



Operating Instructions and Parts Manual

Arbor Press— ½-, 1-, 2-, 3-, 5-Ton

Model AP-0, AP-1, AP-2, AP-3, AP-5HD



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2.0 Safety Instructions

⚠ WARNING

Failure to follow these rules may result in serious personal injury

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This arbor press is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of an arbor press, do not use until proper training and knowledge have been obtained.
5. Do not use this arbor press for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this arbor press. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Do not operate this arbor press while tired or under the influence of drugs, alcohol, or any medication.
8. Make sure this arbor press is firmly secured to the floor or bench before use.
9. Check damaged parts. Before further use of the arbor press, a part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
10. Provide for adequate space surrounding work area and non-glare, overhead lighting.
11. Keep the floor around the arbor press clean and free of scrap material, oil and grease.
12. Keep visitors a safe distance from the work area. Keep children away.
13. Make your workshop child proof with padlocks, master switches or by removing starter keys.
14. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
15. Maintain a balanced stance at all times so that you do not fall into the arbor press. Do not overreach or use excessive force to perform any machine operation.
16. Use recommended accessories; improper accessories may be hazardous.
17. Make sure the work piece is securely attached or clamped to the table.
18. Remove loose items and unnecessary work pieces from the area before starting the machine.
19. Do not overload the arbor press by using extension (cheater) bars.
20. Use steel collars to support parts when pressing on bearings to prevent damage to the bearings.

Familiarize yourself with the following safety notices used in this manual:

⚠ CAUTION

This means that if precautions are not heeded, it may result in minor injury and/or machine damage.

⚠ WARNING

This means that if precautions are not heeded, it may result in serious injury or death.

⚠ DANGER

This means that if precautions are not heeded, it will result in serious or fatal, injury.

Save the Instructions

3.0 About This Manual

This manual is provided by Baileigh Industrial, covering the safe operation and maintenance procedures for a Baileigh Model AP-0, AP-1, AP-2, AP-3, AP-5HD Arbor Press – ½-, 1-, 2-, 3-, 5-Ton. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

Technical Support handles questions on setup, operation, schematics, warranty issues, and individual parts needed. Our Technical Support department can be reached at 920-684-4990.

If there are questions or comments, please contact your local supplier or Baileigh Industrial. We can also be reached at our web site: www.baileigh.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

WARNING

Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

Register your product online -

<https://baileigh.com/product-registration>



4.0 Product Dimensions

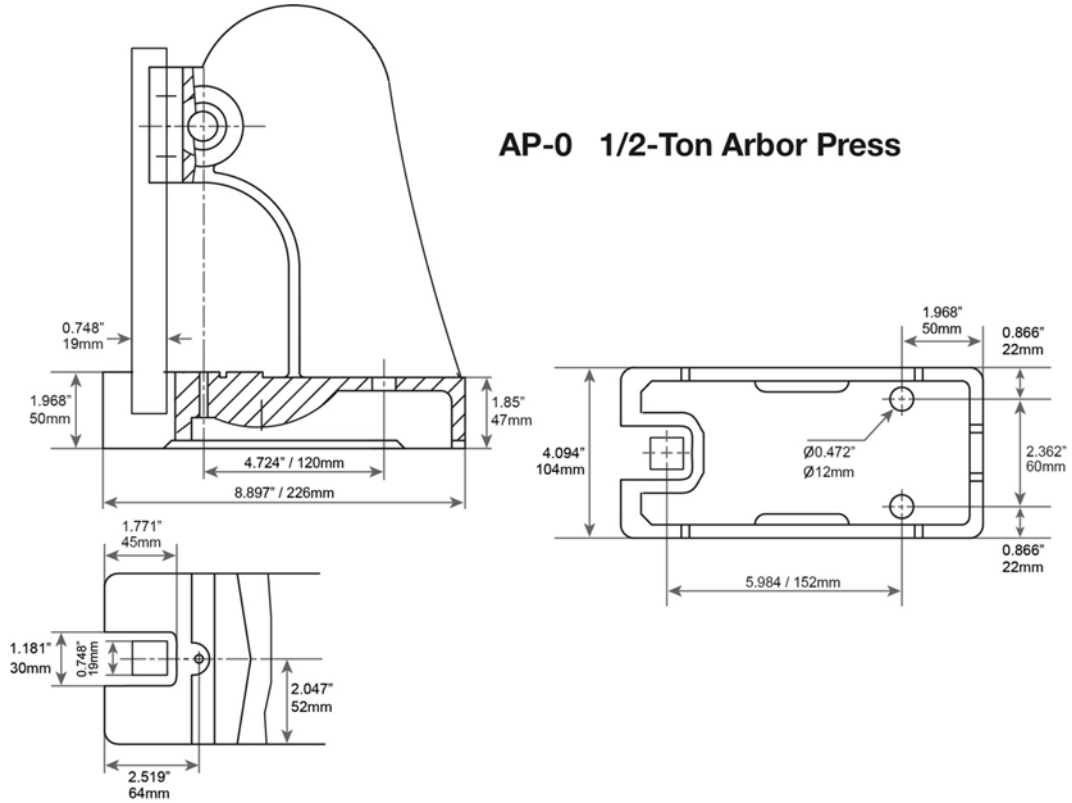


Figure 4-1

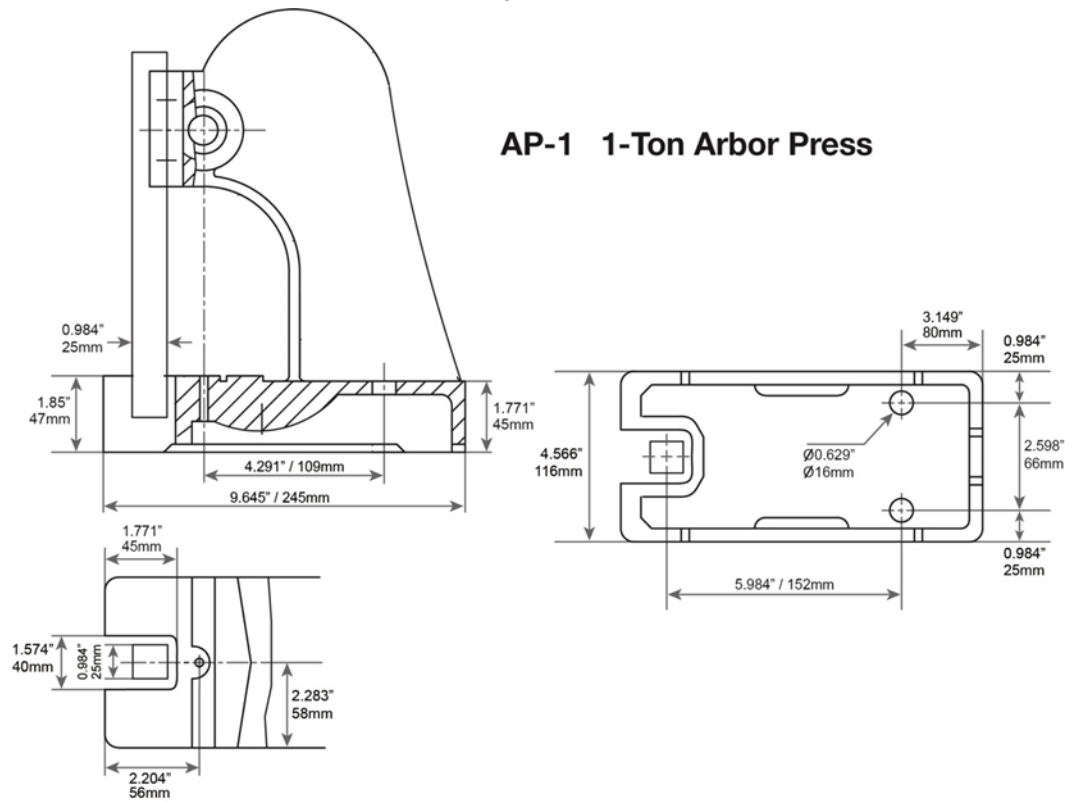


Figure 4-2

AP-2 2-Ton Arbor Press

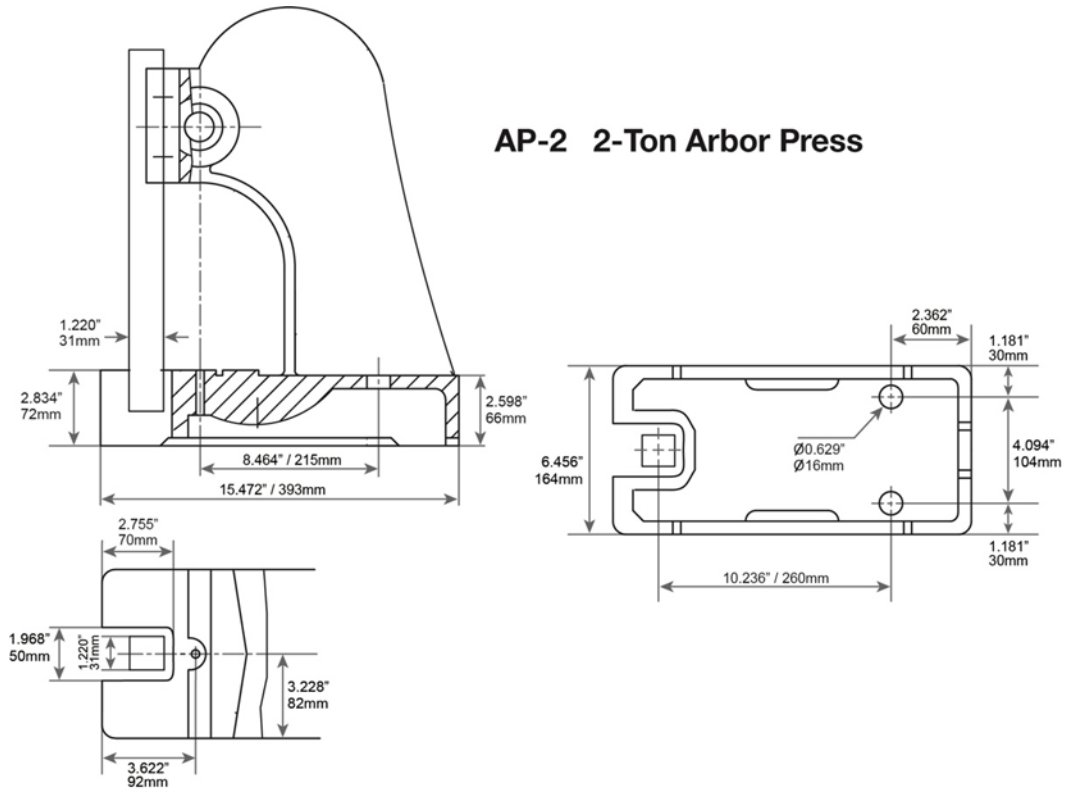


Figure 4-3

AP-3 3-Ton Arbor Press

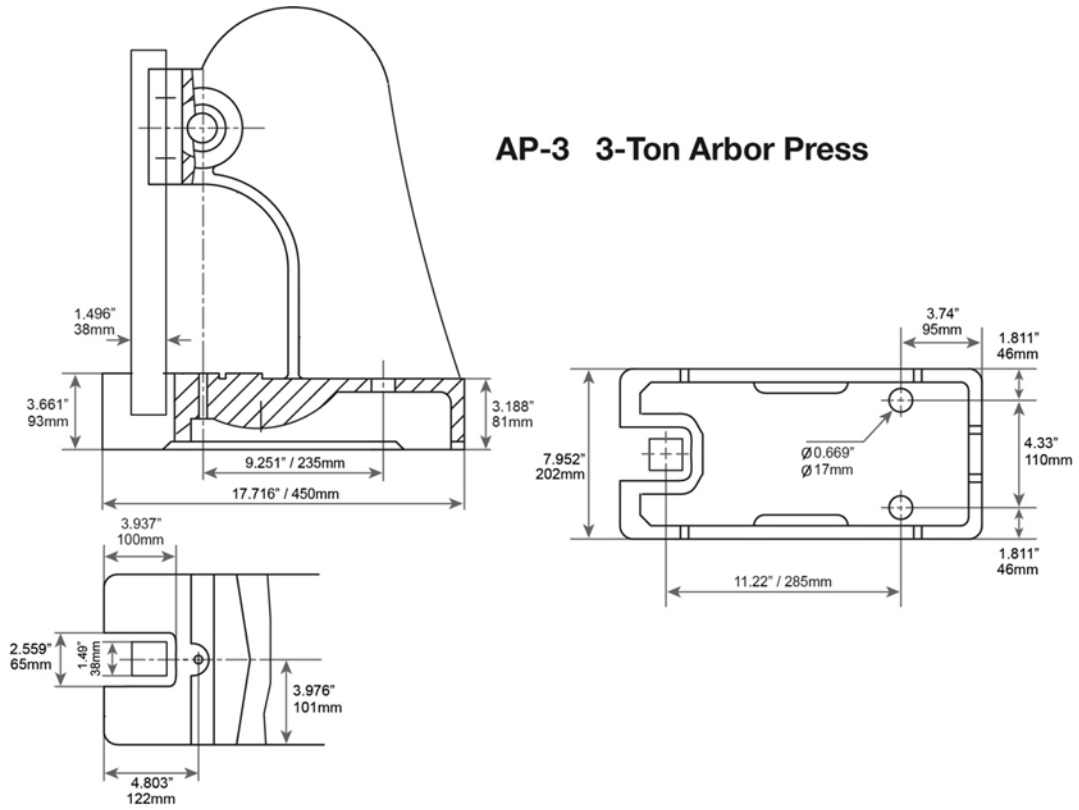
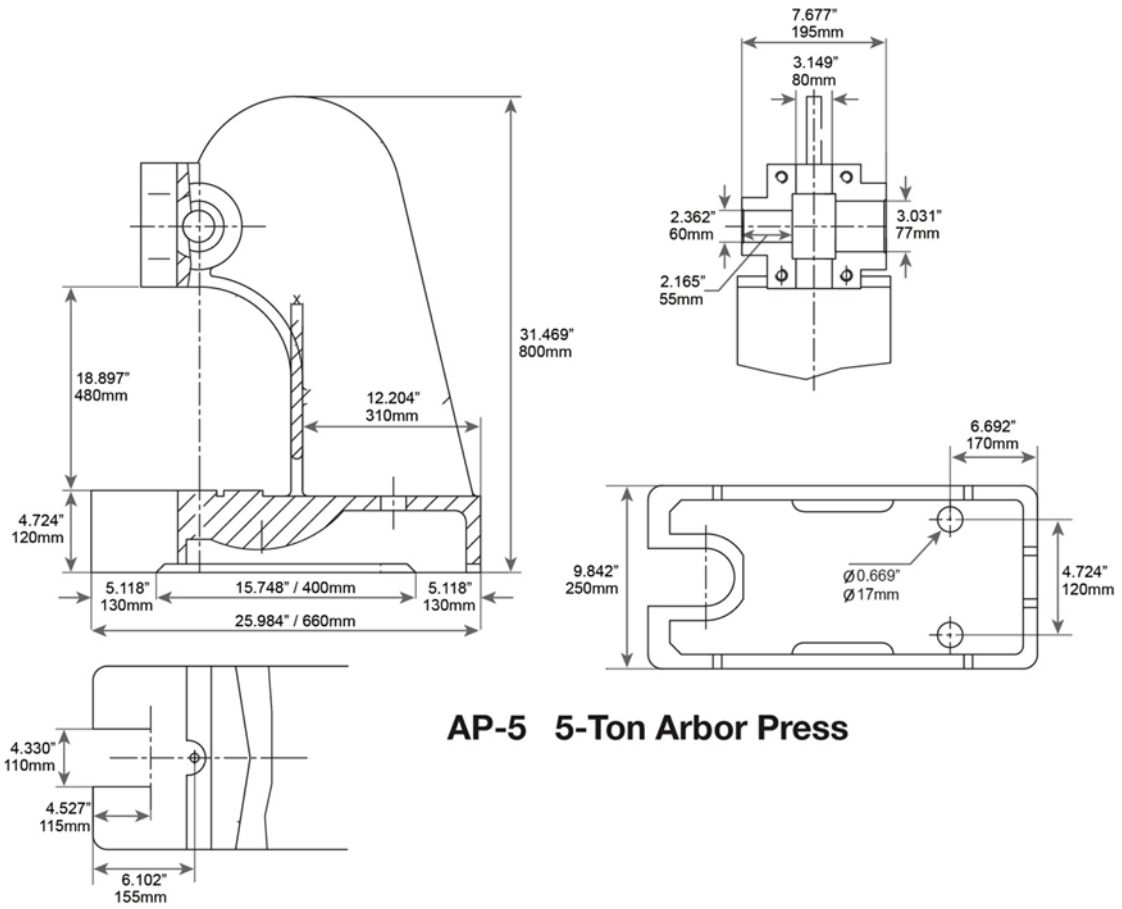


Figure 4-4



AP-5 5-Ton Arbor Press

Figure 4-5

5.0 Specifications

Table 5-1

Model Number	AP-0	AP-1	AP-2	AP-3	AP-5HD
Stock Number	BA9-1232697	BA9-1232698	BA9-1232699	BA9-1232700	BA9-1232701
General Specifications					
Pressure (ton)	½ Ton	1 Ton	2 Ton	3 Ton	5Ton
Max Work Height (in.)	4-3/4	5	7-1/2	11-1/2	17
Diameter of Work (in.)	6-5/8	8	10-3/4	11-3/8	17
Anvil Diameter (in.)	3-1/2	3-1/2	6-11/16	6-11/16	9-3/4
Size of Ram (in.)	3/4 x 7-7/8	1 x 9-1/8	1-1/4 x 13	1-1/2 x 18	2 x 27-1/2
Ram Bore (in.)	3/8	3/8	1/2	1/2	1/2
Ram Travel (in.)	4.72	5.9	9.05	12.6	18.1
Base Size (in.)	4 x 8-15/16	5 x 9-1/2	6-3/8 x 15-3/4	8-1/2 x 18	9-7/8 x 26
Weights and Dimensions					
Overall Dimensions:					
Length (in.)	9-5/16	9-1/2	15-3/4	18-1/8	27
Width (in.)	6-5/8	7-1/2	10	10-1/4	13
Height (in.)	10-3/8	12	17-1/2	22-1/2	31-1/2
Net Weight (lb.)	17-1/2	25-1/2	67-1/2	108	262
Shipping Weight (lb)	19	26-1/2	69-1/2	116	296-1/2

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, Baileigh Industrial reserves the right to change specifications at any time and without prior notice, without incurring obligations.

WARNING

Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

6.0 Setup and Operation

6.1 Arbor Press Features

The arbor press consists of a cast iron base, an anvil, a pressing handle with lock knob, and a rack-type ram.

The removable anvil has four cutouts used for pressing on or off bearings or various sized bushings.

6.2 Set-up and Operation

Note: Numbers in parentheses below correspond to item numbers in the exploded view on page 8.

WARNING

Do not use the arbor press without first mounting the arbor press to the workbench and anchoring the workbench to the floor. Mount the arbor press to the workbench using bolts and using the holes in the base (1).

6.3 Changing Ram Position

The ram has a flat surface on one end and a hole on the other end. The hole is used to accept the punch inserts. Change-out the ram as follows:

1. Remove the handle by loosening the knob (17). Remove one cap (5) from the handle assembly. Remove handle (6) from the pinion (16).
2. Remove the pinion retainer (14) by backing off the Set Screw (13). Slide the pinion retainer (14) off of the pinion (16).
3. Pull up on the ram (4) to provide slack and remove the pinion (16) from the arbor press.
4. Pull the ram (4) out the top of the arbor press body. Turn the ram (4) end-for-end.

Tip: If ram does not freely come out of arbor press body, loosen the two hex nuts (11) on side of arbor press body and the two hex nuts (11) on the front plate (12).

5. Repeat steps 1 – 4 in reverse.

6.4 Maintenance

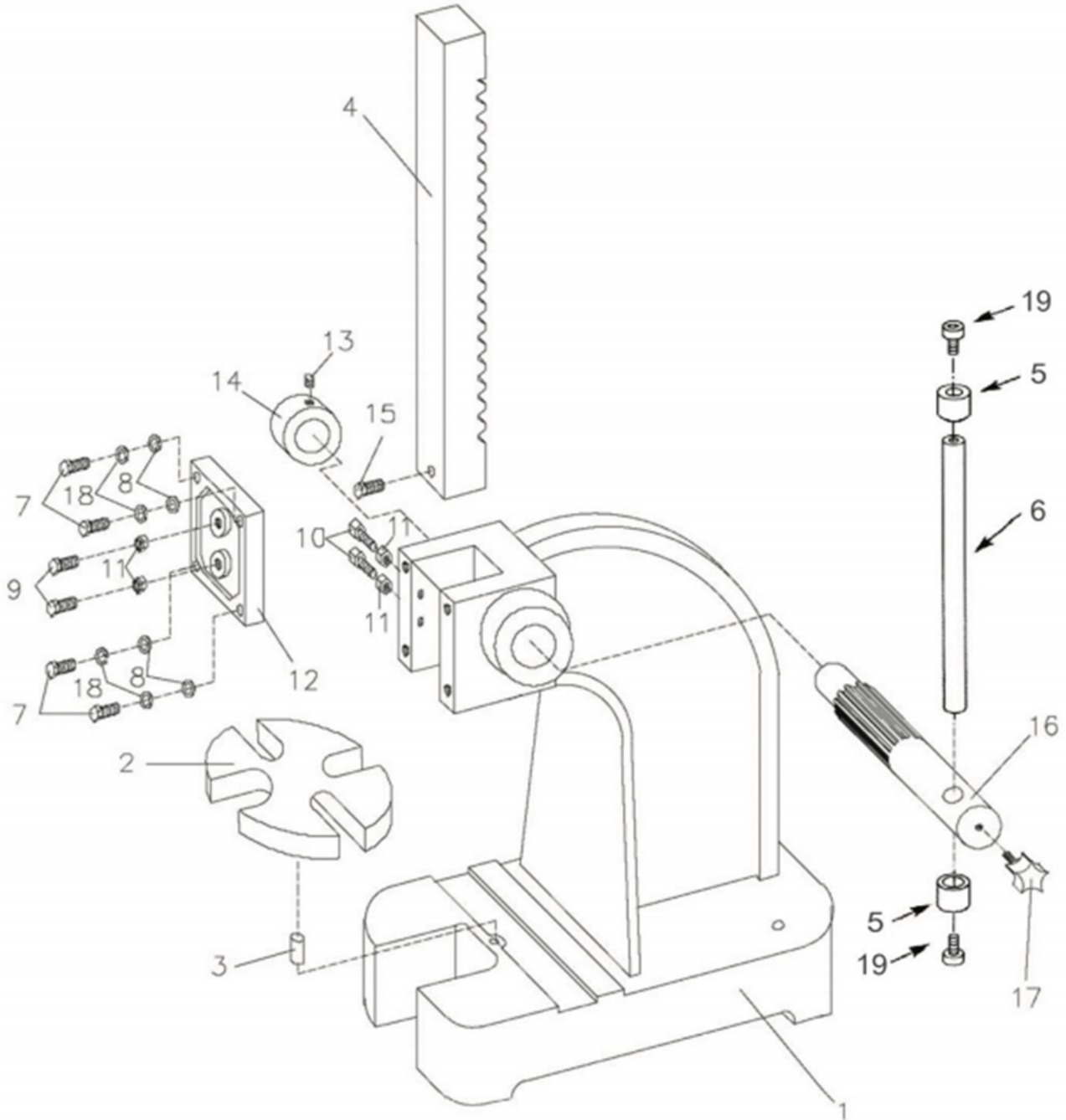
1. Periodically lubricate the arbor press with a light machine oil.
2. Wipe off or vacuum the accumulated debris and dust after using the arbor press.
3. Periodically check the ram for side-to-side and front-to-back play. If the play is excessive, loosen the hex nuts (11) and adjust (tighten) the screws (10 on side, 9 in front) just enough to eliminate the excess play. Tighten them equally to assure even contact with the ram (4).
4. Once the play is eliminated, hold the screw (10 or 9) in position and tighten the hex nut (11). Check to make sure the amount of play is acceptable.

7.0 Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from Baileigh Industrial. Some parts are shown for reference only and may not be available individually.

7.1.1 AP-0, AP-1, AP-2, AP-3, AP-5HD Assembly – Exploded View



7.1.2 AP-0 – 1/2-Ton Arbor Press Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
1	JT9-AP0-01G	Base		1
2	JT9-AP0-06G	Anvil		1
3	JT9-AP0-16	Spring Pin	6x16	1
4	JT9-AP0-02	Ram		1
5	JT9-AP0-5-1	Cap		5
6	JT9-AP0-6-1	Handle		1
7	JT9-TS-1482051	Bolt, Hex	M6x25	4
8	CM9-TS-1550041	Washer	M6	4
9	JT9-TS-1482051	Bolt, Hex	M6x25	2
10	JT9-TS-1482061	Bolt, Hex	M6x30	2
11	CM9-TS-2311061	Nut, Hex	M6	4
12	JT9-AP0-12G	Plate		1
13	JT9-TS-1523011	SHSS	M6x6	1
14	BA1-10738	Pinion Retainer		1
15	JT9-TS-1482021	Bolt, Hex	M6x12	1
16	JT9-AP0-03	Pinion		1
17	BA1-10739	Knob		1
18	CM9-TS-2361061	Lock Washer	M6	4
19	**	Bolt, Hex	M5x12	2
	JT9-AP0-19	ID Label (not shown)		1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

7.1.3 AP-1 – 1-Ton Arbor Press Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
1	JT9-AP1-01G	Base		1
2	JT9-AP1-06G	Anvil		1
3	JT9-AP0-16	Spring Pin	6x16	1
4	JT9-AP1-02	Ram		1
5	JT9-AP1-5-1	Cap	M6	5
6	JT9-AP1-6-1	Handle		1
7	JT9-TS-1482051	Bolt, Hex	M6x25	4
8	CM9-TS-1550041	Washer	M6	4
9	JT9-TS-1482051	Bolt, Hex	M6x25	2
10	JT9-TS-1482061	Bolt, Hex	M6x30	2
11	CM9-TS-2311061	Nut, Hex	M6	4
12	JT9-AP1-12G	Plate		1
13	JT9-TS-1523011	SHSS	M6x6	1
14	JT9-AP1-10	Pinion Retainer		1
15	JT9-TS-1482021	Bolt, Hex	M6x12	1
16	BA1-10740	Pinion		1
17	JT9-AP1-05	Knob		1
18	CM9-TS-2361061	Lock Washer	M6	4
19	**	Bolt, Hex	M5x12	2
	JT9-AP1-19	ID Label (not shown)		1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

7.1.4 AP-2 – 2-Ton Arbor Press Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
1	**	Base		1
2	JT9-AP2-06G	Anvil		1
3	JT9-AP2-16	Spring Pin	M6x25	1
4	JT9-AP2-02	Ram		1
5	JT9-AP2-5-1	Cap	M6	5
6	JT9-AP2-6-1	Handle		1
7	JT9-TS-1490051	Bolt, Hex	M8x30	4
8	JT9-TS-1550061	Washer	M8	4
9	JT9-TS-1490051	Bolt, Hex	M8x30	2
10	JT9-TS-1490051	Bolt, Hex	M8x30	2
11	JT9-TS-1540061	Nut, Hex	M8	4
12	JT9-AP2-12G	Plate		1
13	JT9-TS-1523011	SHSS	M6x6	1
14	JT9-AP2-10	Pinion Retainer		1
15	JT9-TS-1490021	Bolt, Hex	M8x16	1
16	JT9-AP2-03	Pinion		1
17	JT9-AP2-05	Knob		1
18	CM9-TS-2361081	Lock Washer	M8	4
19	**	Bolt, Hex	M5x12	
	JT9-AP2-19	ID Label (not shown)		1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

7.1.5 AP-3 – 3-Ton Arbor Press Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
1	**	Base		1
2	JT9-AP3-06G	Anvil		1
3	JT9-AP2-16	Spring Pin 6x25	M6	1
4	JT9-AP3-02	Ram		1
5	JT9-AP3-5-1	Cap	M6	5
6	JT9-AP3-6-1	Handle		1
7	JT9-TS-1490051	Bolt, Hex	M8x30	4
8	JT9-TS-1550061	Washer	M8	4
9	JT9-TS-1490051	Bolt, Hex	M8x30	2
10	JT9-TS-1490051	Bolt, Hex	M8x30	2
11	JT9-TS-1540061	Nut, Hex	M8	4
12	JT9-AP3-12G	Plate		1
13	CM9-TS-1524011	SHSS M8x8	M8	1
14	JT9-AP3-10	Pinion Retainer		1
15	JT9-TS-1490031	Bolt, Hex M8x20	M8	1
16	JT9-AP3-03	Pinion		1
17	JT9-AP3-05	Knob		1
18	CM9-TS-2361081	Lock Washer	M8	4
19	**	Bolt, Hex	M5x12	
	JT9-AP3-19	ID Label (not shown)		1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

7.1.6 AP-5HD – 5-Ton Arbor Press Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
1	**	Base		1
2	JT9-AP5-06G	Anvil		1
3	JT9-AP5-16	Spring Pin 6x24	M6	1
4	JT9-AP5-02	Ram		1
5	JT9-AP5-5-1	Cap	M6	5
6	JT9-AP5-6-1	Handle		1
7	JT9-TS-1491061	Bolt, Hex M10x40	M8x30	4
8	JT9-5051911	Washer M10	M8	4
9	JT9-TS-1491061	Bolt, Hex M10x40	M8x30	2
10	JT9-TS-2210501	Bolt, Hex M10x50	M8x30	2
11	JT9-TS-1540071	Nut, Hex M10	M8	4
12	JT9-AP5-12G	Plate		1
13	JT9-TS-1524031	SHSS M8x12	M8	1
14	JT9-AP5-10	Pinion Retainer		1
16	JT9-AP5-03	Pinion		1
17	JT9-AP5-05	Knob		1
18	JT9-TS-2361101	Lock Washer M10	M8	4
19	**	Bolt, Hex	M5x12	2
	**	ID Label (not shown)		1

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

8.0 Warranty and Service

Thank you for your purchase of a machine from Baileigh Industrial. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the Goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any Goods to Seller. Goods returned without an RGA will be refused. Seller will not be responsible for any freight costs, damages to Goods, or any other costs or liabilities pertaining to Goods returned without an RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special-order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, **specifications**, or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain an RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without an RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY, OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.

Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightning, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation, or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorney fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy:

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh Industrial issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh Industrial in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial makes every effort to ensure that our posted specifications, images, pricing, and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at Baileigh-Service@jpwindustries.com



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