teeth is unsuitable.	Change blade to one with a number of teeth that matches the material being cut.
	Blade is not installed properly.	Install blade securely in place.
	There is oil on blade.	Wipe away oil from blade and reinstall.
	There is oil on pulleys, guide rollers or "SELI" head bearings.	Wipe away oil.
	There is oil on workpiece.	Wipe away oil.
	Tension lever is not set firmly in place.	Set tension lever to proper position.
	Rubber ring on pulley is worn	Replace rubber ring on pulley.
Motor does not operate or does not stop properly	Lamp is blinking due to low voltage	Secure a 220V power supply.
	Motor interlock has activated, locking motor (lamp blinks).	Wait 5 - 10 minutes; unit will reset itself automatically.
	Power plug has come out of the electric socket..	Replace plug in socket.
	Limit switches are set improperly.	Have limit switches adjusted (contact your dealer or REX).

Periodic Inspections & Care

※ Before inspecting and carrying out maintenance on the unit, be sure to turn the machine off and unplug the unit.

1. Check the blade.

- Check to make sure that the blade is not chipped or otherwise damaged. If it is, replace it. See "Changing the Blade" (Page 17).
- If the blade becomes worn, replace it as soon as possible. Continued use of a worn blade will place excessive stress on the motor and adversely affect work efficiency.

2. Check all bolts.

- Inspect the unit regularly to make sure all bolts are fastened tightly, and tighten any that are loose. It is dangerous to use the unit when bolts are loose.

3. Check the power cord.

- Check the power cord and plug for damage and wear. If the cord is damaged, replace it.

4. Inspect the "SELI" heads.

- Cutting precision will be impaired if the "SELI" heads are not adjusted properly. Check periodically to make sure that the "SELI" heads are properly adjusted.
- If the "SELI" head bearings are worn, replace them as soon as possible.

5. Keep the unit clean.

- Using a cloth or the like, periodically wipe away any chips, dust and dirt from the frame and pulley sections.
- Be careful not to get any water or oil in the motor.

Servicing & Repair

This unit is a precision instrument. If it fails to function properly, do not try to repair it yourself; contact one of the following:

REX dealer

REX sales office (see back page)

REX Technical Support (in Japan) (+81)729-63-1960

If you have questions or need parts or other supplies, feel free to contact REX INDUSTRIES CO. LTD.

Availability of Replacement parts

Replacement parts are maintained for a period of 7 years after production of this model has been terminated. Electrical parts, however, are available for a period of 5 years.

MEMO

REX INDUSTRIES CO., LTD.

Overseas Sales Section & Factory :

1-9-3, Hishiyahigashi, Higashi Osaka 578-0948, Japan.

Tel.: 81 - 729 - 61 - 9820 Fax.: 81 - 729 - 61 - 2913

URL <http://www.rexind.co.jp>

XB180/XB180A-E1
0206D 0100