



Operating Instructions and Parts Manual

Lock Former

Model LF-20



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2.0 Safety Instructions

⚠ WARNING

Failure to follow these rules may result in serious personal injury

1. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE. Learn the machine's application and limitations as well as the specific hazards.
2. Only trained and qualified personnel can operate this machine.
3. Make sure guards are in place and in proper working order before operating machinery.
4. Remove any adjusting tools. Before operating the machine, make sure any adjusting tools have been removed.
5. Keep work area clean. Cluttered areas invite injuries.
6. Overloading machine. By overloading the machine, you may cause injury from flying parts. DO NOT exceed the specified machine capacities.
7. Dressing material edges. Always chamfer and deburr all sharp edges.
8. Do not force tool. Your machine will do a better and safer job if used as intended. DO NOT use inappropriate attachments in an attempt to exceed the machines rated capacity.
9. Use the right tool for the job. DO NOT attempt to force a small tool or attachment to do the work of a large industrial tool. DO NOT use a tool for a purpose for which it was not intended.
10. Dress appropriate. DO NOT wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. Use eye and ear protection. Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
12. Do not overreach. Maintain proper footing and balance at all times. DO NOT reach over or across a running machine.
13. Stay alert. Watch what you are doing and use common sense. DO NOT operate any tool or machine when you are tired.
14. Check for damaged parts. Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. Observe work area conditions. DO NOT use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. DO NOT use electrically powered tools in the presence of flammable gases or liquids.
16. Keep children away. Children must never be allowed in the work area. DO NOT let them handle machines, tools, or extension cords.
17. Store idle equipment. When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
18. DO NOT operate machine if under the influence of alcohol or drugs. Read warning labels on prescriptions. If there is any doubt, DO NOT operate the machine.
19. Turn off power before checking, cleaning, or replacing any parts.
20. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
21. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
22. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. Bare wiring can kill! DO NOT touch live electrical components or parts.
23. DO NOT bypass or defeat any safety interlock systems.
24. Keep visitors a safe distance from the work area.

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 LF-20 Lock Former. 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 Specifications

Table 4-1

Model	LF-20
Stock Number	BA9-1004984
Motor and Electrical	
Speed	25fpm (7.62mpm)
Power	220V, 1ph, 60hz
Motor	1hp (.75kw)
General Specifications	
Capacity*	20ga. (1mm)
Depth Of Pocket Adjustable	.314" up to .375" (8mm up to 9.5mm)
Weights and Dimensions	
Shipping Weight	320lbs. (145kg)
Shipping Dimensions	60" x 44" x 68" (1524 x 1118 x 1727mm)
Based on a material tensile strength of 60000 PSI – mild steel	

⚠️ WARNING

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

5.0 Setup and Assembly

5.1 Unpacking and Checking Contents

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

⚠️ WARNING

SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

⚠️ WARNING

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

5.2 Cleaning

⚠️ WARNING

DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

⚠️ CAUTION

When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.

IMPORTANT: This waxy coating is NOT a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.

5.3 Transporting and Lifting

NOTICE

Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.

Follow these guidelines when lifting with truck or trolley:

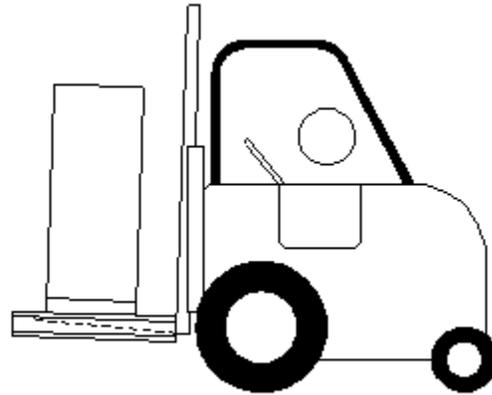


Figure 5-1

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a forklift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.

Follow these guidelines when lifting crane or hoist:

- Always lift and carry the machine with the lifting holes provided at the top of the machine.
- Use lift equipment such as straps, chains, capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.

- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, and lower slowly until it touches the floor.

5.4 Installation

IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor can support the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

6.0 Electrical Connection

CAUTION

HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!

Check if the available power supply is the same as listed on the machine nameplate.

WARNING

Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

6.1 Power Specifications

Your tool is wired for 220 volts, 60Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

6.2 Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your tools. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

WARNING

In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
- Repair or replace damaged or worn cord immediately.

6.3 Extension Cord Safety

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

Table 6-1

Amp Rating	Length		
	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
Wire Gauge			

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

6.4 Power Cord Connection

1. Unwrap the power cord and route the cord away from the machine toward the power supply.
 - a. Route the power cord so that it will NOT become entangled in the machine in any way.
 - b. Route the cord to the power supply in a way that does NOT create a trip hazard.
2. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
3. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation. Turn the switch OFF when the machine is not in operation.

7.0 Operation

⚠ CAUTION

Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges.

⚠ CAUTION

When handling large heavy materials make sure they are properly supported.

Holding the material against the angle gauge, slide it into the forming head. Be sure that the material remains against the gauge until work is finished.

Note: This machine will handle sheets 7" and longer. If shorter, leave on long piece. Notch and cut later.

Make "Hold-Down Adjustment" to meet any variation in the material of your locality. *Do not adjust* unless material slips, tends to leave gauge, or curls up at finish.

7.1 To Adjust

1. Remove top cover.
2. Tighten hold-down studs until snug and then loosen them a quarter turn. (This setting will usually allow proper adjustment for all thicknesses of material.)
3. *If the material slips*, tighten; the studs *equally* until the condition is overcome. *If the material curls* up after leaving the forming head, or shows extremely heavy pressure marks, loosen studs slightly.

If a wider or narrower hammer-over edge is desired, the angle gauge on the right hand side can be moved to give the desired width. When moving this gauge, be sure to move both ends the same distance, keeping it parallel to the front edge of the top plate of the machine.

IMPORTANT: DO NOT MOVE ANGLE GAUGES ON THE LEFT OR FINISHING END OF THE MACHINE. THESE GAUGES ARE NOT INTENDED TO TOUCH THE MATERIAL AS IT COMES THROUGH.

It is very important that long sheets be fed into the machine flat and against the angle gauge for the start.

IMPORTANT: If proper care is taken, the small knife edge roll that holds the pocket of the Pittsburgh Lock open will not break. If burrs and twists from snip cuts are not flattened out, it will sometimes strike against the opening roll causing it to break.

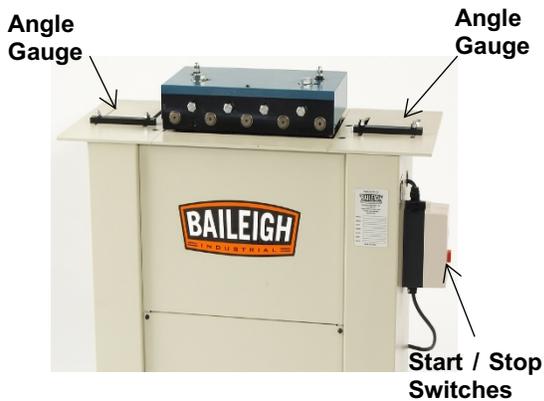


Figure 7-1

8.0 Instructions For Installing Auxiliary Rolls

8.1 Double Seam or Straight Right Angle Flange Rolls

1. Remove top cover.
2. Remove rear section of top plate. This will expose the extended shafts on which the rolls are to be mounted.
3. Select the first pair of rolls, which are marked "T1" and "B1", and slip them on the shafts at the left, or feed side of the machine, placing "T1" on the upper shaft and "B1" on the lower. Repeat this procedure with rolls "T2" and "B2"; "T3" and "B3"; "T4" and "B4"; "T5" and "B5" until all rolls have been mounted. All rolls marked "T" should be on the top shafts and "B" rolls on the bottom shafts, in numerical order, reading from left to right, facing shafts. THE NUMBERED SIDES MUST FACE OUTWARD, OR TOWARD THE OPERATOR.
4. Fasten rolls to shafts with cap screws and special washers which are provided.
5. Mount gauge on starting side of machine, using slotted holes provided in top plate. The position of this gauge is shown below (Gauge Dimensions). The angle gauge on the finishing side should be flush against the metal as it emerges from the rolls.
6. Replace back plate and top cover.
7. Hold material against gauge and feed into machine.

Note: Holding the material against the gauge is very important and may require a great deal of force.

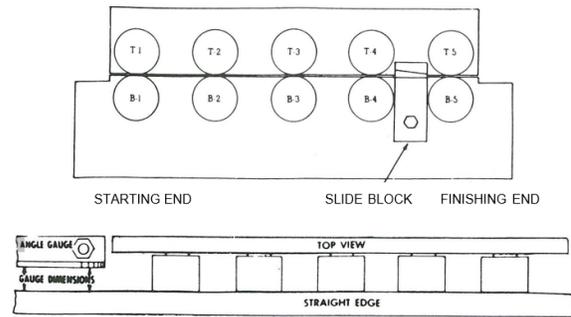


Figure 8-1

For Double Seam Rolls 1-1/8"

For Right Angle Flange Rolls 1 – 1-1/16"

For Drive Cleat Rolls Install guide block with its inner edge in line with outer edge of rolls.

Note: The slide block is used with the drive cleat only.

8.2 Drive Cleat Rolls

1. Proceed as instructed for Double Seam Rolls but leave roll "T-2" loose. This roll centers itself and should not be held in place with cap screw. Woodruff keys are used in all cases, however.

⚠ CAUTION

Always remove the slide block and replace the short stud when taking the drive cleat rolls off the machine.

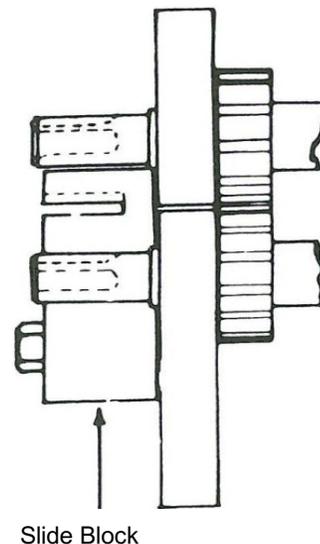


Figure 8-2

2. Remove stud indicated by arrow below (this is located between "B4" and "B5") and place the slide block in position, securing it with the 3" stud furnished.
3. Mount the feed gauge on left hand side so that it is exactly centered with the rolls. THIS IS VERY IMPORTANT! If it is not centered, the cleat will not be perfect.

4. Tighten small hold-down studs so that "T5" and "B5" do not separate when drive cleats are passing through.

IMPORTANT: Be sure to cut your material a full 2 1/8" wide to insure a perfect cleat.

8.3 To Install Power Flanging Attachment

1. Remove present cover.
2. Loosen FRONT CAP SCREWS on Spacers No. 1 and 4.
3. Remove Spacers No. 2 and 3 by taking out front and back cap screws.
4. Set flanging attachment over the forming head so the combination bevel and spur gear meshes with the gear on Pittsburgh Lock Roll No. 3.
5. Fasten flanging attachment with the cap screws which held Spacers No. 2 and 3 in place.

CAUTION

BE SURE TO TIGHTEN ALL CAP SCREWS.

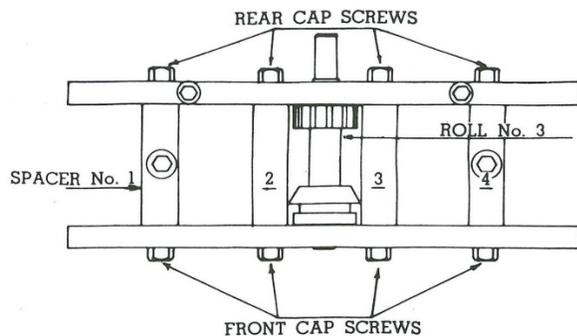


Figure 8-3

9.0 Operate Auto-Guide Power Flanging Attachment

9.1 Adjust Unit for Gauge Material to be Used

To adjust clearance between flanging rolls, tighten the adjusting screw on the front of the block of the machine all the way, then loosen the screw approximately one eighth of a turn. (This setting is usually correct for 26 gauge material.) Do not set front gauge adjusting screw too tight. It should be set just tight enough to draw the metal through the rolls. Too tight a setting will stretch and wrinkle the material. To adjust the spring tension on the compensator arm, tighten the adjusting dial on the back side of the flange to the stop and then turn back to the proper gauge setting shown on the adjusting dial.

TURN UP A "STARTING FLANGE" On the material before inserting it into the rolls. This is done by inserting the leading edge of the work to be flanged in the slot cut into the table and bending the piece away from the operator approximately 45°. Start the leading edge of the material into the rolls. As the material passes through the rolls, the compensator arm will make contact with the material and guide it through the rolls. If the material pulls out of the rolls, it is an indication that either the front adjusting screw is too loose or the back adjusting dial is not tight enough.

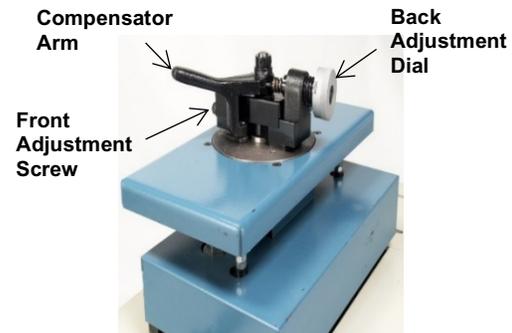


Figure 9-1

IMPORTANT: When starting a partially formed section that contains an inside curve, push the compensator arm back until it locks out of position. Feed partially formed section into the rolls and the machine will pull the material through. As the rolls approach the section that is not formed, bring the compensator arm to the material holding the spring tension off the piece until the unformed section comes to the rolls; then bear pressure to the piece until the flange picks up, then release compensator arm so that "automatic" guiding is resumed.

10.0 Material Selection

CAUTION

It must be determined by the customer that materials being processed through the machine are NOT potentially hazardous to operator or personnel working nearby.

When selecting materials keep these instructions in mind:

- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Dimensional properties of material must be consistent and not exceed the machine capacity values.
- Chemical structure of material must be consistent.
- Buy certificated steel from the same vendor when possible.

11.0 Maintenance

⚠ WARNING

Make sure the electrical disconnect is OFF before working on the machine.

⚠ WARNING

Maintenance should be performed on a regular basis by qualified personnel.

⚠ WARNING

Always follow proper safety precautions when working on or around any machinery.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.

Note: Proper maintenance can increase the life expectancy of your machine.

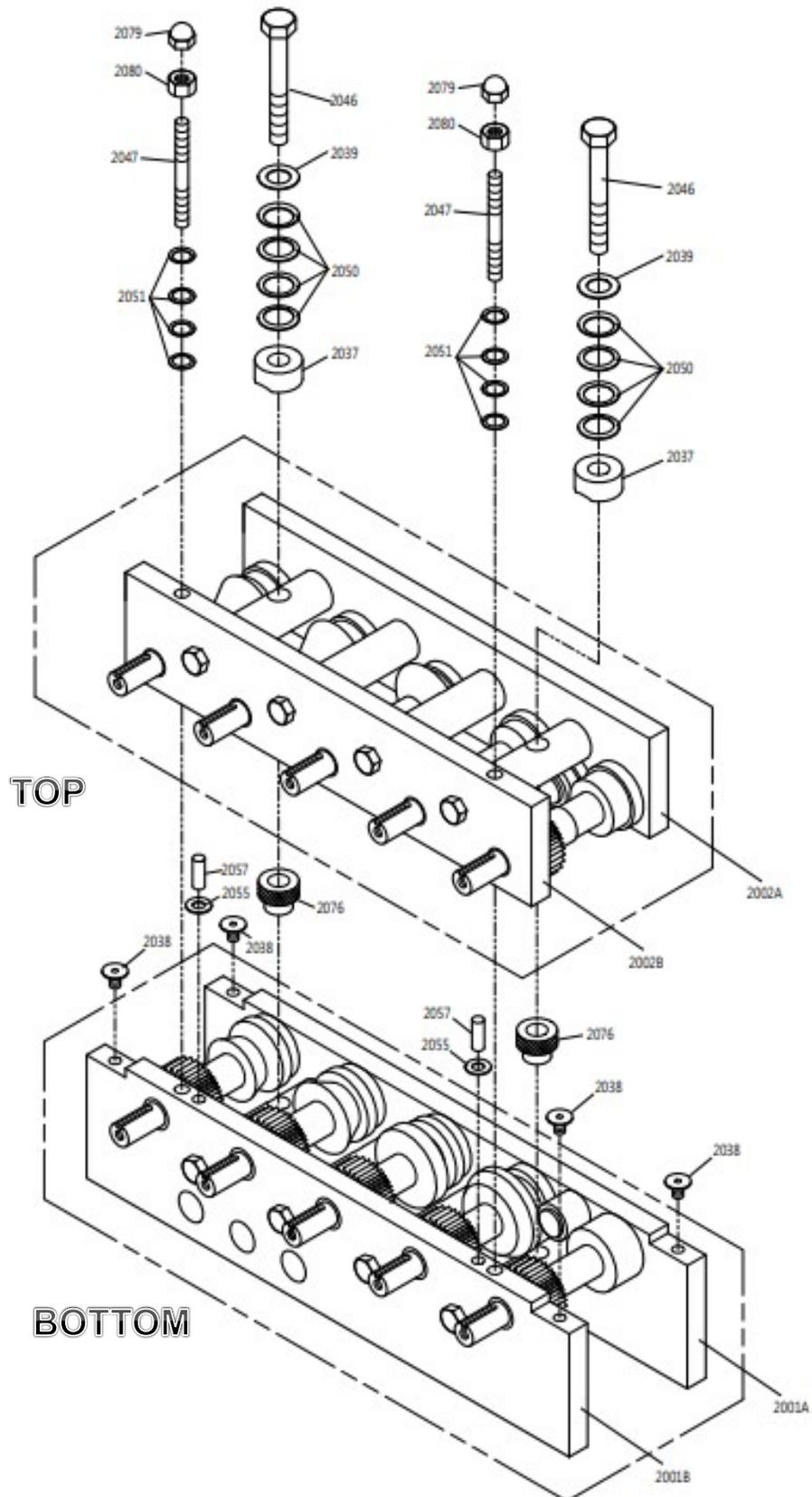
There are six grease fittings located on the underside of the stand roller case on the auxiliary side of the machine. These fittings lubricate the main reduction bearings and should be lubricated after every four hours of operation. Recommended lubricant: Standard Viscous #3 (Product of the Standard Oil Company) or equivalent. The slow speed shafts do not require additional lubrication. Grease gears periodically or as needed. If machine is to be used out of doors, an oil or grease film will prevent rusting of surfaces.



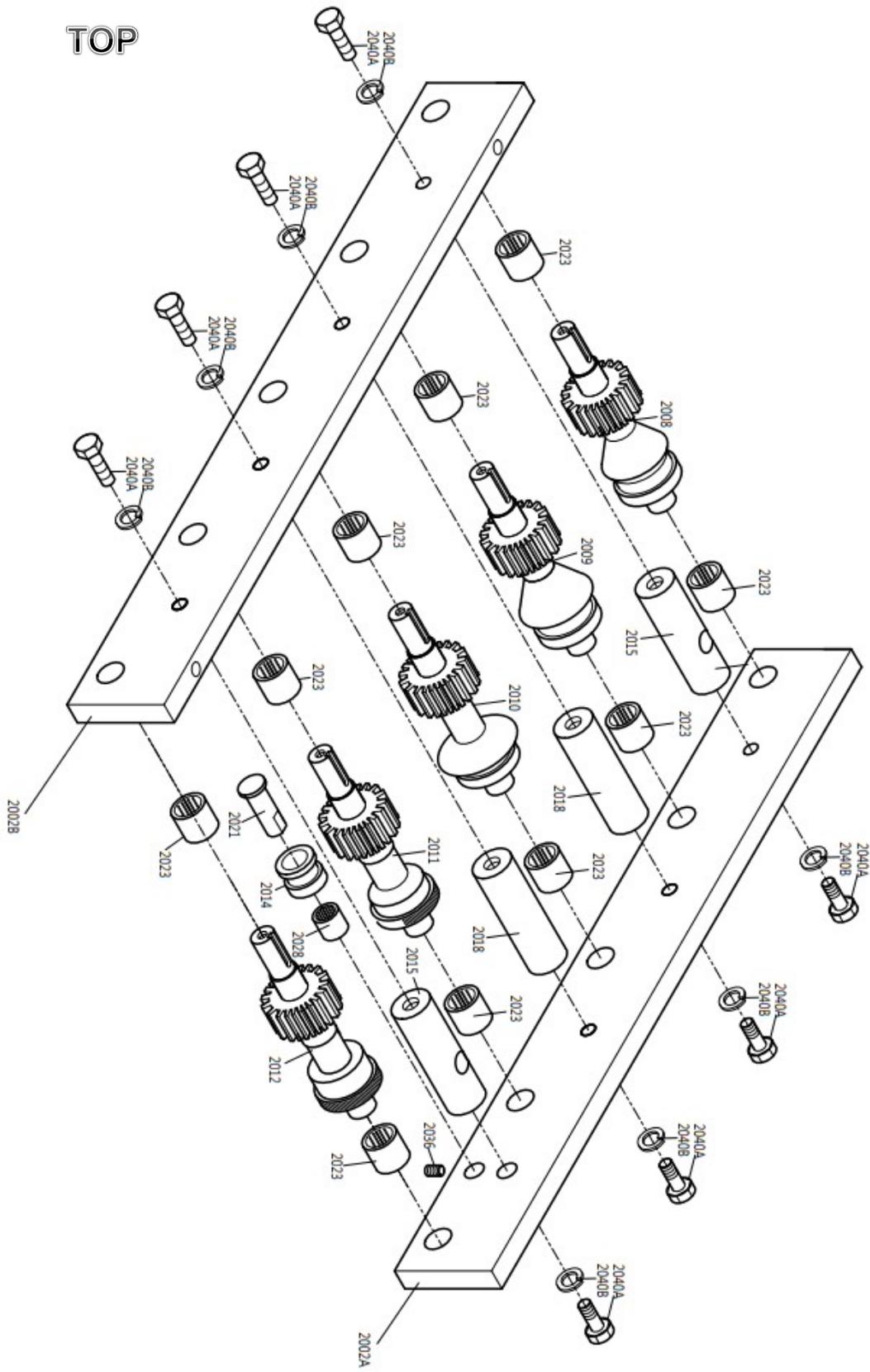
Figure 11-1

12.0 Replacement Parts

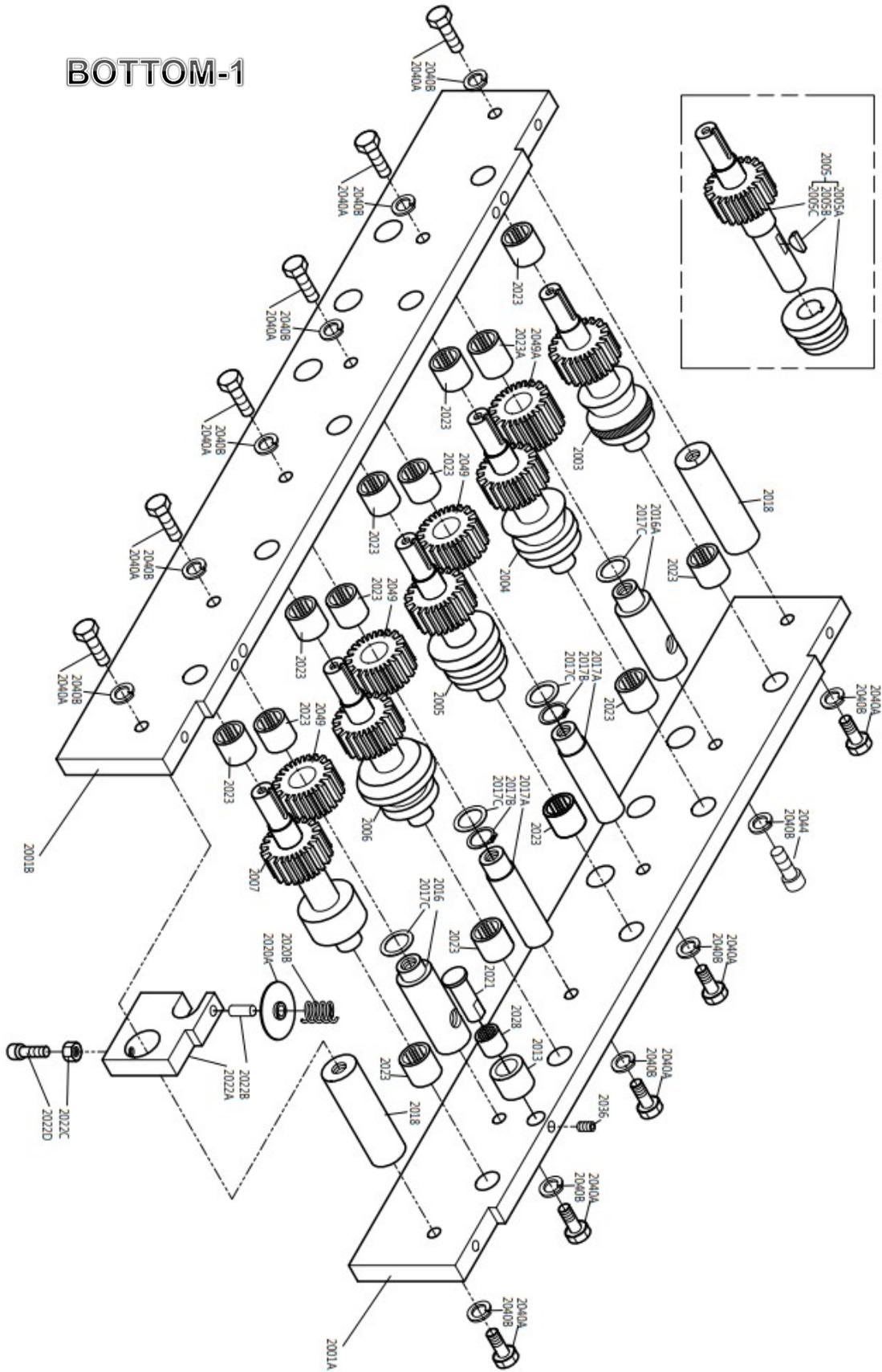
12.1.1 Lock Former Assembly – Exploded View



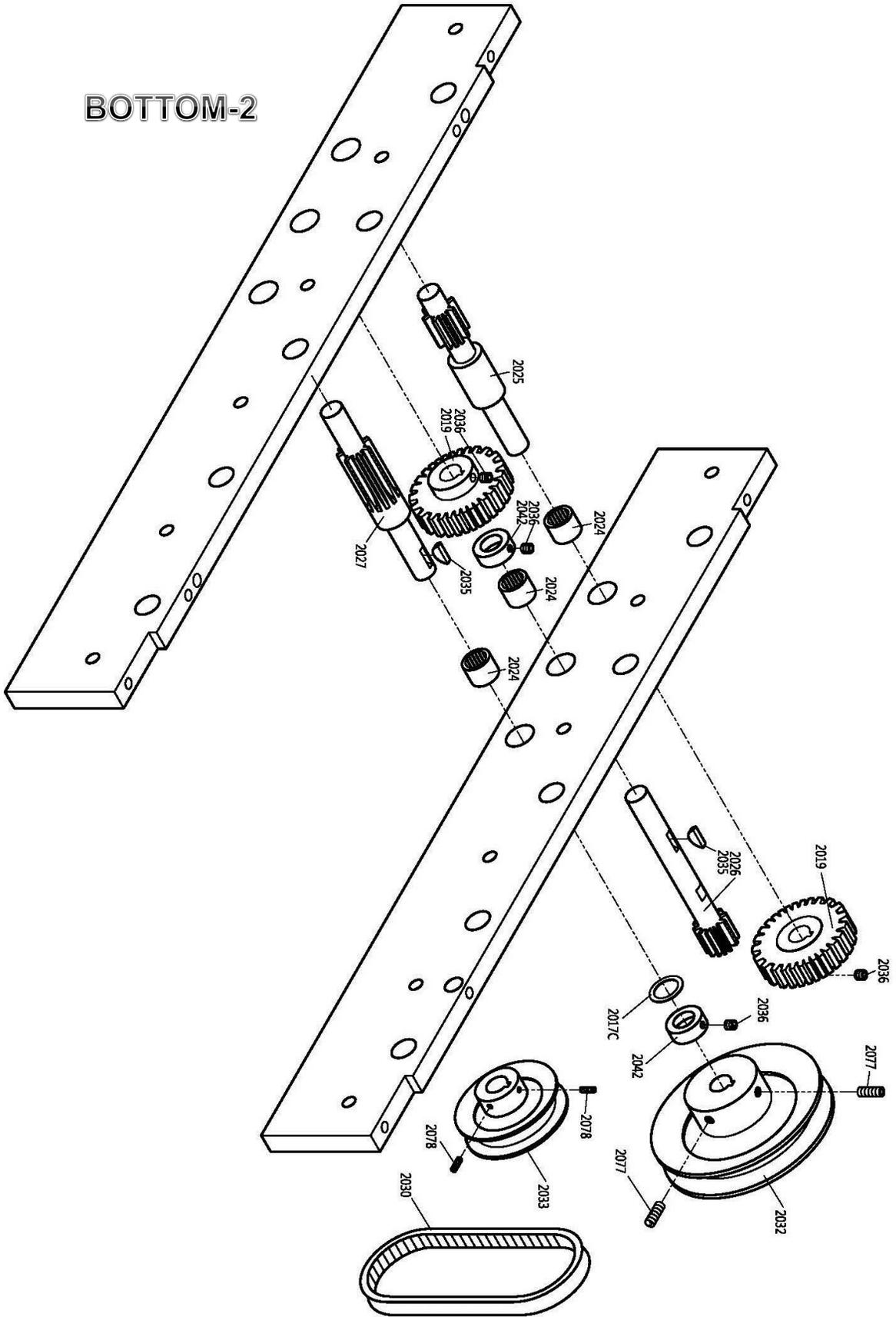
TOP



BOTTOM-1



BOTTOM-2



12.1.2 Lock Former Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
2001A	**	Lower front plate		1
2001B	**	Lower back plate		1
2002A	**	Upper front plate		1
2002B	**	Upper back plate		1
2003	BA9-1230655	Bottom forming Roller #1		1
2004	BA9-1227751	Bottom forming Roller #2		1
2005	BA9-1230656	Bottom forming Roller #3		1
2006	BA9-1230657	Bottom forming Roller #4		1
2007	BA9-1230658	Bottom forming Roller #5		1
2008	BA9-1230659	Top forming Roller #1		1
2009	BA9-1230660	Top forming Roller #2		1
2010	BA9-1016988	Top forming Roller #3		1
2011	BA9-1230661	Top forming Roller #4		1
2012	BA9-1021700	Top forming Roller #5		1
2013	**	Lower Idle Roller		1
2014	**	Upper Idle Roller		1
2015	**	Plain spacer drilled		2
2016	**	Step spacer drilled and tapped		2
2016A	**	Main step spacer		1
2017A	**	Spacer gear stud		2
2017B	**	Retaining ring		2
2017-C	BA1-1333	Dual Backup Ring		3
2018	**	Plain spacer		4
2019	**	32T drive gear		2
2020A	**	Opening roll		
2020B	**	SPRING		
2021	BA9-1231776	Idler roll pin		2
2022A	BA9-1021701	opening roll holder		1
2022B	BA9-1021702	Dowel PIN	3/8" x 7/8"	1
2022C	**	Nut		1
2022D	**	Screw		1
2023	**	Bearing		23
2023A	**	Bearing		1
2024	**	Bearing		6
2025	**	3 Drive shaft		1
2026	**	2 Drive shaft		1
2027	**	1 Drive shaft		1
2028	**	Bearing		2
2030	**	V-belt		1
2032	**	Machine pulley		1
2033	**	Motor sheave		1
2035	**	Woodruff key		3
2036	**	Set screw		5
2037	**	Saddle washer		2
2038	**	3/8"-16 FHCS		4
2039	**	washer		2
2040A	**	Screw		19
2040B	**	Lockwasher		19
2042	**	SET collar		2
2044	**	Screw		1
2046	**	Hold down stud		2
2047	**	Hold down stud		2
2049	BA9-1227752	Idler gear		3
2049A	BA9-1227753	Main Idler gear		1
2050	**	Blvl washer		8
2051	**	Blvl washer		12
2055	**	Spacer washer		2
2057	**	Dowel pin		2
2076	**	KNURLEDNUTS		2

Index No.	Part No.	Description	Size	Qty.
2077	**	Set screw		2
2078	**	Set screw		2
2079	**	nut		2
2080	**	nut		2
	BA9-1022369	Angle Gauge		1
	BA9-1022400	MACH. KEY 5*5*30 (sq/rd ends)	5*5*30	1
	BA9-1004990	Main Power Switch for LF-20		1
	BA9-1229272	Shaft		1
	BA9-1230597	Spacer Plate		1
	BA9-1230598	Steel Forming Head		1

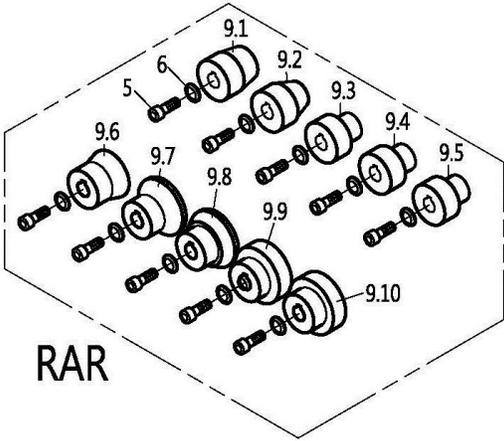
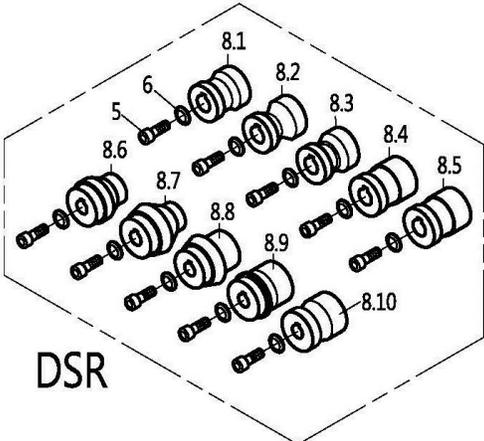
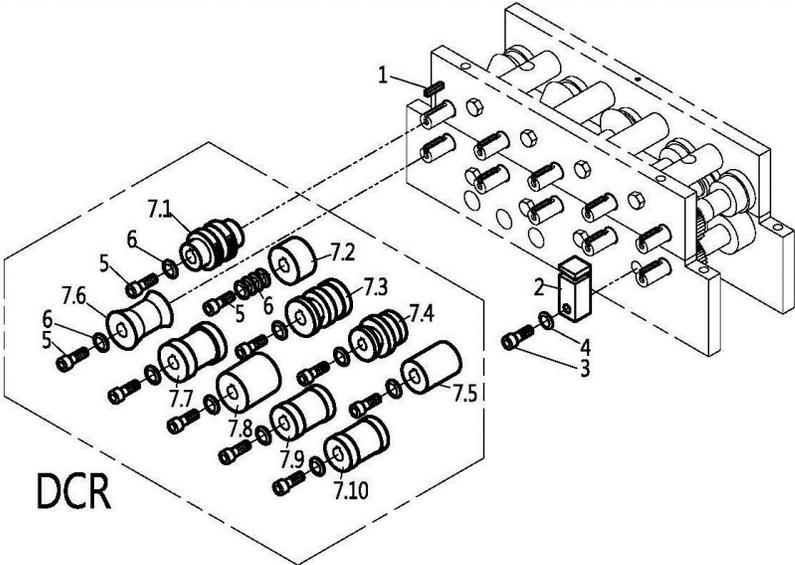
** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

12.1.3 Optional Rollers – Parts List

Index No.	Part No.	Description	Size	Qty.
1	**	Key		10
2	BA9-1004991	Slide Block		
3	**	Screw		
4	**	Washer		

** 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.

12.1.4 DCR, DSR & RAR – Exploded View



12.1.5 DCR – Parts List

Index No.	Part No.	Description	Size	Qty.
5	**	Screw		
6	**	Washer		
7	**	Drive Cleat Rolls, set of 10		1
7.1	**	D.C.R ,T1		1
7.2	**	D.C.R ,T2		1
7.3	**	D.C.R ,T3		1
7.4	**	D.C.R ,T4		1
7.5	**	D.C.R ,T5		1
7.6	**	D.C.R ,B1		1
7.7	**	D.C.R ,B2		1
7.8	**	D.C.R ,B3		1
7.9	**	D.C.R ,B4		1
7.10	**	D.C.R ,B5		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.

12.1.6 DSR – Parts List

Index No.	Part No.	Description	Size	Qty.
8	**	DOUBLE SEAM ROLLS, set of 10		1
8.1	**	D.S.R ,T1		1
8.2	**	D.S.R ,T2		1
8.3	**	D.S.R ,T3		1
8.4	**	D.S.R ,T4		1
8.5	**	D.S.R ,T5		1
8.6	**	D.S.R ,B1		1
8.7	**	D.S.R ,B2		1
8.8	**	D.S.R ,B3		1
8.9	**	D.S.R ,B4		1
8.10	**	D.S.R ,B5		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.

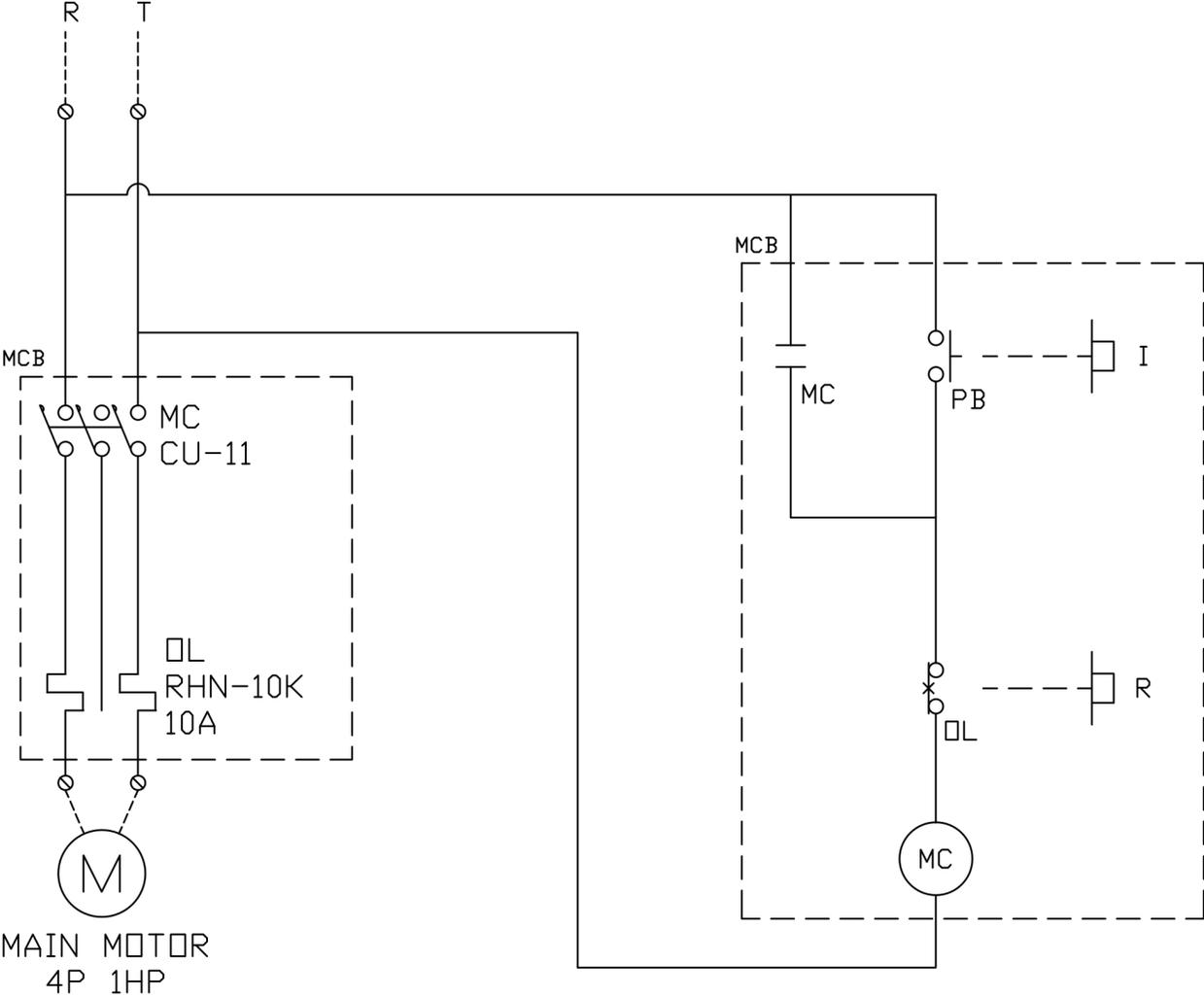
12.1.7 RAR – Parts List

Index No.	Part No.	Description	Size	Qty.
9	**	RIGHT ANGLE ROLLS, set of 10		1
9.1	**	R.A.R ,T1		1
9.2	**	R.A.R ,T2		1
9.3	**	R.A.R ,T3		1
9.4	**	R.A.R ,T4		1
9.5	**	R.A.R ,T5		1
9.6	**	R.A.R ,B1		1
9.7	**	R.A.R ,B2		1
9.8	**	R.A.R ,B3		1
9.9	**	R.A.R ,B4		1
9.10	**	R.A.R ,B5		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.

13.0 Wiring Diagrams

1Ø2W 220V 60HZ



13.1 Electrical Parts List

Index No	Part No	Description	Size	Qty
2	BA1-10812	MAGNETIC CONTACT	HUFBK-11K-220V10A..	1

14.0 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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