PEUGEOT PROFESSIONNELS

WARRANTY 2+2 YEARS

Get a free 2-year warranty

MANUAL BAND SAW PSR125MVE

IN GOOD HANDS

TRANSLATION OF ORIGINAL INSTRUCTION MANUAL

DE / FR / PT / SP

V170426

WHO ARE WE?

Peugeot Professional Tools was born out of several obvious considerations.

The first was to combine the know-how of **Peugeot**, which has mastered the art of cutting since 1810, with the expertise of **Tivoly**, a metalworker since 1917, in order to create a wide range of machines and tools for construction and maintenance professionals.

It was also a natural step to want to serve craftsmen and small businesses driven by strong family and heritage values.

For these professionals, **Peugeot Outils Professionnels** offers machines and tools designed specifically for their needs. **These tools are reliable, durable,** and **can be repaired in France** and in countries under distribution agreements by local industrial and family partners.

Trustworthy equipment with a longer warranty, logistics, and **French after-sales service.** The assurance of dealing with the people who assembled these tools and know every part that goes into them inside out.

From exceptional projects to everyday work, these tools are designed to withstand the most demanding conditions and stand the test of time.

Peugeot Professional Tools was born out of one obvious fact: that our tools are in good hands. The hands of those who work behind the scenes and give their all to satisfy their customers.

Since 1810, many things have changed, but the hands have remained the same. The hands of enthusiasts, craftsmen, dedicated technicians and installers, workers who are proud of themselves and their achievements.

Peugeot Professional Tools: tools in good hands.

THANK YOU FOR YOUR PURCHASE.

We are delighted that you have chosen Peugeot Professional Tools. Every detail has been designed to offer you an exceptional experience, and we hope you enjoy using it as much as we enjoyed creating it for you.

Your trust is essential to us, and we are delighted to accompany you every step of the way in your experience with the Peugeot Professional Tools brand.

Your purchase comes with a 2-year warranty, extendable to an additional 2 years.

To benefit from this, register at www.peugeot-outils-pro.com

If you have any questions or need assistance, our team is available to provide you with the best possible service.

To contact our after-sales service, visit , call , or email .
+33(0)4.79.89.59.00

Thank you for choosing Peugeot Professional Tools. Your satisfaction is our priority.

CONTENTS

1 INTRODUCTION

For safety reasons, read these instructions carefully before using this machine.
Failure to follow the instructions will result in damage to persons and/or the machine.

This instruction manual is intended for the operator, adjuster, and maintenance technician.

This instruction manual is an important part of your equipment. It provides rules and guidelines that will help you use this machine safely and efficiently. You must familiarize yourself with the functions and operation by reading this instruction manual carefully. For your safety, it is particularly important that you read and observe all recommendations on the machine and in this instruction manual.

These recommendations must be strictly followed at all times when using and maintaining the machine. Failure to follow the safety guidelines and warnings in the instruction manual and on the machine and/or use other than that recommended in the instruction manual may result in machine failure and/or injury.

Please keep this instruction manual with the machine or in a place that is easily accessible at all times for future reference. Ensure that anyone involved in the use of this machine can consult it periodically. If the instruction manual is lost or damaged, please contact us or your dealer to obtain a new copy.

Always use PEUGEOT OUTILS PROFESSIONNELS components and parts. Replacing components or parts other than PEUGEOT OUTILS PROFESSIONNELS may cause damage to the machine and endanger the operator.

This manual describes the safety instructions to be followed by the user. It is the responsibility of the employer or user, in accordance with Article L.4122-1 of the Labor Code, to take care of their health and safety and that of other persons affected by their actions or omissions, in accordance, in particular, with the instructions given to them.
The employer must carry out an assessment of the specific risks associated with their activity, must train workers in the use of the machine and in the prevention of these risks, and must appropriately inform workers responsible for the use or maintenance of work equipment of the instructions or guidelines concerning them.

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2 PICTOGRAMS

2.1 MACHINE SAFETY PICTOGRAMS

Meaning of the safety pictograms affixed to the machine (keep them clean and replace them when they are illegible or detached):


Safety shoes must be worn.


Protective eyewear must be worn.


Read the instruction manual carefully.


Risk of debris and sparks caused by cutting.


Risk of cuts.


Electrical presence.


Ground connection for metal parts.


Protective gloves must be worn.


Hearing protection must be worn.


Do not wear loose clothing, wide sleeves, bracelets, watches, wedding rings, jewelry, ties, scarves, or any other items that could get caught in the moving parts of the machine.
Wear hair nets for long hair.


Risk of crushing.


Direction of assembly and tape feed.

2.2 PICTOGRAMS USED IN THIS INSTRUCTION MANUAL


Direct danger to persons and damage to the machine.


For ribbon replacement and cleaning operations, wear protective goggles and gloves.

✓ Note.


Possible damage to the machine or its surroundings.


Minimum number of personnel required for certain operations.


If necessary, wear respiratory protection to reduce the risk of inhaling hazardous dust.


Technical skill level: operator, user.


Technical skill level: adjuster, maintenance.


Technical skill level: maintenance technician.



Electrical work must be carried out by personnel who are qualified and authorized to perform low-voltage electrical work.

3 SAFETY

3.1 GENERAL SAFETY REQUIREMENTS

To reduce the risk of fire, electric shock, mechanical shock, and personal injury when using power tools, follow basic safety precautions.

This instruction manual only takes into account reasonably foreseeable behavior.

Our machines are designed and manufactured with the operator's safety in mind.
The machine must not be used by young workers under the age of eighteen.

We accept no liability for any damage caused by inexperience, incorrect use of the machine and/or damage to it and/or failure to comply with the instructions and safety rules contained in this instruction manual.
As a general rule, accidents always occur as a result of misuse or failure to read the instruction manual.
We remind you that any modification to the machine will result in our withdrawal of liability.

Check the presence, condition, and operation of all guards before starting work.
Ensure that moving parts are working properly, that there are no damaged components, and that the machine is in perfect working order during start-up.
Only competent and authorized personnel are permitted to repair or replace damaged parts.

Keep the work area clean and tidy.
Ensure that the entire work area is visible from the work position.
Cluttered work areas and workbenches are a potential source of injury.
Do not use the machine outdoors when weather and environmental conditions do not permit it or in very humid locations . Reserve it for indoor use, in a dry, well-ventilated area free from flammable liquids or gases.
Position the machine in a sufficiently lit work area.
Do not allow unauthorized persons, especially children and animals, to touch the tools or electrical cables, and keep them away from the work area.
Turn off the machine when you have finished using it. Always disconnect the power supply.
Never leave the machine unattended while it is running. Only leave the machine when it has come to a complete stop.

Do not force the disc; it will perform better and be safer at the speed for which it is designed.
Do not use discs for work for which they are not intended.

Do not damage the power cord.
Never pull on the power cord to remove it from the electrical outlet.
Keep the power cord away from heat sources, greasy areas, and/or sharp edges.
Protect the power cord from moisture and any potential damage.
Check the power cord periodically. If damaged, have it repaired by an authorized repairer.
Defective switches must be replaced by a qualified person or an authorized repairer.
Do not use the machine if the switch does not control the stop or start functions.

Do not overestimate your strength.
Always maintain a stable position and good balance.
Be aware of what you are doing and use common sense.
Do not use the machine when tired.
Always use both hands to operate this machine.

The use of any accessories other than those described in the instruction manual may present a risk of injury to persons.

The user is responsible for their machine and must ensure that:

- The chainsaw is used by people who have read the instructions and are authorized to do so.
- Safety rules are followed.
- Users have been informed of the safety rules.
- Users have read and understood the instruction manual.
- Responsibilities for maintenance and any repairs have been clearly assigned and observed.
- Defects or malfunctions have been immediately reported to an authorized repairer or your dealer.
- The chainsaw must be used in the areas of application described in this manual.
- Any use other than that specified in this instruction manual may constitute a hazard.
- Mechanical and/or electrical guards must not be removed or bypassed.
- No modifications and/or conversions must be made.

PEUGEOT OUTILS PROFESSIONNELS declines all responsibility for damage caused to persons, animals, or objects as a result of failure to comply with the instructions and safety rules contained in this instruction manual.

3.2 SPECIAL SAFETY REQUIREMENTS

Special safety requirements for the band saw.

Before use, the machine must be correctly assembled.
Secure the machine to a workbench that is fixed to the floor and is sufficiently flat and non-slip, so that the workbench is as stable as possible.
Do not use if the machine is not placed on a flat, stable surface that is free of obstacles and well lit.
Do not operate the machine when the safety guards are removed.
Fit a blade that complies with the machine's specifications.
Only use belts recommended by PEUGEOT.
Ensure that the choice of blade and teeth correspond to the material and cross-section of the part to be cut.
Use appropriate cutting speeds.
Ensure that the blade is correctly fitted.
Check that the band is correctly tensioned.
Do not use damaged or deformed blades.
Do not use this machine to cut building materials (concrete, cinder blocks, paving stones, stone, etc.), wood, PVC, or derivatives.
Occasionally use stainless steel with the speed variator set to minimum (with a gradual and correct descent) and with a suitable blade.
Do not stop the blade by hand.
Do not touch the blade while it is moving.
Always keep the blade clean.
Do not clean the blade while it is moving.
The blade can become very hot during machine operation. Wait for the blade to cool before replacing it.
Always keep the band saw frame clean and uncluttered.
Do not add additional accessories for operations for which they are not designed.
Using an inappropriate accessory can lead to accidents.
Keep hands away from cutting areas when the machine is in operation.
Never hold the workpieces by hand; clamp them securely in the vise.
Do not start cutting with the blade against the workpiece.
Do not hit the blade against the workpiece, but apply pressure gradually.
Lubricate the workpiece manually with a sufficient amount of cutting fluid.
Always work in a stable position and maintain your balance.
Always wear safety goggles.
Ensure that no one is in the path of debris and sparks caused by cutting.
Always keep the work area clean and uncluttered.
In all cases, remain focused on the task at hand.

For all operations involving a risk of cutting, burning, pinching, snagging, entanglement, or crushing, including loading and unloading the parts to be cut, changing the blade, and handling the part to be cut and the vise, stop the machine and wear protective gloves.
Rushing rarely saves time: the blade heats up, becomes dull, and needs to be resharpened. The work is poorly done. The risk of accidents is increased.
Wear hearing protection.
If necessary, wear respiratory protection to reduce the risk of inhaling hazardous dust.
Keep the fan cover clean and uncovered to ensure the machine operates correctly.
Before changing a cutting part or tape, and before performing any operation to position or remove waste material, stop the machine.
Disconnect the power supply for any major operations (maintenance, servicing, etc.).
Replace the vise base when it is worn.
Keep the machine clean and in good condition.
Remove chips regularly.
When cleaning, remove any chips that may be sharp and hot while wearing protective goggles and gloves, with the machine turned off, and collect them in bins. Avoid using a blow gun; instead, use a clean, dry cloth, a brush, a long-handled brush, a hook, a magnetic collector, or a vacuum cleaner.
Do not immerse the machine in water or wash it with a pressurized water jet, as this may cause water to penetrate the electrical components.
Do not use solvents or aggressive detergents for cleaning.
Disconnect the machine and check that the moving parts are locked when transporting the band saw.
Store the machine in a dry place out of the reach of children.

Accidents are generally the result of:

- Lack of accessories that allow the part to be held correctly.
- Disorder: if accessories are available, they are not stored properly and the operator cannot find them, so does without them.
- Inappropriate or dangerous operating procedures.
- Insufficient training, learning, and/or experience of operators in the use of the machine.
- Absence of protective covers during machine use.
- Ill-fitting clothing, lack of safety glasses for certain tasks.

3.3 OPERATOR PROTECTION

For operator safety, ensure that non-working parts are always covered by a protective guard.

This machine is designed for a single operator.
The operator must wear appropriate personal protective equipment:

- During use:
  - Safety glasses.
  - Hearing protection.
  - Safety shoes.
  - Protective gloves.
  - Respiratory protection.
- When cleaning the machine or changing the tape:
  - Safety glasses.
  - Safety shoes.
  - Protective gloves.

The operator must wear close-fitting clothing and, if necessary, hair coverings for long hair.
The operator must not wear, for example:

- Loose-fitting clothing with wide sleeves.
- Bracelets, watches, wedding rings, jewelry, ties, scarves.
- Any other objects that could become caught in the moving parts of the machine.
- Hair covers for long hair.

4 DESCRIPTION AND OPERATION

4.1 INTENDED USE OF THE MACHINE

The PSR125MVE manual band saw is a machine designed and manufactured solely for occasional use (2 hours/day) for cutting ferrous metals (steel, iron, cast iron) and non-ferrous metals (stainless steel, aluminum, copper, lead, zinc, tin, brass, etc.), profiles or solids, using a suitable endless rotating blade, dry.
The manufacturer declines all responsibility in the event of misuse or cutting of materials not recommended for the band.
Under proper conditions of use and maintenance, safe operation and performance are guaranteed for several years.
To do this, explore the machine's various functions.

Do not use this machine to cut construction materials (concrete, cinder blocks, paving stones, stone, etc.), wood, PVC, or derivatives.

Occasionally machine non-ferrous metals (stainless steel, aluminum, copper, lead, zinc, tin, brass, etc.) at an appropriate speed using the speed variator (minimum speed for stainless steel, maximum speed for aluminum, for example), with a gradual and correct descent, and with a suitable blade.

4.2 FEATURES

- Lightweight and compact band saw
- Manual descent
- Cast aluminum bow
- Swivel frame for cuts up to 60° straight
- Belt guides equipped with bearings
- Trigger switch handle
- Manual tape tension adjustment
- Electronic speed control
- Motor protection via thermal circuit breaker
- Supplied as standard with:
  - 1435 x 12.7 x 0.65 mm tape
  - cutting stop

Cutting capacities (mm)	Round	Square	Rectangular (L x H)	Opening Vise (mm)	Height of working (mm)	Dimensions Tape (mm)	Speeds of rotation (m/min)	Power	Power motor (kW)	Weight (kg)	Dimensions (L x H x W) (mm)
90	125	125	125 x 125	129	100	1435 x 12.7 x 0.65	25:80	230 V single-phase	1	22	705 x 405 x 305
45° D	80	80	80 x 80								
60° D	50	50	50 x 50								

4.3 MACHINE DESCRIPTION

1. Handle
2. Tape tension lever
3. Bow
4. Adjustable front tape guide
5. Vise
6. Vise clamp handle
7. Base
8. Cutting stop
9. Motor
10. Speed variator

5 INSTALLATION

The procedures described below must be performed by qualified and authorized personnel.

5.1 PACKAGING

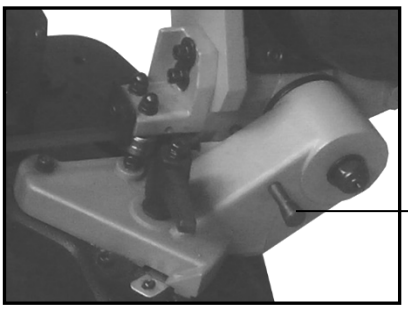
The band saw is packaged in a cardboard box for easy handling and storage.
When unpacking, remove each component of the band saw, check its overall condition, and then proceed with assembly.
The bow of the band saw is locked in the down position for transport using a bow lock handle. To move the bow up, simply pull the bow lock handle.

Check that the machine is clean. The machine is delivered with the ground parts coated with a protective anti-rust oil.
If the product does not appear to be correct or if any parts are broken or missing, contact your dealer.
Keep the instruction manual for future reference.

A small moisture-proof bag may be included in the packaging. Keep it out of the reach of children and dispose of it.

5.2 HANDLING AND TRANSPORT

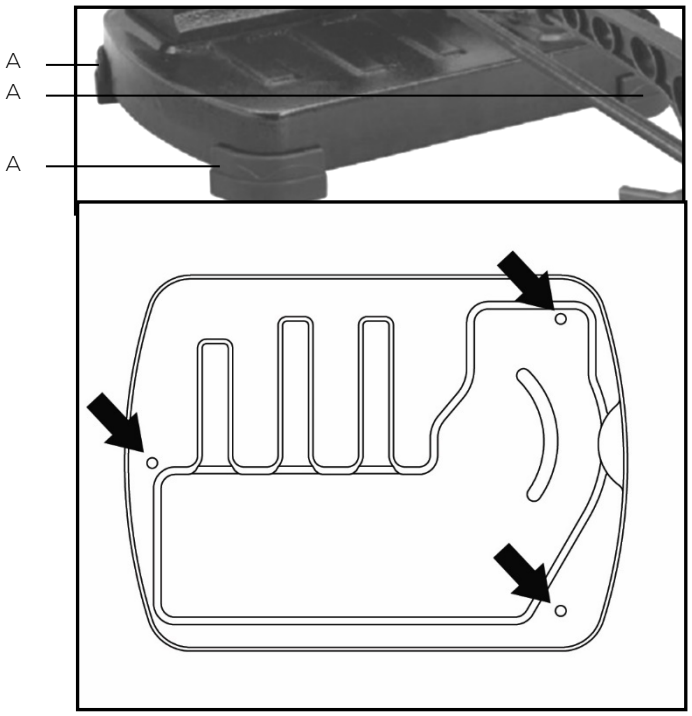
Given the weight (23 kg) and dimensions of the machine, two people are required for handling and installation.
To transport the band saw, always lock the bow in the down position using the bow lock handle (A) provided for this purpose.



5.3 SETTING UP THE MACHINE

Installation environment:

- Power supply voltage in accordance with the machine's specifications.
- Ambient temperature between +5°C and +35°C.
- Relative humidity not exceeding 90%.
- Sufficient ventilation at the installation site.
- Work area sufficiently lit for safe working: lighting must be 500 LUX.

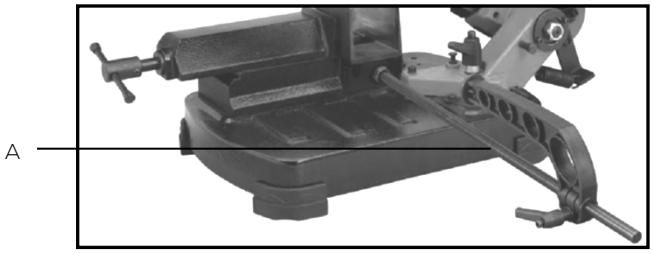


Consider the location of the machine in the room; it must allow for easy movement and maneuvering. Maintain a minimum distance of 800 mm between the rear of the machine and the wall.
Position the workbench on a sufficiently flat and non-slip floor so that it is as stable as possible.
Place the four pads (A) at each corner of the base to ensure the machine is stable.
Carefully position the band saw on a workbench and secure it using the three fixing points (see figure opposite). Check that the band saw is level.
Ensure that no one is in the path of debris and sparks caused by cutting.

5.4 ASSEMBLY

Cutting stop

- Screw the threaded part of the cutting stop (A) into its seat, then lock it in place.



5.5 ELECTRICAL CONNECTION

Electrical work must be carried out by qualified personnel authorized to perform low-voltage electrical work.

ELECTRICAL PRESENCE

Ensure that the supply voltage of the electrical installation corresponds to that of the machine.
Connect using the machine's power cable.
Check that the electrical outlet of the installation is compatible with the machine's plug (2P+E).
The socket used for connection must comply with the "EN 60309-1" standards.
Check that the electrical installation to which the machine will be connected is properly earthed in accordance with current safety standards.
Do not use a welding machine or any other device that could overload the same electrical installation line as the machine.
We remind the user that there must always be a magnetothermal protection device upstream of the electrical installation to protect all conductors against short circuits and overloads.

This protection must always be selected based on the electrical characteristics of the machine, as specified on the nameplate:

- Voltage: 230 V single-phase
- Frequency: 50 Hz
- Motor power: 0.6/1 kW
- Current: 3.6 A
- Protection rating: IP 54

At the end of the machine's power cable is an electrical plug approved (NF EN 60309-1) in accordance with current regulations. The yellow-green protective conductor is on the corresponding terminal marked (earth logo).

Do not use a welding machine or any other device that could overload the same electrical installation line as the machine.

Use of the machine with a damaged power cord is strictly prohibited.
Regularly check the condition of the power cord, switches, and cable gland.

Use a cable reel with a cross-section and length appropriate for the power of the machine, and unroll it completely.
Electrical connections and extension cords must be protected from splashes and kept on dry surfaces.

Do not remove the plug from the electrical outlet by pulling on the cord; pull only on the plug.

Check the direction of tape feed (a pictogram showing the direction of tape feed is displayed on the machine).
The warranty does not cover damage caused by improper connection.

5.6 INITIAL TEST AND INSPECTION BEFORE FIRST USE

- Check that the band saw is securely attached to its frame, that the frame is attached to the workbench, and that the workbench is positioned on a sufficiently flat and non-slip surface so that it is as stable as possible.
- Check that the moving parts are working properly and that there are no damaged components.
- Check that the guards are in place, intact, and in good working order.
- Check the condition of the tape.
- Check the up/down movement of the bow, the ribbon cover, and the rotation of the bow.
- Check that the machine operates perfectly when empty.

6 TAPE

Never install damaged ribbon.
Check that the ribbon is clean.
Install a ribbon that complies with the machine's recommendations for use.

Replace the ribbon when the teeth are worn or broken to avoid additional vibrations and imprecise cuts.

The blade can become very hot during machine operation. Wait for the blade to cool before replacing it.

Only use PEUGEOT OUTILS PROFESSIONNELS blades that comply with the original specifications: 1435 x 12.7 x 0.65 mm.
Always use 0.65 mm thick bands.

Protective gloves must be worn.

6.1 TAPE RECOMMENDATIONS

A. Material classification

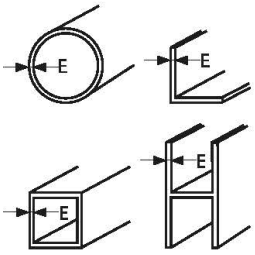
Various parameters such as material hardness, the shape and thickness of the workpiece, the choice of tape, the cutting speed, and the bow descent speed must be taken into account to achieve optimum cutting quality.
Various problems can be solved more easily if the operator is familiar with these specifications.

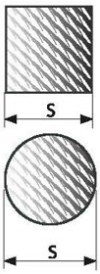
B. Choice of blade

Bands differ mainly in their construction characteristics, such as the shape and angle of the teeth, the tooth pitch, and the set.
To optimize cuts, match the tooth pitch* of the band to the thickness of the workpiece.
As a general rule, when choosing between two tooth patterns, the finer one will result in a longer blade life.
For cutting a bundle of several workpieces of the same shape and size:

1. Determine the tooth pitch for a single workpiece.
2. Choose a larger tooth pitch for batch cutting.

Teeth (= pitch): number of teeth per inch (1 inch = 25.4 mm) (recommended guideline, consult the band manufacturer)

Tubes and profiles	Profile thickness (E) (mm)	Tooth pitch (mm)
	1 to 2	14/18
	2 to 3	10/14
	3 to4	8/12
	4 to 5	6/10
	5 to 7	5/8
	7 to 15	4/6
	15 to 25	3/4
	30 to 50	2/3

Solid materials	Solid section (S) (mm)	Tooth pitch (mm)
	5 to 10	14/18
	10 to 15	10/14
	15 to 20	8/12
	20 to 25	6/10
	25 to 50	5/8
	50 to 75	4/6
	75 to 100	3/4
	150 to 200	2/3

C. Cutting and feed speed

The cutting speed (m/min) and feed rate (cm^2/min = distance traveled by the teeth during chip removal) are limited by the heat generated near the tips of the teeth:

- The cutting speed depends on the strength of the material (R = N/mm^2), its hardness (HRC), and the dimensions of the highest section.
- An excessively high feed rate (or downward movement of the bow) tends to cause the band to deviate from the ideal cutting path, producing non-straight cuts both vertically and horizontally.

D. Tip for using the blade

- The cut is more accurate if the blade guides are close to the workpiece.
- When the blade has just been replaced, reduce the feed rate by about 20% during the first few cuts (running-in time corresponding to a cutting surface of about 300 to 1000 cm^2), then gradually increase the feed rate to the recommended level.
- Lubrication is essential for most metals. For aluminum and its alloys, it helps to remove chips from the teeth in order to obtain a better cutting surface finish. Cast iron, brass, and other non-metallic materials (plastic, graphite, etc.) do not require lubricant.
- The shape of the chips provides information about the cutting pressure and cutting conditions:



6.2 ASSEMBLING/DISASSEMBLING THE TAPE

Disconnect the machine from the power supply before performing this operation.

Principle

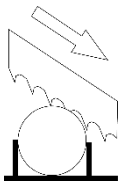
1. Raise the bow completely.
2. Remove the tape guide guard.
3. Remove the ribbon access cover by unscrewing the screws located at each end.
4. Carefully loosen the ribbon using the tension wheel (risk of the ribbon springing back).
5. Carefully remove the defective tape from the pulleys.
6. Clean the belt guides and pulleys (using an air gun) to remove any accumulated chips (the main cause of misaligned cuts).
7. Insert the new blade, paying attention to the position of the teeth, by first positioning it in the blade guides and then on the pulleys.
8. Check that the back of the band (non-cutting part) rests firmly at the bottom of the band guides.
9. Apply slight tension to the blade using the handwheel, ensuring that the blade is perfectly positioned on the pulleys.
10. Refit the removable blade guard.
11. Refit the tape guide guard.
12. Tension the blade.
13. Start up the band saw.
14. Let it run idle for 5 minutes.
15. Tighten the blade again if necessary.

✓ **Loosen the blade at the end of the day.**

To achieve an excellent cut finish and ensure the blade has a long service life, it is essential to choose the correct blade teeth, and to adjust the blade speed and motor speed according to the profile of the workpiece to be cut.

Do not use blades with dimensions other than those specified.

Ensure that the teeth of the band are facing in the correct direction when installing.



7 USE

Follow the specific safety instructions for the band saw (section 3.2).

Before starting operation, familiarize yourself with the controls.

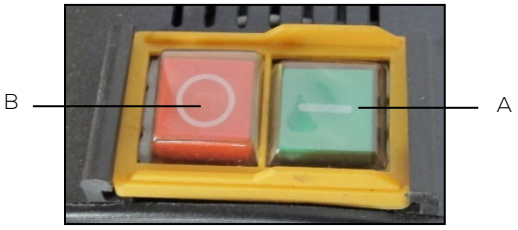
Wearing appropriate personal protective equipment is mandatory.

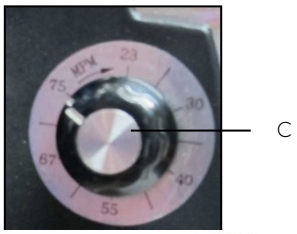
Before any maintenance or servicing, disconnect the machine.

7.1 CONTROL DEVICES

A. Control elements

A. Green "I" switch to start tape rotation
B. Red "0" switch to stop tape rotation
C. Speed variator:
   - 38 m/min (low speed suitable for solid or hard materials)
   - 80 m/min (high speed suitable for thin-walled profiles and tubes)





B. Control handle with trigger switch

- The control handle (H) is used to lower and raise the bow during the cutting process. It consists of a trigger switch (G).
  The trigger switch is used to activate the rotation of the blade.

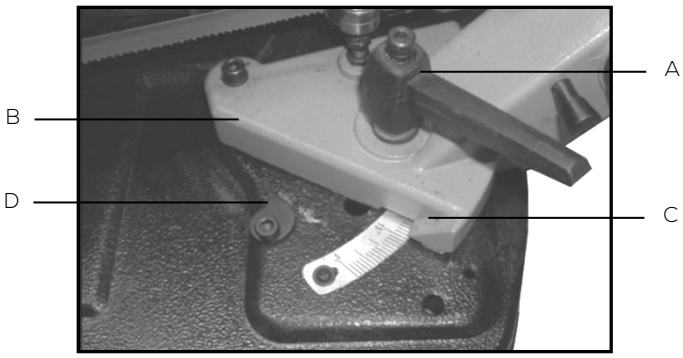
7.2 ADJUSTMENTS

Disconnect the machine from the power supply before performing these operations.

A. Angle cuts

The band saw can be used to make cuts at 0°, 45° right, and intermediate angles:

1. Loosen the handle (A) by turning it counterclockwise (press with your thumb while pulling upward against the spring tension to loosen the handle).
2. Turn the bow support (B) and set it to the desired angle using the mark (C) (angle stops are located at 0° (D) and 45° Right).
3. Tighten the handle (A).



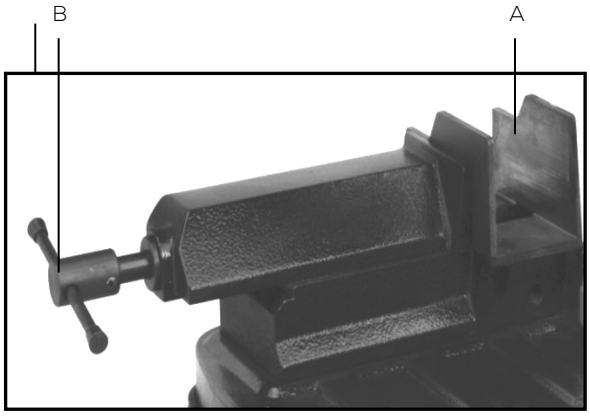
Lock the handle firmly to prevent the bow from changing position during cutting.

B. Vise assembly

The band saw is equipped with a vise:

1. Place the workpiece against the fixed rear vise jaw (A).
2. Tighten the vise completely using the crank handle (B).

Vise opening: 129 mm max.



Before making a cut, ensure that the workpiece is securely clamped in the vise to prevent it from shifting during cutting.

Do not place workpieces to be cut on the vise assembly:
- **During cutting.**
- **When a workpiece is already inserted in the vise.**

C. Belt tension

Before starting the saw, the blade must be sufficiently tensioned to ensure proper cutting conditions:

1. Turn the blade tension wheel (A).
2. Check the blade tension setting: tighten the tension wheel fully and then turn it half a turn. The blade must not be too tight, to prevent it from breaking, nor too loose, to prevent it from slipping off the pulleys.

✓ Loosen the tape at the end of the day.

Use original ribbons to ensure correct ribbon tension.

D. Movable front ribbon guide

For optimal cutting and safe working, adjust the movable front tape guide as close as possible to the workpiece:

1. Loosen the handle (A) on the guide by turning it counterclockwise (press with your thumb while pulling upward against the spring tension to loosen the handle).
2. Slide the guide (B) as close as possible to the workpiece so that it does not interfere with the sawing at the end of the cut.
3. Tighten the handle (A).

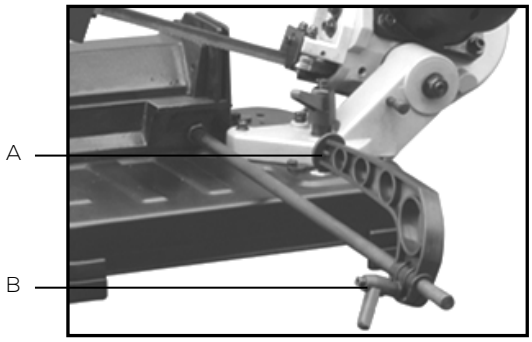
Make this adjustment each time the workpiece dimensions change.

For angle cuts, make sure to adjust the front blade guide so that it does not touch the base of the vise at the end of the cut.

E. Cutting stop

The length of the piece to be cut can be adjusted using the cutting stop:

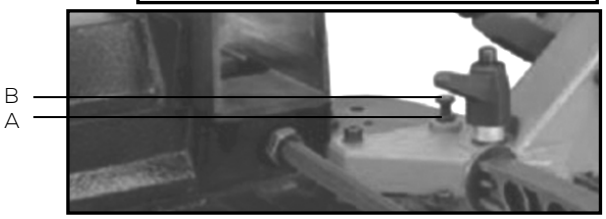
1. Select the desired cutting length.
2. Place the workpiece to be cut in the vise so that its end touches the stop cam (A), then tighten the adjustment handle (B).
3. Lock the workpiece in the vise.
4. Check the length of the workpiece.



F. Bow downstroke

The bow stroke can be adjusted using the depth stop:

1. Loosen the lock nut (A).
2. Tighten or loosen the stop screw (B) as needed.
3. Then retighten the lock nut (A).

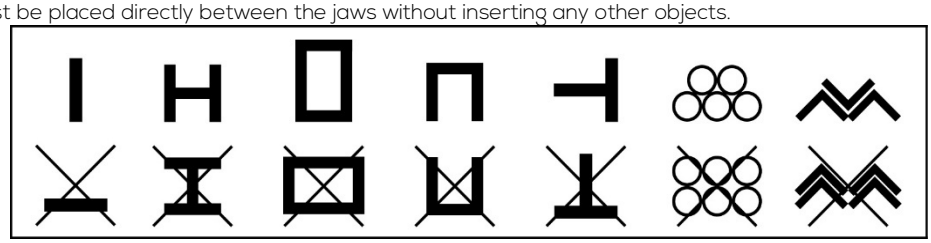


The stop screw (B) must not be tightened too far, as this will cause the tape to cut into the vise base.
Ensure that the stop screw is always at the correct height before starting the machine.

7.3 PLACING PARTS IN THE VISE

Never hold the parts to be cut by hand.

To ensure precise cuts, optimum performance, and increased blade life, the figures below show recommendations for clamping parts in the vise according to their shape (for straight cuts at 0°).
The parts to be cut must be placed directly between the jaws without inserting any other objects.



7.4 CUTTING PROCEDURE

Wearing appropriate personal protective equipment is mandatory.

All operations relating to the cutting procedure must be carried out when the machine's bow is in the rest position and the band is stopped.

Keep hands away from the cutting areas when the machine is in operation.
Stop the machine before positioning the part or removing cutting waste.

Always use the vise: workpieces being cut must be securely clamped in the vise to prevent any projections.

Manually lubricate the machining process with a sufficient amount of cutting fluid.

During use, there is a risk of sparks or hot metal debris being projected.

Do not apply excessive pressure to the tool. Machining performance is not improved by applying high pressure to the tool, but the service life of the tool and machine will be reduced.

A. Cutting instructions

1. Set the bow to the desired cutting angle.
2. Adjust the depth stop.
3. Check that the band is correctly tensioned.
4. Adjust the front movable band guide.
5. Open the vise sufficiently.
6. Insert the workpiece into the vise at the desired length (check its positioning).
7. Secure the workpiece using the vise handle.

B. Cycle operation

1. Press the green "I" switch.
2. Grasp the control handle and press the trigger switch, which will cause the band to rotate.
3. Adjust the speed of the band to the desired value using the speed control.
4. Lower the bow slowly toward the workpiece to be cut, applying constant and correct pressure, avoiding any sudden contact.
5. Raise the bow carefully.
6. Remove the cut piece.

C. Stopping the blade

- Press the red "0" switch.
- Release the trigger switch on the control handle.

✓ Release the tension on the tape at the end of the day.

7.5 OPERATING INCIDENTS

A. Tape jammed in the part

Protective gloves must be worn.

1. Carefully lift the bow.
2. Carefully open the clamp.
3. Carefully remove the workpiece.
4. Check that the tape is not damaged.

B. Power cut

1. Raise the bow.
2. Press the green "I" switch.

The machine is equipped with a very low voltage electrical system (24 V TBT) with a voltage failure device (preventing any unexpected restart).

7.6 TABLE OF FAULTS AND SOLUTIONS

FAULTS	SOLUTIONS
Premature wear:	Reduce speed. Increase the pressure of the bow to keep the teeth in contact with the material. Use a lubricant suitable for the material being cut. Spray the cut excessively for mild, extra mild, and non-ferrous steels. Check that the tape is mounted in the correct direction.
Belt vibrations during cutting:	Increase or decrease the speed of the band. Increase the pressure. Increase the blade tension. Use a finer pitch. Hold the workpiece more firmly.
Tooth breakage:	Use a finer pitch (for thin materials) or increase the pitch in other cases. Reduce the pressure. Hold the workpiece more firmly. Reduce the feed rate.
Insufficient surface finish:	Increase the cutting speed. Reduce pressure. Use a finer pitch. Lubricate the cut.
Convex or concave faces or tape kickback:	Reduce the feed rate. Increase the tension of the tape. Use a larger band pitch. Adjust the movable tape guide as close as possible to the workpiece. Adjust the play of the ribbon guides as close as possible to the ribbon. Reduce the pressure.
Premature ribbon breakage:	Reduce the speed. Reduce the pressure. Decrease the ribbon tension. Check the surface condition of the tape pulleys. Adjust the movable ribbon guide as close as possible to the workpiece. Lubricate the cut. Check the tape welding parameters.
Chip jamming in the tooth:	Use a larger pitch. Reduce the descent of the bow. Increase the cutting speed. Lubricate the cut.
Poor contact between the tape and the guides:	Check the alignment of the tape pulleys. Check the wear on the tape guides and replace them if necessary.
Insufficient sawing speed:	Increase the cutting speed. Use a larger pitch. Increase the pressure. Lubricate the cut.
Premature disappearance of the ribbon path:	Belt too wide for the radius to be cut. Reduce the cutting speed. Lubricate the cut.

8 MAINTENANCE

Disconnect the machine from the power supply before performing these operations.
Wear gloves and protective eyewear, and use a brush and a clean, dry cloth for all cleaning operations (especially when removing chips).

Do not use solvents or aggressive detergents.
Do not use compressed air to remove machining chips.
Do not immerse the machine in water or wash it with a water jet.

Chips are often very sharp and hot. Do not touch them with your bare hands.

To maintain the efficiency of the machine and its components, it is necessary to perform maintenance on the machine.
Below are the most important maintenance tasks, which can be classified according to their frequency as daily, weekly, or monthly tasks.

Failure to perform the prescribed tasks will result in premature wear and tear and reduce the performance of the machine.

8.1 ●○○ DAILY MAINTENANCE

- Clean the machine as normal to remove any chips that have accumulated (collect them in bins).
- Check that the motor ventilation grille is clear.
- Check that the belt is not worn and/or the teeth broken.
- Raise the bow completely and allow the belt to hang slightly to avoid unnecessary strain.
- Check that the protective covers, safety devices, and stop mechanisms are working properly.

8.2 ●●○ WEEKLY MAINTENANCE

- Thoroughly clean the machine, removing any chips from the cutting fluid reservoir (collect them in containers).
- Clean the tape guides (pads and cutting fluid outlet).
- Clean the tape pulley housings and the tape sliding surfaces on the pulleys.
- Check that the screws are tight.

8.3 ●●● MONTHLY MAINTENANCE

- Check that the motor pulley screw is tight.
- Check that the tape guide components are working properly.
- Check that the screws on the motor and protective covers are tight.
- Check and replace the power cable if necessary.

8.4 ●●● SIX-MONTHLY MAINTENANCE

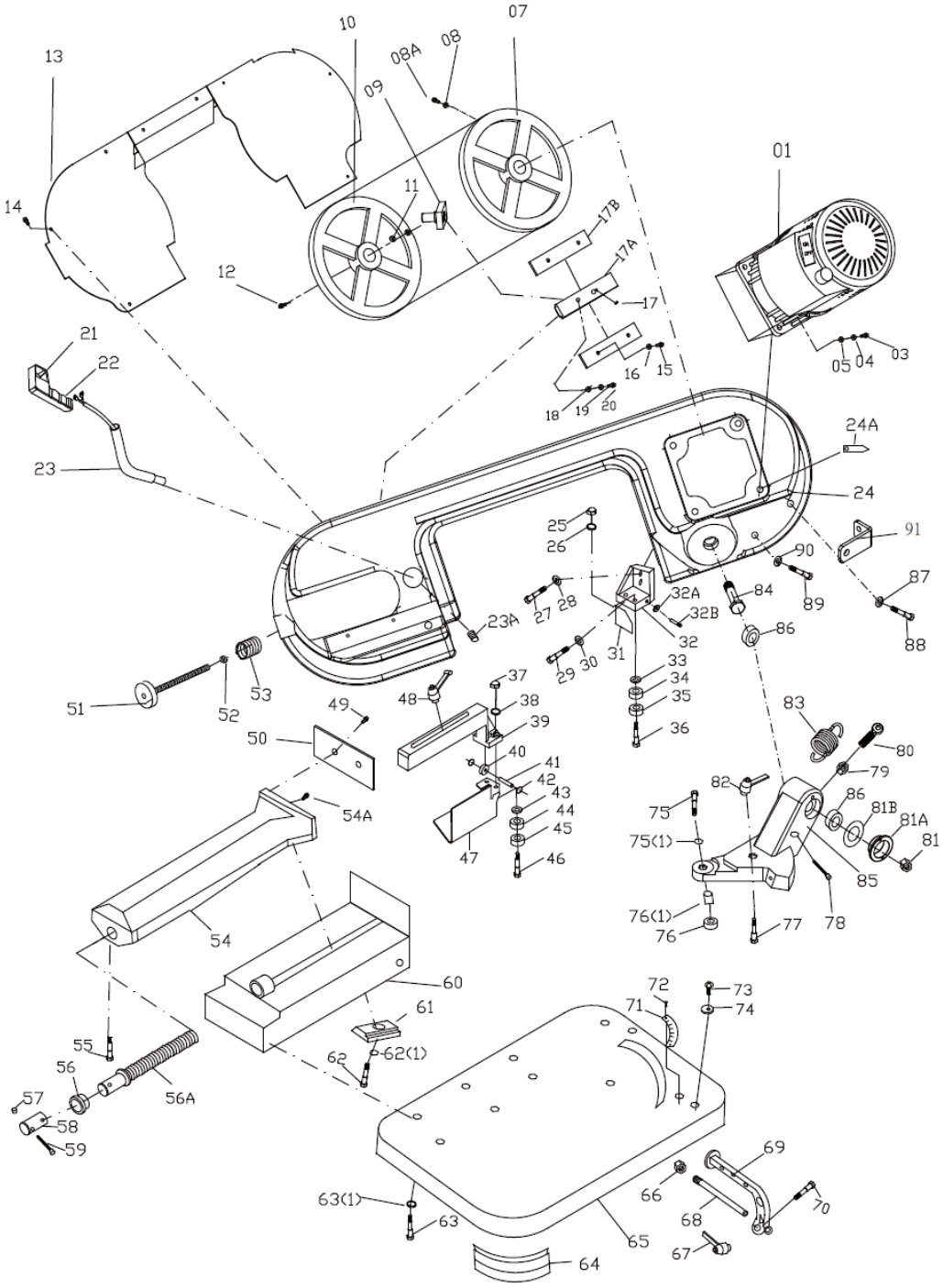
- Test the continuity of the equipotential protection circuit.

8.5 ●●○ TAKING THE MACHINE OUT OF SERVICE

1. Disconnect the plug from the power supply.
2. Loosen the tape.
3. Carefully clean and lubricate the machine.
4. Cover the machine if necessary.

9 EXPLODED VIEW

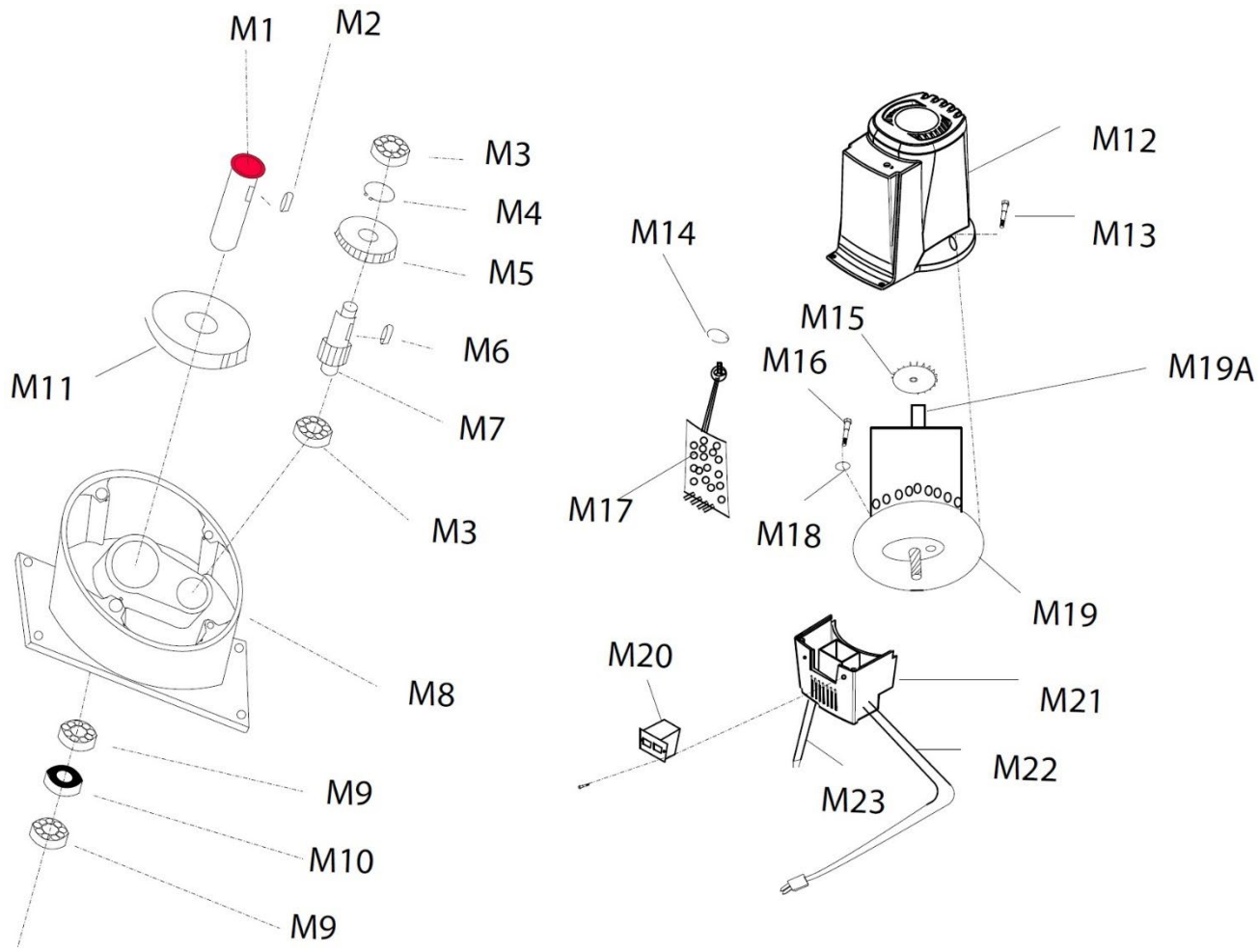
EXPLODED VIEW PSR125MVE (VIEW 01)



PARTS LIST EXPLODED VIEW PSR125MVE (VIEW 01)

Part	Description	Quantity	Part number	Description	Quantity
1	MOTOR ONLY 1KW 230V Single-phase	1	48	CLAMPING HANDLE	1
3	8x25 SCREW	4	49	Screw	1
4	M8 SPRING WASHER	4	50	CLAMP PLATE	1
5	WASHER M8x16x2	4	51	TENSION WHEEL TAPE	1
7	DRIVE PULLEY	1	52	WASHER	1
8	M6 WASHER	1	53	M10 BELLEVILLE WASHER	8
8A	Screw	1	54	MOBILE VISE #RAL 9004	1
9	TENSION PULLEY SUPPORT	1	54A	SCREW	1
10	TENSION PULLEY	1	55	4x6 SCREW	1
11	BEARING 6201ZZ	2	56	GUIDE BUSHING	1
12	8x16 SCREW	1	56A	WHEELBOLT	1
13	BOW CASE	1	57	CRANK	2
14	4x8 SCREW	4	58	VISE HANDLE SUPPORT	1
15	5x10 SCREW	4	59	CRANK	1
16	M5 SPRING WASHER	4	60	BASE #RAL 9004	1
17	SCREW 8x16	1	61	FLANGE	1
17A	SLIDING TENSION BLOCK TAPE	1	62	M6X20 BLACK HEXAGON HEAD SCREW	1
17B	TAPE TENSION SLIDE	2	62(1)	Washer	1
18	WASHER M8x16x2	4	63	M8 SPRING WASHER	6
19	M8 SPRING WASHER	4	63(1)	SCREW 8x16	1
20	8x25 SCREW	4	64	SKATE	4
21	TRIGGER BUTTON CONTROL HANDLE	1	65	TABLE #RAL 9004	1
22	TRIGGER HANDLE	1	66	M12 NUT	1
23	CONTROL ARM	1	67	CLAMPING HANDLE	1
23A	M6x8 SCREW	1	68	CUTTING STOP AXLE	1
24	BOW #RAL 2008	1	69	CUTTING STOP	1
24A	SET OF 3 BIMETAL TAPE M42 XPLR+LSCR 1440 X 13 X 0.6 - 10/14 TEETH	4	70	6x20 SCREWS	1
25	M6 NUT	2	71	BOW ANGLE GRADUATION	1
26	M6 WASHER	2	72	4x8 SCREW	1
27	6x25 SCREW	2	73	6x12 SCREW	2
28	M6 WASHER	2	74	CUTTING ANGLE STOP 6*21*3	2
29	SCREW 5x10	1	75	6x35 SCREW	1
30	Washer	1	75(1)	M6 NUT	1
31	FIXED REAR TAPE GUIDE PROTECTION	1	76	SPACER	1
32	FIXED REAR TAPE GUIDE	1	76(1)	3/8x11/2 SCREW	1
32A	BEARING 625 ZZ	1	77	BOW LOCKING AXLE	1
32B	PIN	1	78	NUT	1
33	Washer	2	79	TENSION HOOK	1
34	BEARING 607 Z	2	80	LUG NUT	1
35	BEARING 607 Z	2	81	SOCKET	1
36	ECCENTRIC AXLE	2	81A	BEARING COVER	1
37	M6 NUT	2	81B	CLAMP HANDLE BOW SUPPORT 3/8	1
38	Washer	2	82	RETURN SPRING FOR SR 125 MV BAND SAW	1
39	MOBILE FRONT BAND GUIDE	1	83	BOW SUPPORT AXIS	1
40	BEARING 625 ZZ	2	84	ROTATION SUPPORT #RAL 2008	1
41	PIN	2	85	BEARING 30202	1
42	M5 WASHER	2	86	WASHER	2
43	Washer	2	87	Screw	1
44	Bearing 607	2	88	SCREW	1
45	Bearing 607	2	89	NUT	1
46	ECCENTRIC AXLE	2	90	SPRING PLATE	1
47	MOBILE FRONT TAPE GUIDE PROTECTION	1	91	6x12 SCREW	1

EXPLODED VIEW OF PSR125MVE MOTOR (VIEW 02)

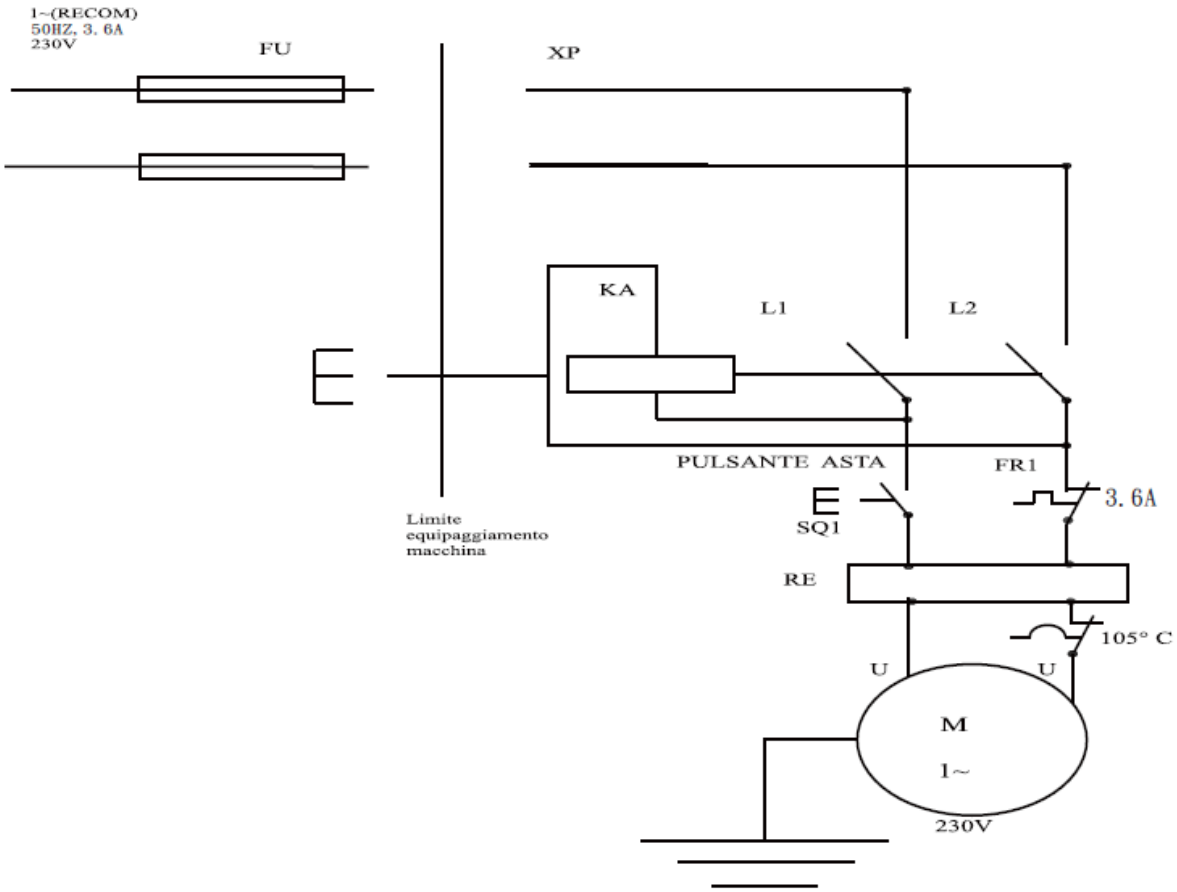


PSR125MVE ENGINE EXPLODED VIEW NOMENCLATURE (VIEW 02)

Part number	Reference	Description	Quantity	Note
M1		REDUCTOR SHAFT	1	
M2		KEY 5x5x10	1	
M3		BEARING 607	2	
M4		CIRCLIPS	1	
M5		LOWER SPROCKET	1	
M6		KEY 4x4x6	1	
M7		PINION AXLE	1	
M8		GEARBOX	1	
M9		BEARING 6202	2	
M10		OIL SEAL 15x32x7	1	
M11		UPPER PINION	1	
M12		UPPER ENGINE COVER	1	
M13		4x10 SCREW	1	
M14		M6 NUT	1	
M15		FAN	1	
M16		SCREW 5x20	1	
M17		COMPLETE ELECTRONIC BOARD	1	
M18		OIL SEAL	1	
M19		ENGINE	1	
M19A		MOTOR SHAFT	1	
M20		ON/OFF SWITCH	1	
M21		LOWER MOTOR COVER	1	
M22		POWER CABLE	1	
M23		TRIGGER SWITCH CABLE	1	

10 ELECTRICAL DIAGRAM

ELECTRICAL DIAGRAM PSR125MVE



Reference	Description	Quantity
KA	CE protector	1
SB1	OFF switch	1
SB2	Main switch (ON)	1
XP	Power cable	1
SQ1	On/off switch	1
M	1010W motor	1
FR1	Thermal protector	1
RE	Inverter	1

11 NOISE LEVEL

The data relating to the noise level emitted by this machine during operation will depend on the type of material being ground and the type of grinding wheel. For this reason, the measurement data is relative.

The risk of hearing damage to the operator depends on the length of exposure to noise.
The operator must wear ear defenders or other appropriate personal protective equipment when the sound power exceeds 85 dB(A) in the workplace.

- Sound pressure level (1 m at no load):
  LpA = 69.5 dB(A)
- Sound power level (1 m at no load):
  LwA = 74.9 dB(A)

The sound power was calculated taking into account factors such as: reverberation at the test site, ground noise absorption, and other factors that may interfere with measurements. This estimate allows us to state that the degree of error in the values obtained would be around 3 dB(A).

The values given are emission levels and not necessarily levels that allow for safe working. Although there are correlations between emission levels and exposure levels, these cannot be used reliably to determine whether additional precautions are necessary. Parameters that influence actual exposure levels include workshop characteristics, other sources of noise, etc., i.e., the number of machines and neighboring manufacturing processes. In addition, permissible exposure levels may vary from country to country. However, this information allows the machine user to make a better risk assessment.

12 VIBRATION LEVEL

The data relating to the vibrations transmitted by this machine during the work process will depend on the type of material used and the type of disc. For this reason, the measurement data is relative.
Exposure to vibrations can have serious consequences for the health of workers. A person exposed daily to high-amplitude vibrations may develop neurological and joint disorders in the long term.
These values must be taken into account when assessing the level of exposure.
Regular and frequent exposure to a highly vibrating work disc exposes workers' hands and arms to chronic disorders known as "vibration syndrome."

- Average hand/arm vibration level:
  A(8) < 1.02 m/s²

The exposure level assessment is based on the calculation of the daily exposure value A(8), normalized to a reference period of 8 hours.
Whenever an employee is exposed to A(8) vibrations exceeding the daily exposure action level set at 2.5 m/s², the employer must assess the risks of the task assigned to the employee and implement control measures.
Exposure values for vibrations transmitted to the hand-arm system:

- Daily exposure limit value:
  A(8) = 5 m/s²
- Daily exposure value triggering action:
  A(8) = 2.5 m/s²

13 ENVIRONMENTAL PROTECTION

Your machine contains many recyclable materials.
This logo indicates that used machines must not be mixed with other waste.
This will ensure that the machines are recycled under the best conditions, in accordance with European Directive 2012/19/EU on waste electrical and electronic equipment.
Contact your local council or dealer to find out where your nearest collection points for used machines are located.
Thank you for your cooperation in protecting the environment.

14 WARRANTY

If the machine is covered by warranty, it must be serviced exclusively by an authorized after-sales service center.
The machine warranty is valid for 2 years from the date of purchase by the user.
This product benefits from an additional 2-year warranty extension, provided that the user registers the product on the PEUGEOT OUTILS PROFESSIONNELS website (www.peugeot-outils-pro.com) within 30 days of the date of purchase. This warranty extension is subject to the same conditions as the initial warranty.
Accessories and consumables are not covered by the warranty.
It is important to keep the invoice, which serves as the warranty certificate.
The warranty is limited to the repair or replacement of defective parts free of charge, after evaluation by the manufacturer.
For any requests for information or spare parts relating to the machine, it is essential to provide the exact information shown on the nameplate.
The warranty does not cover damage caused by the user or by a repairer not approved by Tivoly.
Link to the General Warranty Terms and Conditions:

15 DECLARATION OF CONFORMITY

CE AL DECLARATION OF CONFORMITY "ORIGINAL"

The undersigned (Manufacturer/Importer):

TIVOLY

266 ROUTE PORTES DE TARENTAISE 73790 TOURS-EN-SAVOIE

Declares that the following new machine:

- Designation: MANUAL BAND SAW
- Brand: PEUGEOT OUTILS PROFESSIONNELS
- Model: PSR125MVE
- Reference: PPM00300001
- Serial number:

Complies with applicable harmonized legislation:

- **Machinery Directive 2006/42/EC (until January 19, 2027)**
- **EU Regulation 2023/1230 (from January 20, 2027)**

Complies with the essential safety requirements applicable to it:

- **Low Voltage Directive 2014/35/EU**
- **Electromagnetic Compatibility Directive 2014/30/EU**
- **WEEE Directive 2012/19/EU**
- **RoHS-2 Directive 2011/65/EU**
- **REACH 1907/2006**
- **Noise Directive 2003/10/EC**
- **Vibration Directive 2002/44/EC**

Done at TOURS-EN-SAVOIE
On

Stéphane Le Mounier
Managing Director

Person authorized to compile the technical file:

- Mr. LE MOUNIER – TIVOLY – 266 ROUTE PORTES DE TARENTAISE 73790 TOURS-EN-SAVOIE