



Operating Instructions and Parts Manual

Variable Speed Drill Press

Model DP-1000VS



Baileigh Industrial
P.O. Box 531
Manitowoc, WI 54221-0531
Ph.: 920-684-4990
Fax: 920-684-3944
Baileigh-Sales@jpwindustries.com

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1.0 Table of Contents

Section	Page
1.0 Table of Contents	2
2.0 Safety Instructions	4
2.1 Additional Safety Precautions.....	4
3.0 About This Manual	6
4.0 Product Identification	7
4.1 The Drill Head.....	9
4.2 The Work Table.....	10
4.3 The Machine Base.....	10
4.4 Overall Dimension	10
5.0 Specifications.....	11
6.0 Setup and Assembly	13
6.1 Unpacking and Checking Contents	13
6.2 Cleaning	13
6.3 Transporting and Lifting	13
6.4 Installation	14
6.5 Anchoring the Machine.....	14
7.0 Electrical Connection	15
7.1 Power Specifications	15
7.2 Considerations.....	15
7.3 Extension Cord Safety.....	15
7.4 Power Cord Connection	15
8.0 Adjustments	16
8.1 Adjusting the Gear Rack Height	16
9.0 Operation	16
9.1 Drilling.....	16
9.2 Tapping.....	17
9.3 Removing Tooling from Spindle.....	17
10.0 Drilling Recommendations	17
10.1 Drilling Speeds	17
10.2 Drilling Feed	17
10.3 Excessive Speed/Feed Indicators	18
10.4 Speeds for High Speed Steel Drills	18
11.0 Maintenance	18
11.1 Daily Maintenance	18
11.2 Weekly Maintenance	18
11.3 Monthly Maintenance	18
11.4 Greasing the Machine	18
11.5 Spindle Return Spring Adjustment.....	19
11.6 Accessing and Cleaning the Coolant System.....	19
11.7 Oils for Lubricating Coolant	19
11.8 Timing Belt Replacement.....	20

11.9 Storing Machine for Extended Period of Time	20
12.0 Troubleshooting	21
13.0 Troubleshooting the Inverter	22
14.0 Replacement Parts	23
14.1.1 Drill Head Assembly - Exploded View	23
14.1.2 Drill Head Assembly - Parts List	25
14.1.3 Base, Column and Table Parts Assembly – Exploded View	27
14.1.4 Base, Column and Table – Parts List	29
14.1.5 Table Gear Assembly – Exploded View	30
14.1.6 Table Gear Assembly – Parts List	31
14.1.7 Coolant Pump Assembly – Exploded View	32
14.1.8 Coolant Pump Assembly – Parts List	33
14.1.9 Control Panel Assembly – Exploded View	34
14.1.10 Control Panel Assembly – Parts List	35
14.1.11 Chuck Guard Assembly – Exploded View	36
14.1.12 Chuck Guard Assembly – Parts List	37
15.0 Wiring Diagram	38
15.1 Electrical Schematic	38
15.2 Electrical Enclosure Components	39
15.3 Electrical Component Parts List	40
16.0 Warranty and Service	41



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 machine's 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 appropriately. 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 protection. Always wear ISO approved protective eye wear when operating machinery. Wear a full-face shield if you are producing metal filings. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specification. Use of eye wear which does not comply with ANSI Z87.1 specification could result in severe injury from breakage of eye protection.
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. Bit adjustments and maintenance. Always keep bits sharp and properly installed for optimum performance.
17. Keep children away. Children must never be allowed in the work area. DO NOT let them handle machines, tools, or extension cords.
18. Keep visitors a safe distance from the work area.
19. 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.
20. 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.
21. Turn off power before checking, cleaning, or replacing any parts.
22. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
23. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
24. 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.
25. DO NOT bypass or defeat any safety interlock systems.

2.1 Additional Safety Precautions

- Turn off main power to the machine and wait for the drill bit, or cutting tool to stop turning before removing debris, removing or securing the piece part, or changing the position of the work table.
- Never expose your hands or limbs to the cutting area while the machine is operating.
- When the machine is NOT in use, the drill bit or tool should NOT be rotating.

- Never leave the machine running while unattended. Turn the power OFF. Do not leave the machine until the spindle comes to a complete stop.
- Hold the piece part firmly against the table. DO NOT attempt to drill a piece part that does not have a flat surface against the table, or that is not secured by a vise. Prevent the piece part from rotating by clamping it to the table or by securing it against the drill press column.
- Never start the machine before clearing the table of all objects (tools, scrap pieces, etc.)
- Properly lock the drill bit, cutting tool, or sanding drum in the chuck before operating the machine.
- Do not remove any warning signs.
- Check safety equipment, such as safety covers, emergency stop buttons, safety mats, railings, light booms, ramps, and warning signs.
- Make sure electrical cables are well protected from damage. Check insulation periodically for wear.

- Never use the drill press without the swing-away safety guard.
- Make sure the actuator of the limit switch is seated in the detent of the round pad or the machine will not run.

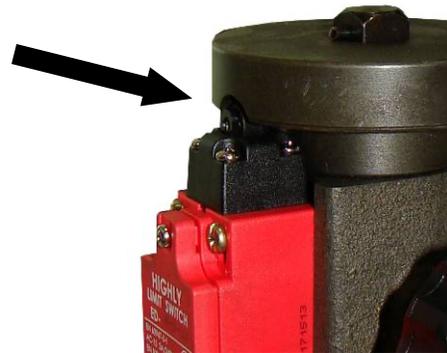


Figure 2-1

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 DP-1000VS Variable Speed Drill Press. 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 Identification

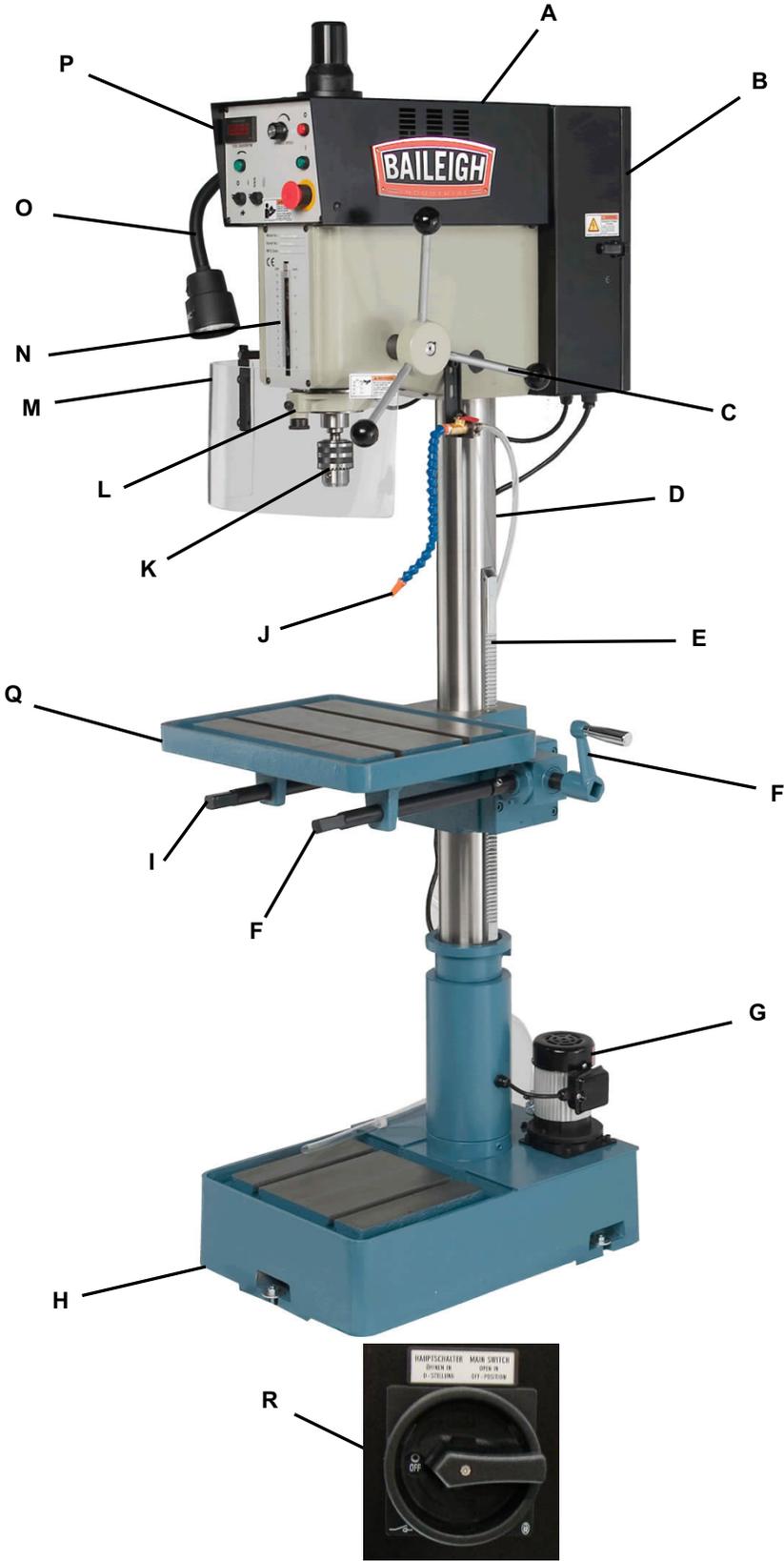


Figure 4-1

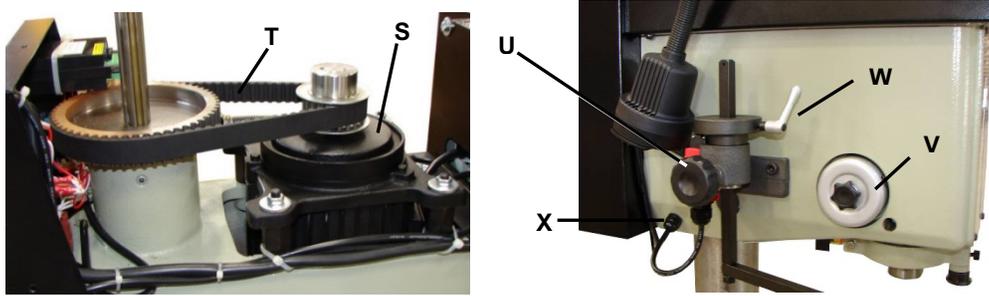


Figure 4-2

Table 4-1

Item	Description	Function
A	Motor Cover	Contains the motor and drive components.
B	Electrical Enclosure	Houses the electrical components.
C	Down - Feed Handle	Controls up-down movement of the spindle.
D	Column	Supports the table and head.
E	Gear Rack	Engages the table for height adjustment.
F	Handle	Table height adjustment at two locations.
G	Coolant Pump	Pumps coolant to the chuck.
H	Base	Supports the drill press and houses the coolant reservoir.
I	Work Table Lock	Secures the table movement on the column.
J	Coolant Nozzle W/Valve	Controls the location and volume of coolant.
K	Chuck	Holds various tooling for drilling and tapping.
L	Depth Stop Knob	Moves the depth stop up and down.
M	Safety Guard	Adjustable guard with limit switch shut-off.
N	Depth Indicator	Used for setting the drill or tap depth.
O	Halogen Work Light	Provides additional light directly toward the work area.
P	Control Panel	Houses the operating controls.
Q	Work Table	Adjustable table with T-slots.
R	Main Power Disconnect	Turns main power on to the operating controls.
S	Main Motor	Drives the drilling spindle.
T	Timing Belt	Transfers power from the main motor to the drilling spindle.
U	Limit Switch	Stops the machine if the guard is in an open position.
V	Spring Cover	Covers the Spindle retractions spring DO NOT REMOVE.
W	Guard Knob	Use to hold guard after pivoting sideways.
X	Guard Adjustment Knob	Change guard height and lock with knob.

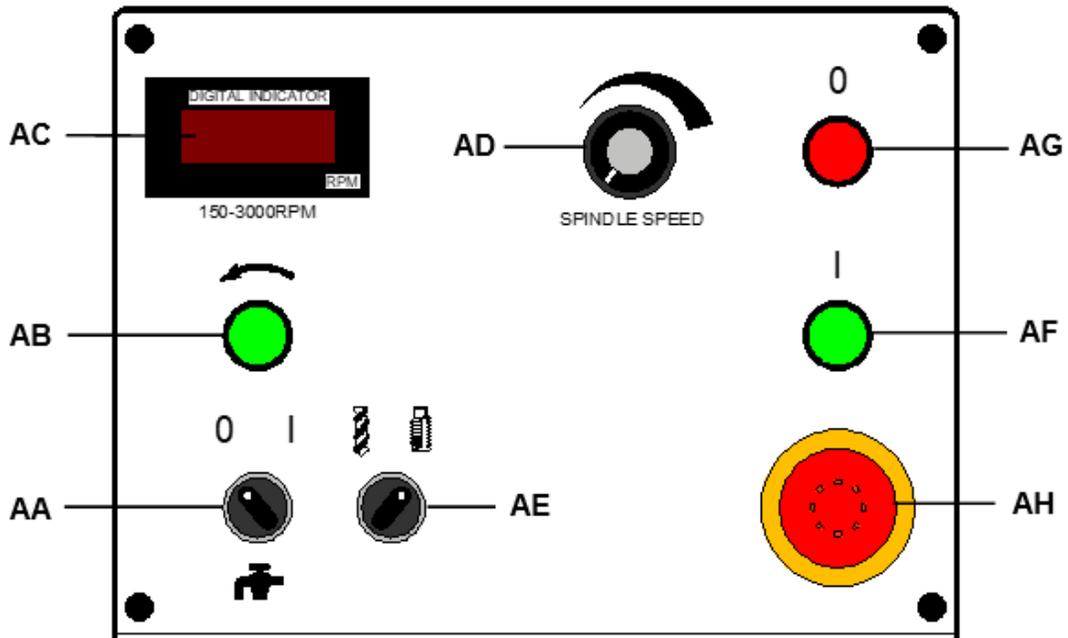


Figure 4-3

Table 4-2

Item	Description	Function
AA	Coolant Pump Selector Switch	Starts the coolant flow for cutting.
AB	Reverse Button	Reverses the spindle rotation for tapping only.
AC	Digital Indicator	Displays the rate of spindle rotation in RPM.
AD	Spindle Speed Knob	Changes the speed of spindle rotation.
AE	Drilling / Tapping Selector Switch	Selects the mode of operation: drilling or tapping.
AF	Start Button	Starts the spindle motor. A 10 sec. wait is required before a machine restart or the machine will not start.
AG	Stop Button	Stops the spindle motor.
AH	Emergency Stop Button	Stops all machine functions. Turn the switch clockwise (cw) to reset the switch.

4.1 The Drill Head

The drill head attaches to the top of the column. It houses the motor, spindle, controls, and transfer mechanisms. Attached to it is the electrical enclosure, the protective guard, the work light, and the coolant valve with nozzle.



Figure 4-4

4.2 The Work Table

The sturdy work table can be positioned at varying heights and rotated 180° in either direction. It has T-slots to allow the use of 1/2" or M14 bolts. Below the work table are three crankshafts. The two crankshafts (F) control the up/down motion of the table. Always unlock the table with crankshaft (I) before changing the height or rotating it. Then lock the work table to secure in position. The one handle works for all three crankshafts.



Figure 4-5

4.3 The Machine Base

The machine base houses the coolant reservoir and supports the coolant pump (G). The coolant is pumped up to a nozzle where a valve controls the flow onto the tool. The coolant / lubricant enters the table drain and flows back to the reservoir.

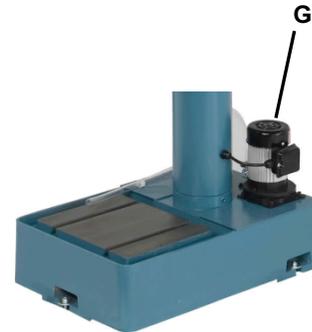


Figure 4-6

4.4 Overall Dimension

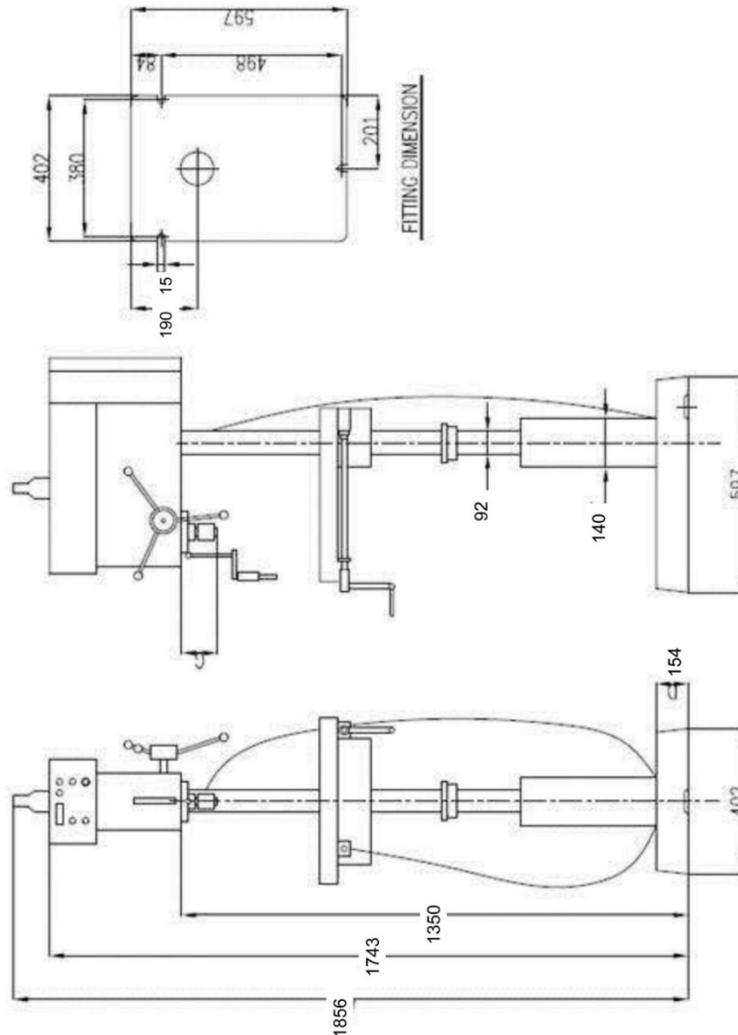


Figure 4-7

5.0 Specifications

Table 5-1

Model Number	DP-1000VS
Stock Number	BA9-1017066
Motor and Electricals	
Power Input Requirements	220V, 1Ph, 60Hz
Motor Type	TEFC Induction
Motor Power	2HP (1.5kW), 220V, 3ph, 60Hz, 6.6A, 1720rpm
Starting Amps	9.2A
Running Amps (No Load)	1.7A
Inverter	M-Type
Power Cable	14awg, 6 Ft
Power Plug	Not included
Recommended Circuit and Fuse/Breaker Size	20A
Sound Emission Without Load	70db
Coolant Pump	1/8HP, 220V 1ph, 60Hz, 0.4A
Capacities:	
Drilling Capacity, Cast Iron	1.25" (31.75mm)
Drilling Capacity, Mild Steel	1" (25.4mm)
Tapping Capacity, Cast Iron	.75" (19.05mm)
Tapping Capacity, Mild Steel	.625" (15.875mm)
Spindle To Table Maximum Distance	23.8" (604mm)
Spindle To Base Maximum Distance	45.3" (1150mm)
Spindle To Column Maximum Distance	10.4375" (265.1mm)
Coolant Capacity	2 Gal. (7.5L)
Spindle:	
Spindle Taper	MT-3
Spindle Speed	Variable, 150 – 3000rpm
Spindle Travel	5.3" (134mm)
Rotation	Fwd/Rev (Rev = Tapping Only)
Table and Column:	
Table Size	22" x 18.75" (559 x 476mm)
Table Working Surface	18.125" x 14.25" (460 x 375mm)
Table Travel:	
Without Rack Adjustment	15" (381mm)
Maximum Travel With Rack Adjustment	20" (508mm)
T-Slot Number	2
T-Slot Size	.625" [5/8"] (15.857mm)
T-Slot Centers	7.4375" (188.1mm)
Table Weight Capacity	154lbs (70kg)
Column Diameter	3.62" (92mm)

Base:	
Base Size	23.5" x 15.82" (597 x 402mm)
Base Working Surface	14-3/4 X 11-13/16 In. (375 X 300mm)
T-Slot Number	2
T-Slot Size	5/8 In. (16mm)
Main Materials:	
Head	Cast Iron, Steel Cover
Table And Base	Cast Iron
Spindle And Quill	Steel
Column	Steel
Dimensions:	
Assembled Machine Dimensions (L X W X H)	38-3/16 X 27-5/32 X 79-1/2 In. (970 X 690 X 2020mm)
Shipping Crate Dimensions (L X W X H)	48" x 44" x 82" (1219 x 1118 x 2083mm)
Weights:	
Net Weight	486lbs (220kg)
Shipping Weight	574lbs (260kg)

⚠ 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 Assembly

6.1 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.

6.2 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.

6.3 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:

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.



Figure 6-1

- 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 straps around the head of the machine.
- Take proper precautions for handling and lifting. Remove the coolant valve bracket from the head to avoid damaging it. **DO NOT** let the lift strap damage the guard limit switch or guard support bracket.
- Check to see that the machine head is secured to the column using the socket wrench provided on nut (A).

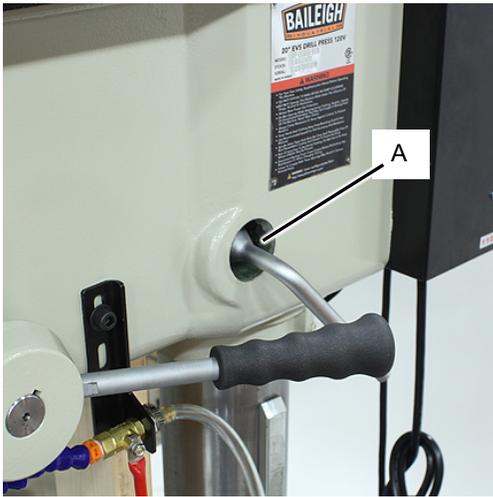


Figure 6-2

IMPORTANT: Failure to lock the machine head to the column may result in personal injury or machine damage.

- 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.

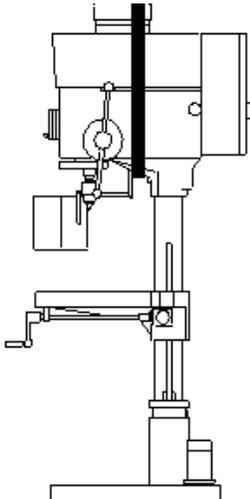


Figure 6-3

- 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.

6.4 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, worktables, 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 machine distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting 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.

6.5 Anchoring the Machine

- Once positioned, anchor the machine to the floor, as shown in the diagram. Use bolts and expansion plugs or sunken tie rods that connect through and are sized for the holes in the base of the stand.
- This machine requires a solid floor such as concrete at a minimum of 4" (102mm) thick. 6" (153mm) minimum is preferred.

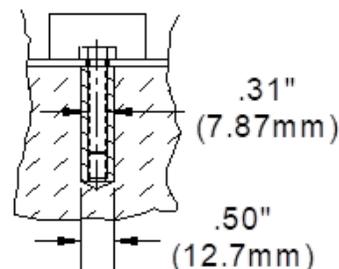


Figure 6-4

7.0 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.

7.1 Power Specifications

Your machine is wired for 110 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

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 $\pm 1\%$.

7.2 Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with an amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machines. 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 machine.
- 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 machine 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 qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

7.3 Extension Cord Safety

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

Table 7-1

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.

7.4 Power Cord Connection

1. Turn the main disconnect switch on the control panel to the OFF position.
2. 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.
3. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
4. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation.
5. Turn the switch OFF when the machine is not in operation.

8.0 Adjustments

8.1 Adjusting the Gear Rack Height

CAUTION

Failure to lock the collar can result in personal injury or damage to the machine.

1. Raising the table to an adequate working height may require raising the column gear rack.



Figure 8-1

2. Lock the table by turning crankshaft (I) clockwise (cw).
3. Raise the gear rack (G) by turning either crankshaft (F) counterclockwise (ccw).
4. Unlock column bearing (Y) by loosening the two setscrews and sliding it up to the gear rack.
5. Lock column bearing (Y) by tightening the two setscrews.



Figure 8-2

6. After unlocking (I), the table can now be raised or lowered for normal operation.

9.0 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.

9.1 Drilling

1. Load and secure the piece part to the table.
2. Secure drill bit in the chuck.

3. Unlock the table, adjust to the desired height, and relock the table.
4. Adjust the safety guard up or down as needed.
5. Select drilling mode with selector switch (A). Selector switch (A) shown in tap position.
6. Set the drill bit depth to zero position by lowering it to the top surface of the piece part, using the down-feed handles.
7. While holding the zero position, turn the depth scale lock knob (B) counterclockwise (ccw) to release depth stop knob (C).



Figure 9-2

8. Rotate Knob (C) to set the drill depth on the scale with indicator (D).
9. Re-tighten lock knob (B).
10. Start machine by pressing start button (E).



Figure 9-3

11. Turn on the coolant selector switch (F).
12. Begin drilling using the down-feed handles to lower the chuck.
13. When the desired depth has been reached, return the down feed handle to the up position. Do Not allow the handle to spin free back to the up position.
14. Press the Red Stop button to stop the drill motor.
15. Wait for the spindle to come to a full stop before opening the chuck guard and reaching into the drill area.

9.2 Tapping

1. Load and secure the piece part to the table.
2. Secure tapping tool in the chuck.
3. Unlock the table, adjust to the desired height, and relock the table.
4. Adjust the safety guard up or down as needed.

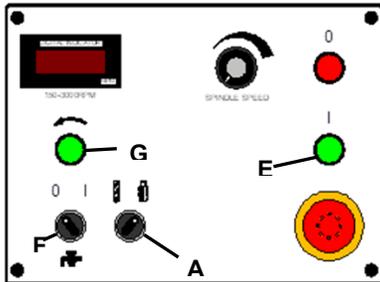


Figure 9-4

5. Selector switch (A) shown in tapping position.
6. Set the tap tool depth to zero position by lowering it to the top surface of the piece part, using the down-feed handles.
7. While holding the zero position, turn the depth scale lock knob (B) counterclockwise (ccw) to release depth stop knob (C).



Figure 9-5

8. Rotate knob (C) to set the drill depth on the scale with indicator (D).
9. Tighten lock knob (B).
10. Start machine by pressing start button (E)
11. Turn on the coolant selector switch (F).
12. Begin tapping using the down-feed handles (E) to lower the chuck. When the tap reaches the bottom of the preset depth, the spindle will automatically reverse direction. You can also reverse the tapping operation at any time by pressing the green reverse button (G).

9.3 Removing Tooling from Spindle

1. Disconnect machine from the power source.
2. Place a piece of wood on the table for protection.
3. Position the worktable approximately 10" under the bit and lower the spindle about 6".

4. Place the drift key (A) into the slot (B) of the quill and tap the end of the drift key with a hammer until the bit or chuck arbor falls out.

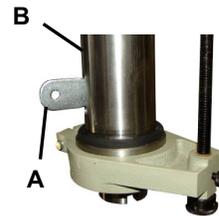


Figure 9-6

10.0 Drilling Recommendations

10.1 Drilling Speeds

The speed of a drill is usually measured in terms of the rate at which the outer periphery of the tool moves in relation to the work being drilled. The common term for this is Surface Feet per Minute (SFM).

The relationship of SFM is expressed in the following formulas:

- $SFM = 0.26 \times rpm \times \text{Drill Diameter (in inches)}$
- $RPM = 3.8 \times SFM \div \text{Drill diameter (in inches)}$

In general, the higher the speed the shorter the drill life. Operating at the low end of the speed range for a particular material will result in longer life.

The most efficient speed for drill operation depends upon many variables:

- Composition and hardness of material.
- Depth of hole.
- Efficiency of cutting fluid.
- Type and condition of drilling machine.
- Desired quality of hole.
- Difficulty of set-up.

10.2 Drilling Feed

The feed of a drill is governed by size of tool and the material drilled. Because feed rate partially determines rate of production and also is a factor in tool life, it should be chosen carefully for each job. In general, the most effective feeds will be found in the following ranges:

Table 10-1

Diameter of Drill (inches)	Feed per Revolution (inches)
Under 1/8	0.001 to 0.002
1/8 to 1/4	0.002 to 0.004
1/4 to 1/2	0.004 to 0.007
1/2 to 5/8	0.007 to 0.015

10.3 Excessive Speed/Feed Indicators

- A drill that splits up the web is evidence of too much feed or insufficient tip clearance at the center because of improper grinding.
- The rapid wearing away of the extreme outer corners of cutting edges indicates that speed is too high.
- A drill chipping or breaking out at the cutting edges indicates that either feed is too heavy, or drill has been ground with too much tip clearance.

10.4 Speeds for High Speed Steel Drills

Table 10-2

Material	Speed (SFPM)
Alloy Steel — 300 to 400 Brinell	20-30
Stainless Steel	30-40
Automotive Steel Forgings	40-50
Tool Steel, 1.2C	50-60
Steel, .4C to .5C	70-80
Mild Machinery Steel, .2C to .3C	80-110
Hard Chilled Cast Iron	30-40
Medium Hard Cast Iron	70-100
Soft Cast Iron	100-150
Malleable Iron	80-90
High Nickel Steel or Monel	40-50
High Tensile Bronze	70-150
Ordinary Brass and Bronze	200-300
Aluminum and its Alloys	200-300
Magnesium and its Alloys	250-400
Slate, Marble, and Stone	15-25
Plastics and similar materials (Bakelite)	100-150
Wood	300-400
Titanium Alloys	10-25
Titanium Alloy Sheet	50-60
Note: In cases where carbon steel drills are applicable, the drill should be run at speeds of 40 to 50 percent of those given above.	

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.

11.1 Daily Maintenance

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- Do a general cleaning by removing dust and metal chips from the machine.
- Top off the coolant reservoir. (80% of full tank capacity)
- Clean filter screen located on the machine base as often as necessary.
- Check that the guard and emergency stop are in good working order.

11.2 Weekly Maintenance

- Thoroughly clean the machine including the coolant tank. See accessing and cleaning the cooling system.
- 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.
- Clean and grease the sliding surfaces.

11.3 Monthly Maintenance

- Check that all screws on the motor, the pump, and the guard are tight and secure.
- Check that the guard is operating properly.

11.4 Greasing the Machine

- Grease the gear rack on the column to keep the table moving smoothly.
- Lubricate the spline of the spindle and the teeth of the quill with a #2 grease.



Figure 11-1

11.5 Spindle Return Spring Adjustment

The spindle return is preset by the manufacturer and should not need adjustment.

If future attention is ever required, proceed as follows:

1. Do NOT remove spring cap.
2. Loosen screw (E) just enough to rotate spring cap (F) past pin (Inside case. Not normally visible.) and engage pin into next notch.
3. Rotate spring cap clockwise to decrease spring tension. Rotate spring cap counterclockwise to increase spring tension.
4. Tighten both screws (E).

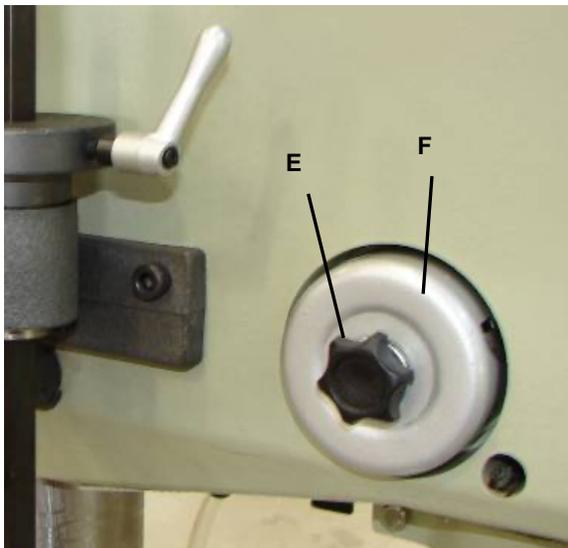


Figure 11-2

11.6 Accessing and Cleaning the Coolant System

1. Clean the drain screen.

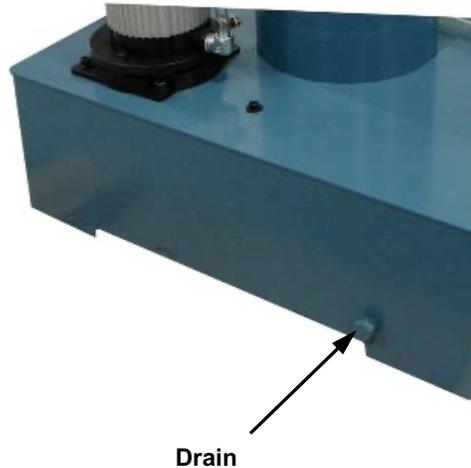


Figure 11-3

2. Drain and wash out the dirt and debris from the reservoir
3. Replace coolant drain plug.
4. Thoroughly clean the pump and pump inlet
5. Re-fill tank with coolant solution.

The coolant system should be filled with 2 gallons of a cutting coolant. Fill by pouring coolant into base of machine. Add coolant in the same manner when coolant is low. Follow all coolant manufacturer's instructions for safety, mixing and disposal.

Make sure drain hose has good, tight connection into table and that coolant flows into base.

Make sure hose leaving pump and entering ball valve has good, tight connections.

The flexible nozzle enables user to adjust coolant for each job. One ball valve controls coolant flow to nozzle.

11.7 Oils for Lubricating Coolant

Any 10:1 (water to coolant) solution will work, however we recommend Baileigh B-Cool 20:1 (water to coolant) biodegradable metal cutting fluid. It has excellent cooling and heat transfer characteristics, is non-flammable, and extends tool and machine life. Each gallon of concentrate makes 21 gallons of coolant.

11.8 Timing Belt Replacement

This machine is designed with a timing pulley and belt to provide greater braking response and torsion strength. The timing belt should be replaced when the belt is worn or broken.

1. Lockout power to the machine.
2. Remove the machine head cover (A).
3. Loosen (4) nuts to free the motor (S).
4. Slide the motor toward the pulley (AL).
5. Lift out or remove the timing belt (T).
6. Replace the belt.
7. Slide the motor away from the pulley to tension the belt.

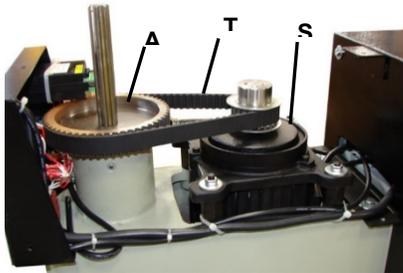


Figure 11-4

8. Check that the belt teeth sit properly in the grooves of the timing pulley.
9. Tension should be loose enough to allow .197"-.394" (5-10 mm) movement when pushing the belt from the side.
10. Tighten nuts to secure the motor.
11. Replace the cover.

11.9 Storing Machine for Extended Period of Time

If the Drill Press is to be inactive for a long period of time, prepare the machine as follows:

- Detach the plug from the electrical supply panel.
- Empty and clean the coolant reservoir.
- Clean and grease the machine.
- Cover the machine.

12.0 Troubleshooting



WARNING

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

Table 12-1

Fault	Probable Cause	Remedy
Drill Press Does Not Run	Wrong voltage	Make sure the machine voltage matches the nameplate.
	Emergency switch has been pressed.	Turn E-Stop switch clockwise (cw) to reset. Wait 10 sec. for the Delta motor controller to reset. Push the start button.
	Electrical enclosure door malfunction.	Make sure door is closed properly and switched to ON (locked) position.
	Safety guard malfunction because of the limit switch.	Make sure limit switch actuator is in the center detent position.
	Limit switch faulty	Replace limit switch.
	Stop button was pressed.	Wait 10 sec. for the Delta motor controller to reset. Push the start button.
Excessive Vibration	Improper belt tension.	Adjust belt tension.
	Uneven belt wear. (hard spots)	Replace belt.
	Motor or spindle pulley out of balance.	Balance or replace problem pulley.
	Bad motor.	Replace motor.
Motor Stalls	Over feeding.	Reduce feed rate.
	Dull drill or tap.	Sharpen drill & keep sharp.
	Motor not building up to running speed.	Replace or repair motor.
	Bad motor	Replace motor.
Noisy Operation	Noisy spline.	Lubricate spline.
	Noisy motor	Check motor bearings or loose fan motor.
Drill or Tool Heats up or Burns Work	Excessive speed.	Reduce speed.
	Chips not clearing.	Use pecking operation to clear chips.
	Dull tool.	Sharpen tool or replace.
	Feed rate too slow.	Increase feed enough to clear chips.
	Failure to use cutting oil or coolant. (on steel.)	Use cutting oil or coolant on steel.
Drill Leads Off	No drill spot.	Center punch or center drill work piece.
	Cutting lips on drill off center.	Regrind drill.
	Quill loose in head.	Tighten quill.
	Bearing play.	Check bearings and reseal or replace if necessary.

Fault	Probable Cause	Remedy
Excessive Drill Runout or Wobble.	Bent drill bit or tool.	Replace drill bit or tool. (Do Not attempt to straighten.)
	Bearing play.	Replace or reseal bearings.
	Drill not seated properly in chuck.	Loosen, reseal, and tighten chuck.
Work or Fixture Comes Loose or Spins	Failure to clamp piece part or work holding device to table.	Clamp piece part or work holding device to table surface.

13.0 Troubleshooting the Inverter

Prior to operating or adjusting any electronic component, qualified personnel must take the following aspects into consideration:

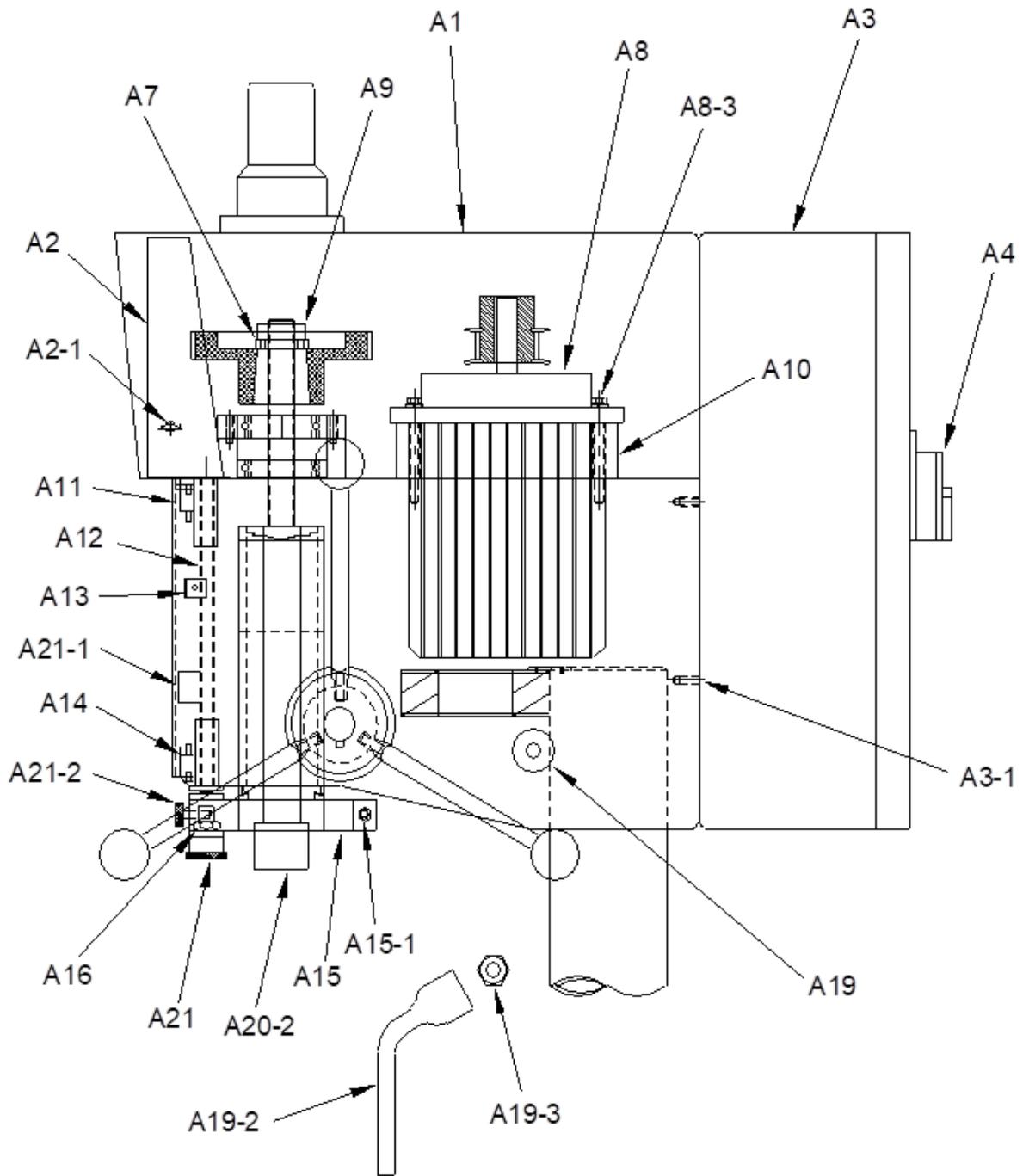
- Disconnect machine from the power supply.
- DO NOT use bare hands or metal tools to remove or install sensitive electronic parts.
- As residual voltage still exists in the capacitor after the voltage has been turned off, wait until the light disappears from the lighted display before proceeding with any work.
- Visually inspect the electronic circuit board for any defects.
- NEVER connect the alternating current directly to the output connector (U/V/W) of the speed controller.
- The electronic self-diagnosis program can notify you of situations like motor overloading, voltage fluctuations, etc. When the program detects an error, the machine will stop immediately, and the error will be displayed on the inverters digital display. Follow the solutions to correct any errors.

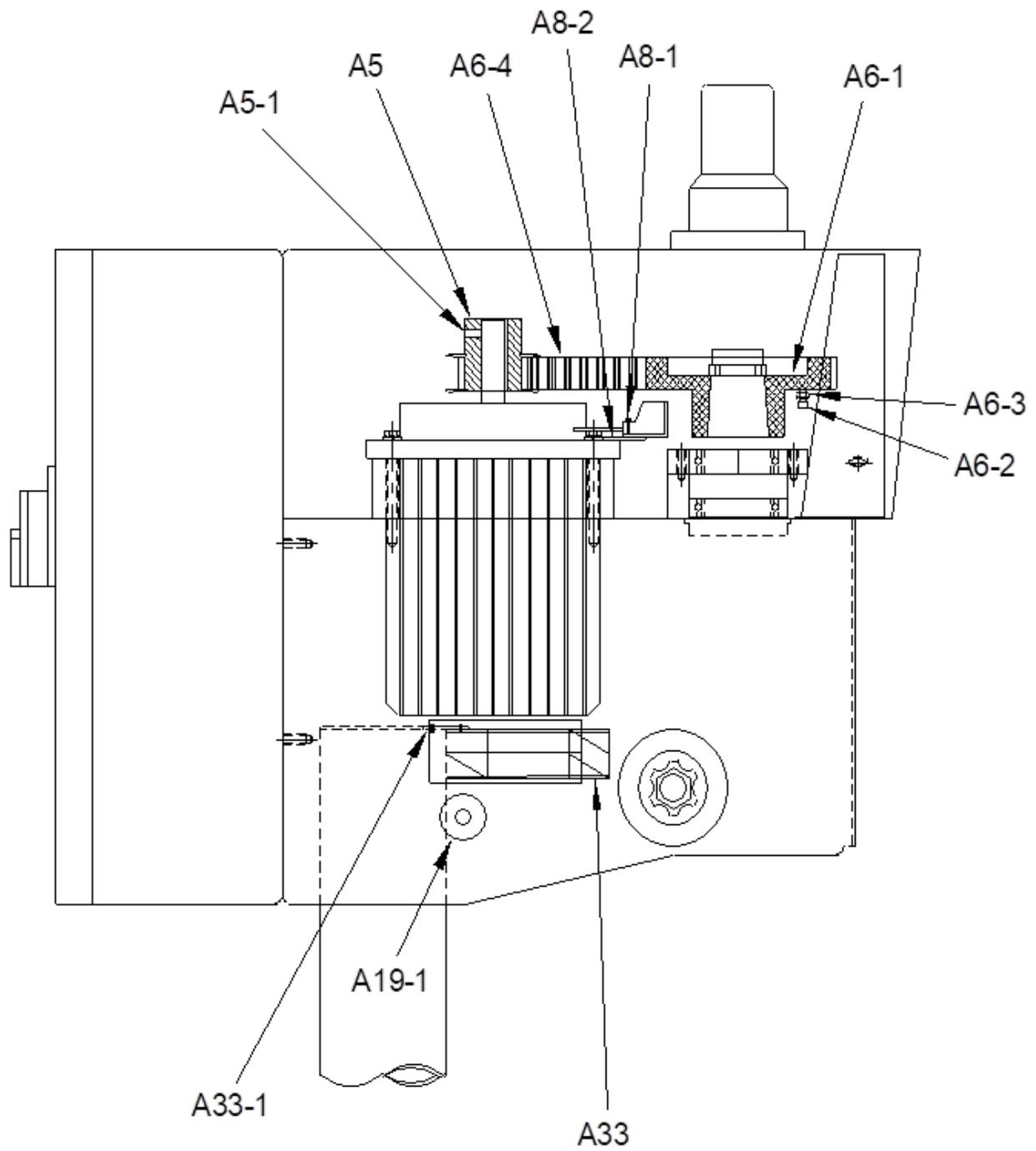
Table 13-1

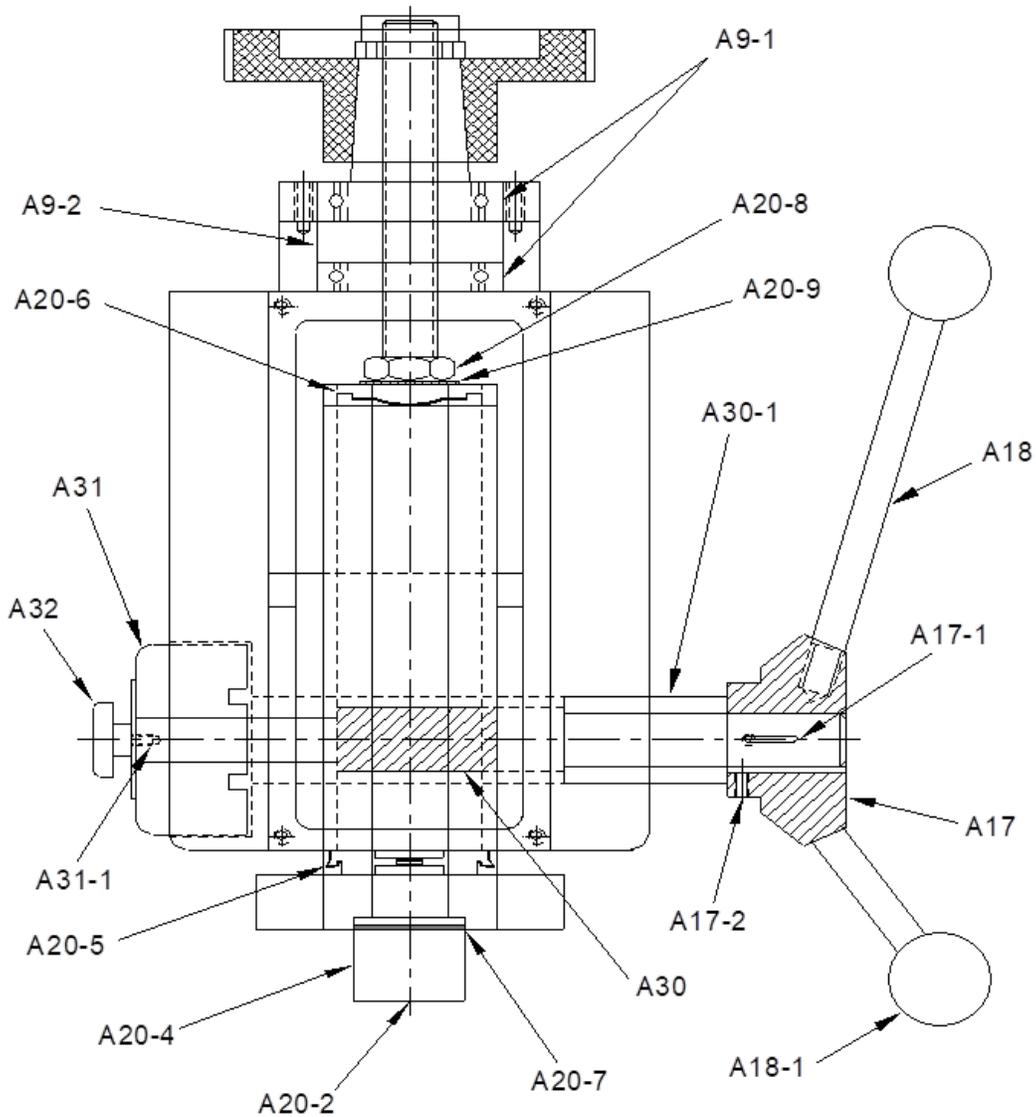
Code	Error Description	Solution
O.C.	The voltage inverter detects that the output current exceeds the normal value.	Check if motor voltage matches that of the voltage inverter. Check connection between the motor and the voltage inverter. Check if the motor is overloaded.
O.U.	The voltage inverter of the motor is detected with a D.C. high voltage lateral pressure value that exceeds the acceptable range.	Check if the circuit input voltage matches that of the voltage inverter. Frequent on/off and forward/reverse directions result in high voltage self-protection.
O.H.	The touch pole cooling device of the motor voltage inverter indicates an overheat condition.	Check if the circuit input voltage matches that of the voltage inverter. Make sure the cooling device is free from dirt and foreign objects.
O.L.	The frequency converter detected an output exceeding 150% above normal for 1 minute.	Check if the motor is overloaded. Tooling may be dull. Check for proper sized tooling, gear speed, and feed rate.
o.c.A o.c.d o.c.n	Electric current is too large during acceleration. Electric current is too large during deceleration. Electric current is too large during normal operation.	Check if the output connection of the motor adjuster is insulated improperly.
G.F.F	Grounding or safety wire issues.	Check if grounding is adequate. Replace safety fuses.
C.F1~3 or others	Internal EEPROM cannot be read or programmed. Current sensor error. U-phase error. W-phase error	Replace the Inverter.

14.0 Replacement Parts

14.1.1 Drill Head Assembly - Exploded View







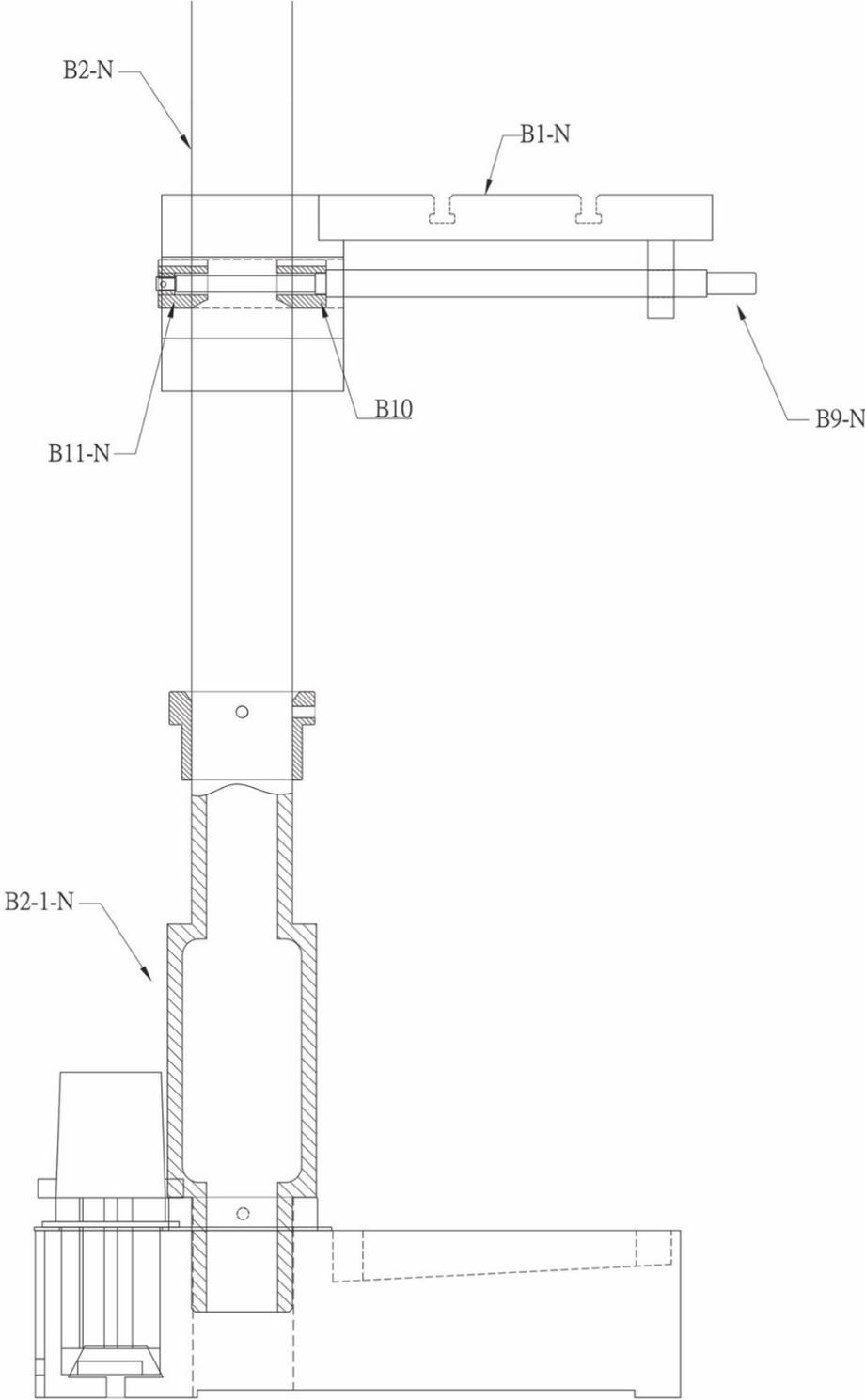
14.1.2 Drill Head Assembly - Parts List

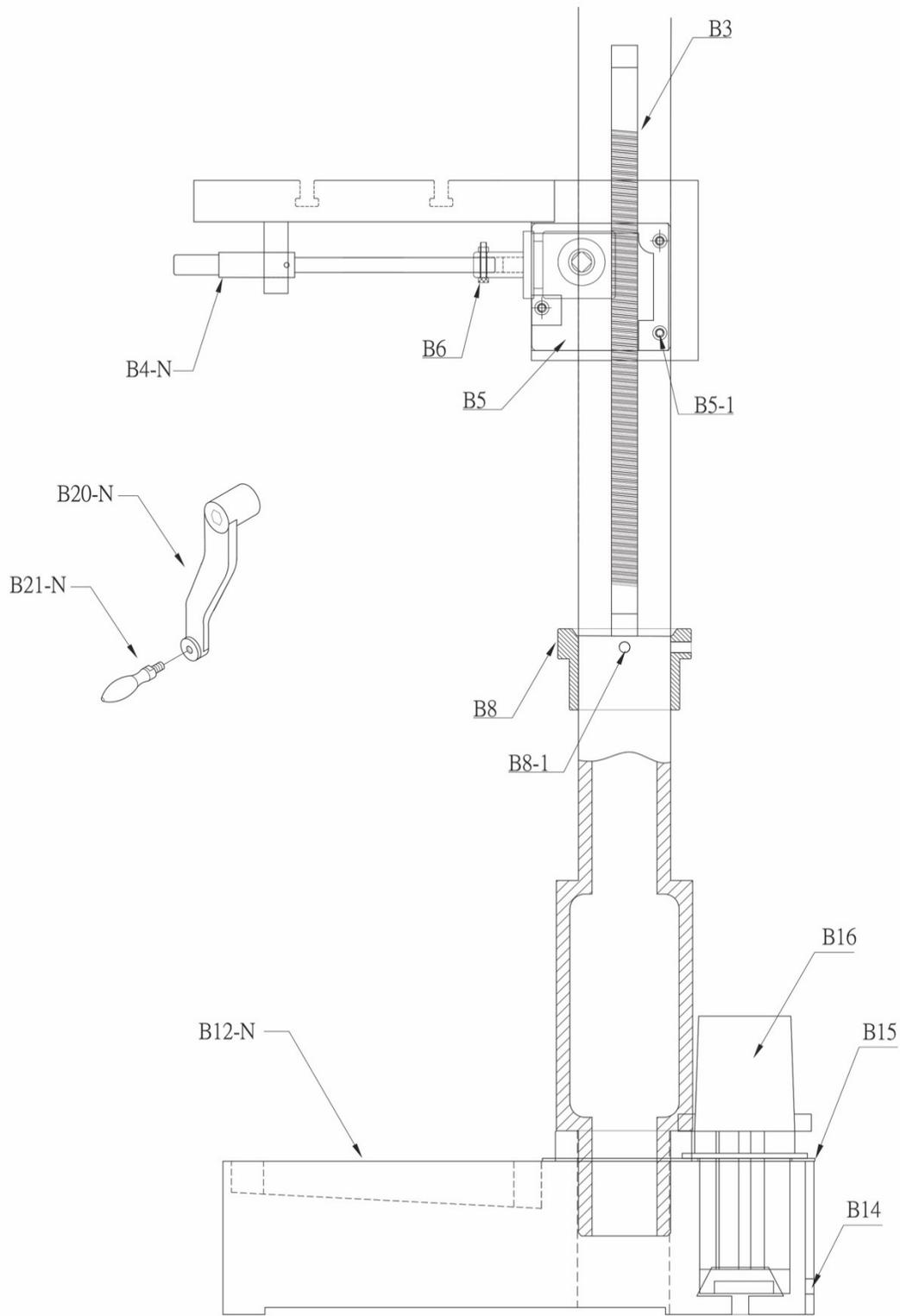
Index No.	Part No.	Description	Size	Qty.
A1	BA9-1019418	Pulley Cover		1
A2	BA9-1019419	Plate Bracket		1
A2-1	**	Screw	M6x10	1
A3	BA9-1231673	Electric Control Box		1
A3-1	**	Hex. Socket Cap Screw	M6x12	3
A4	BA1-9048	Q1, Safety Door Switch		1
A5	**	Drive Pulley		1
A5-1	**	Set Screw	5/16"X3/8"	1
A6-1	**	Spindle Pulley	#MT3	1
A6-2	**	Hex. Socket Cap Screw	3/16"X3/4"	1
A6-3	**	Nut	3/4"	1
A6-4	BA9-1002866	Belt		1
A7	**	Spindle Nut		1
A8	BA9-1015063	M1, Motor 2HP		1
A8-1	BA9-1228930	Induction Switch (Speed Sensor)		1
A8-2	BA9-1228931	Switch Support Plate		1
A8-3	**	Hex Nut	M8x1.25	4
A9	**	Spindle Taper Sleeve		1
A9-1	**	Ball Bearing		2

Index No.	Part No.	Description	Size	Qty.
A9-2	**	Bearing Spacer		1
A10	**	Screw	M8x1.25	4
A11	BA9-1019420	Micro Switch Bracket		1
A12	BA9-1019421	Micro Switch Support Rod		1
A13	BA9-1019422	Set Position Block		1
A14	BA9-1019423	QS2, Micro Switch		1
A15	**	Feed Base		1
A15-1	**	Hex Cap Bolt/Washer/Nut	1/4"X2	1
A16	BA9-1228933	Hex Nut	5/8"	1
A17	BA9-1016604	Handle Hub		1
A17-1	BA9-1016605	Key	5x20	1
A17-2	BA9-1016606	Set Screw	M6x1.0	2
A18	BA9-1016607	Handle Rod		3
A18-1	**	Knob		3
A19	BA9-1227593	Right Lock Sleeve		1
A19-1	BA9-1227594	Left Lock Sleeve		1
A19-2	BA9-1227595	Lock Handle		1
A19-3	BA9-1227596	Hex Nut	1/2"	1
	BA9-1021306	Spindle Assembly (A20-2 ~ A20-9) (Not shown)		1
A20-2	BA9-1227297	Spindle Shaft	#MT3	1
A20-4	**	Quill	#MT3	1
A20-5	**	Taper Roller Bearing		1
A20-6	**	Taper Roller Bearing		1
A20-7	**	Oil Seal		1
A20-8	**	Jam Nut		2
A20-9	**	Star Washer		1
A21	BA9-1228934	Scale Rod		1
A21-1	BA9-1228935	Limit Block		1
	BA9-1009105	Micro Switch (not shown)		1
	BA9-1228940	Lower Bracket Bar (not shown)		1
A21-2	BA9-1228936	Screw	1/4"	1
	BA9-1228941	Safety Guard (not shown)		1
	BA9-1228942	Dp915ahe-A29 Safety Guard Slide (not shown)		1
A30	BA9-1228943	Pinion Shaft		1
A30-1	**	Bushing		1
A31	BA9-1002863	Spring		1
A31-1	BA9-1002864	Cross Cap Screw	3/16"X3/8"	1
A32	BA9-1002865	Screw/Washer	1/4"	1
A33	BA9-1232782	Fan		1
A33-1	BA9-1232783	Fan Support Plate		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.

14.1.3 Base, Column and Table Parts Assembly – Exploded View





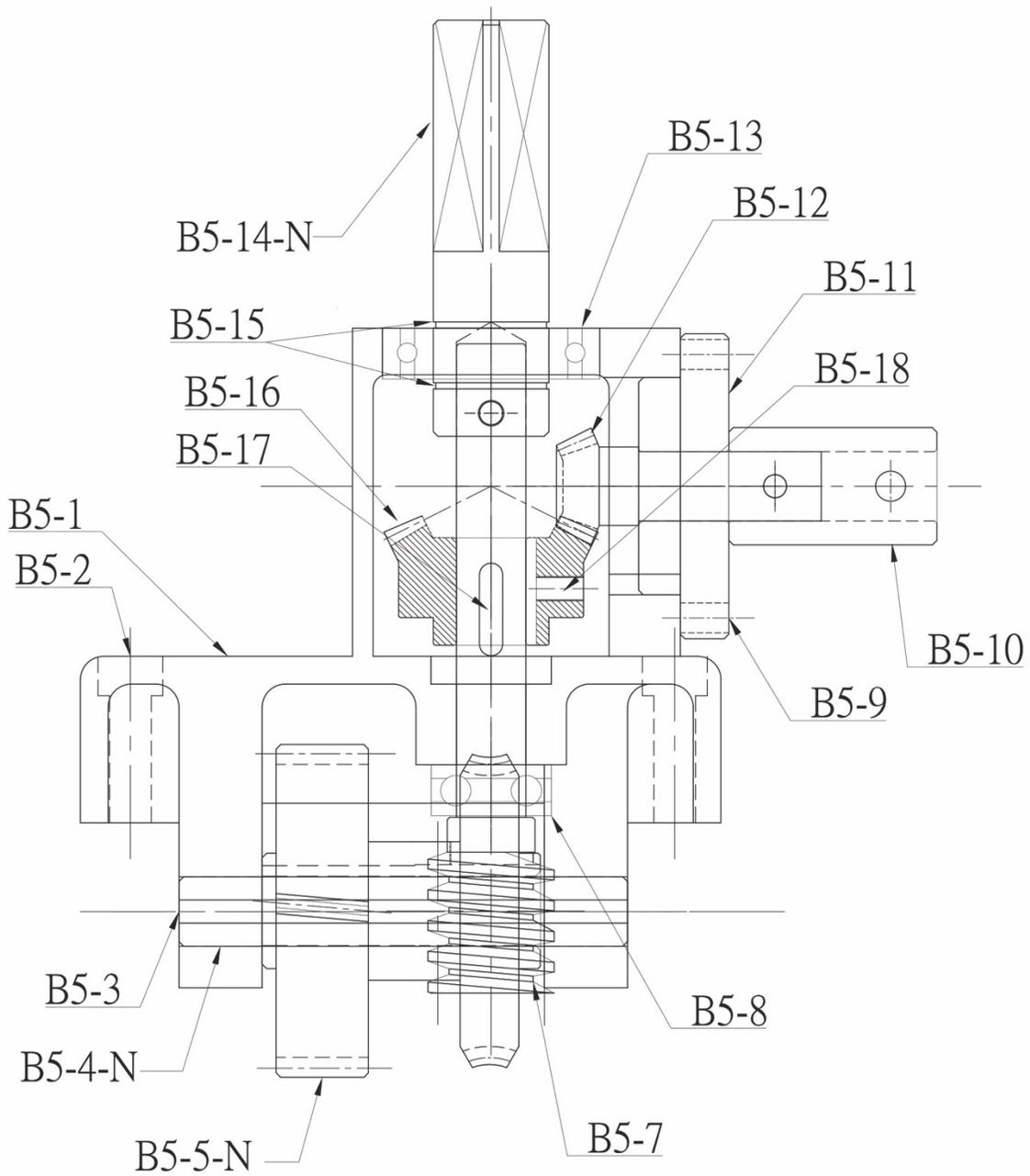
14.1.4 Base, Column and Table – Parts List

Index No.	Part No.	Description	Size	Qty.
B1-N	**	Table		1
B2-N	**	Column		1
B2-1-N	**	Column Base		1
B3	BA9-1002867	Rack		1
B4-N	**	Crank shaft		1
B5	**	DP-1000VS-B5 Gear bracket Assembly		1
B5-1	BA9-1010922	Gear bracket		1
B6	BA9-1227097	Hex. socket cap screw	1/4"x1-1/2"	1
B8	**	Column collar		1
B8-1	**	Set screw	3/8"x1"	2
B9-N	**	Lock shaft		1
B10	BA9-1227101	Lock sleeve		1
B11-N	**	Lock sleeve (thread)		1
B12-N	**	Base		1
B14	**	Screw PT	3/8"	1
B15	**	Reservoir Cover		1
B16	BA9-1002959	Coolant Pump	M2	1
B20-N	BA9-1224787	Handle		1
B21-N	**	Handle Rod		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.

14.1.5 Table Gear Assembly – Exploded View

B5-ASSEMBLY

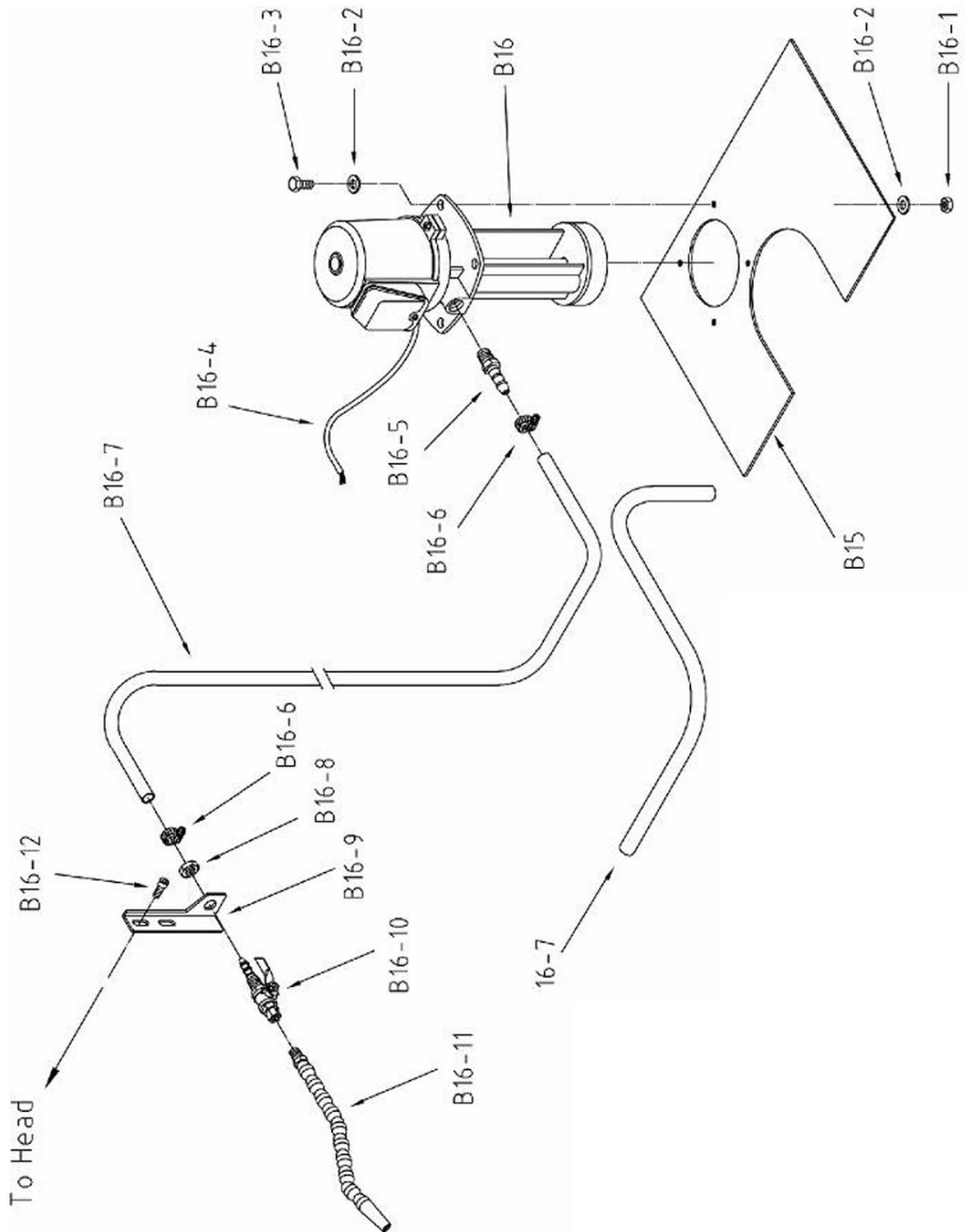


14.1.6 Table Gear Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
B5-1	BA9-1010922	Gear bracket		1
B5-2	**	Hex. socket cap screw	M8x35	3
B5-3	**	Key	5x5x30	1
B5-4N	**	Shaft		1
B5-5N	**	Gear/set screw	1/4"x 3/8"	1
B5-7	BA9-1010926	Worm shaft		1
B5-8	BA9-1010927	Thrust bearing		1
B5-9	**	Hex. Socket Cap Screw w/washer	M6x20	2
B5-10	BA9-1010928	Sleeve		1
B5-11	BA9-1010929	Flange		1
B5-12	BA9-1010930	Small bevel gear		1
B5-13	BA9-1010931	Ball bearing		1
B5-14N	**	Crankshaft		1
B5-15	BA9-1010933	C-Clip	S-25	2
B5-16	BA9-1010934	Bevel gear		1
B5-17	**	Key	4x4x20	1
B5-18	**	Set screw	1/4"x3/8"	2
	BA9-1010935	Table Gearbox Assembly		

** 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.

14.1.7 Coolant Pump Assembly – Exploded View

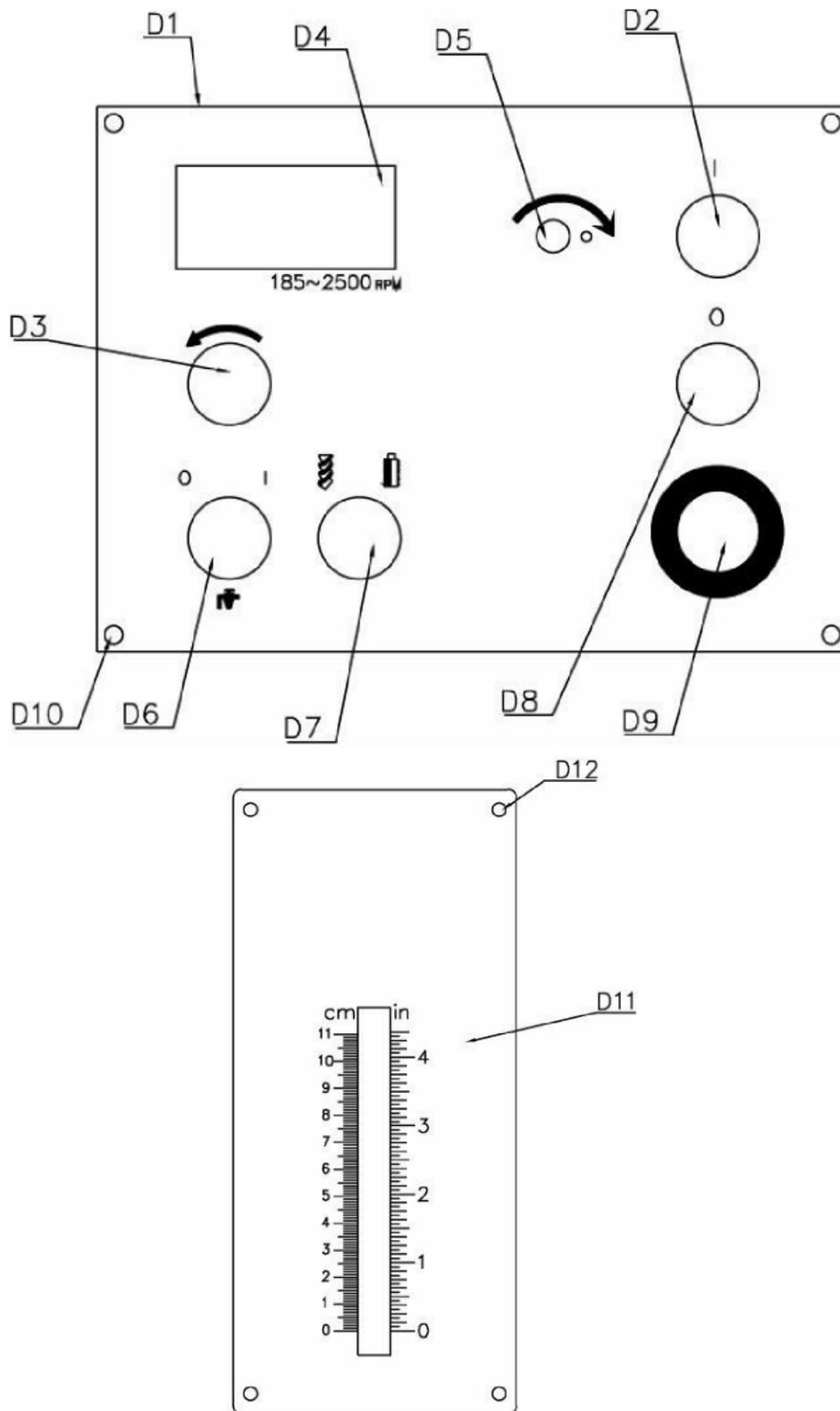


14.1.8 Coolant Pump Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
B15	**	Reservoir Cover		1
B16	BA9-DP1000VS-B16	Coolant Pump	M2	1
B16-1	**	Hex Nut		4
B16-2	**	Washer		8
B16-3	**	Hex Cap Bolt		4
B16-4	**	Cord		1
B16-5	**	Hose Nipples		1
B16-6	**	Worm Drive Hose Clamp		2
B16-7	**	Discharge Tube/Hose		
B16-8	**	Lock Nut		1
B16-9	**	Valve Bracket		1
B16-10	**	Valve		1
B16-11	**	Nozzle		1
B16-12	**	Hex Socket Cap Screw		2

** 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.

14.1.9 Control Panel Assembly – Exploded View

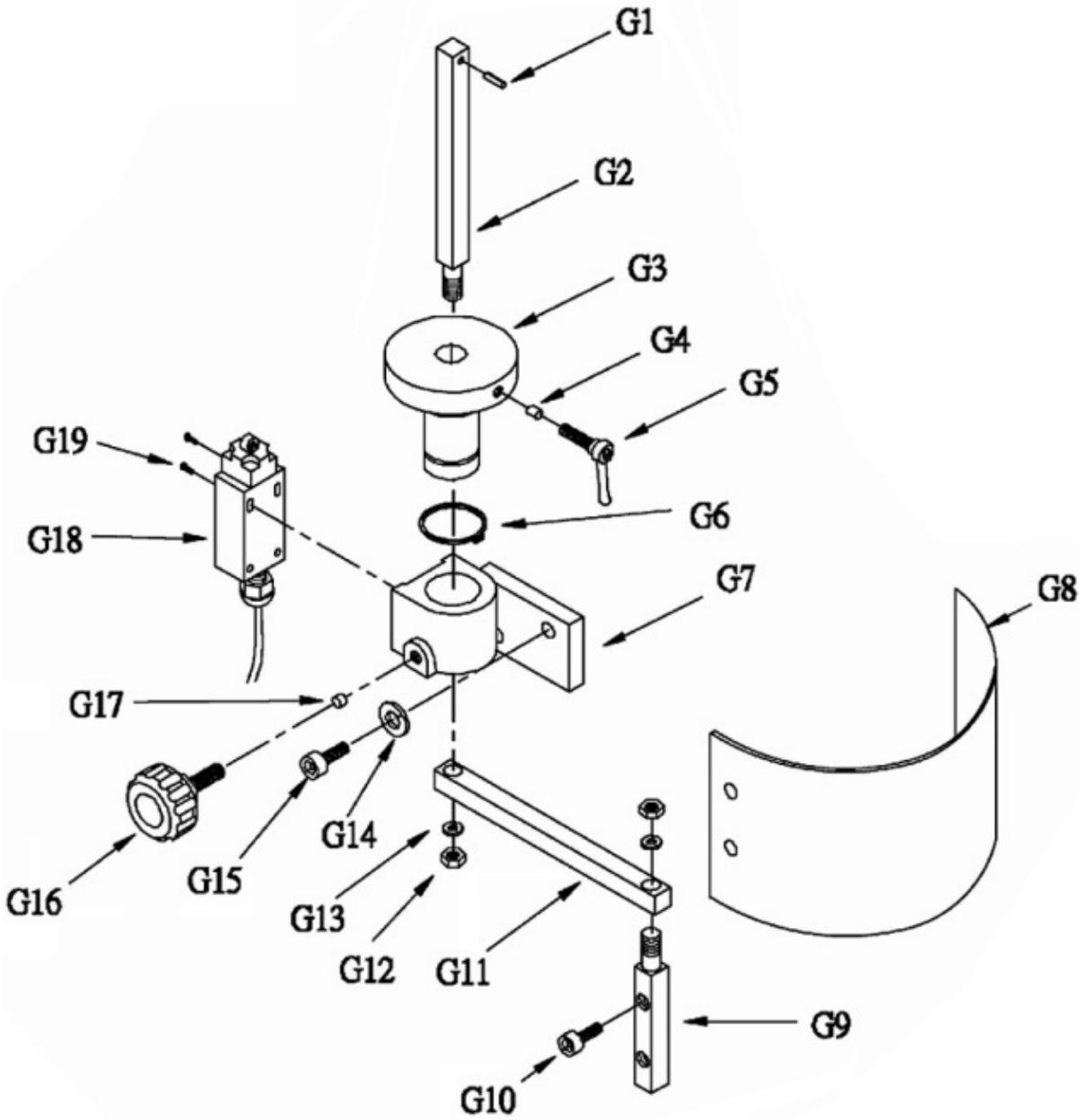


14.1.10 Control Panel Assembly – Parts List

Index No.	Part No.	Description	Size	Qty.
D1	BA9-1231675	Control Panel LD		1
D2	**	SB2, Stop Switch		1
D3	**	SB5, Reverse Switch		1
D4	**	Digital Readout Assembly		1
D5	**	VR, Speed Control Knob		1
D6	BA9-1231514	SB6, Pump Switch		1
D7	BA9-1231515	SB4, Drill / Tapping Switch		1
D8	**	SB3, Start Switch		1
D9	**	SB1, Emergency Stop Switch		1
D10	**	Cross Head Screw	3/16"x3/8	4
D11	**	Graduated Dial Label		1
D12	**	Cross Head Screw	3/16"x3/8	4

** 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.

14.1.11 Chuck Guard Assembly – Exploded View



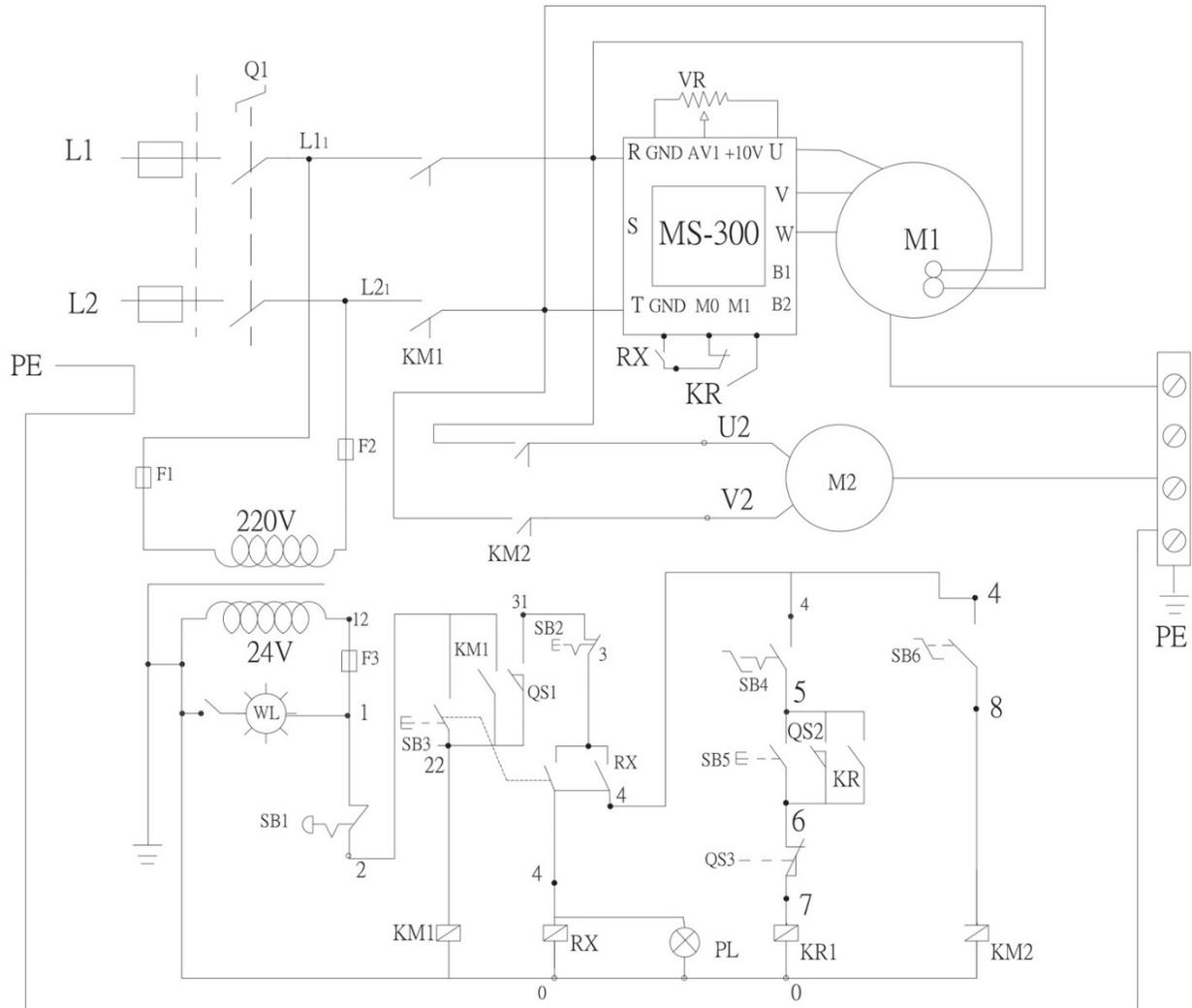
14.1.12 Chuck Guard Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
G1	**	Spring Pin, 3x16mm		1
G2	**	Support Bracket Bar		1
G3	**	Bushing		1
G4	**	Spacer		1
G5	**	Ratchet Lock Handle	M6x20	1
G6	**	C-Clip S30		1
G7	BA9-1232152	Bracket		1
G8	BA9-DP15VSF-G8	Safety Shield, Lexan	410x210mm	1
G9	BA9-1228940	Lower Bracket Bar		1
G10	**	Hex Socket Head Cap Screw	M8x12	1
G11	BA9-1228939	Support Arm		1
G12	**	Hex Nut	3/8"	1
G13	**	Spring Washer	3/8	1
G14	**	Spacer		1
G15	**	Socket Head Cap Screw	M8x20	1
G16	BA9-1232151	Lock Bolt with Knob	M8x18	1
G17	**	Spacer		1
G18	BA9-1009105	QS1, Micro Switch (Highly, ED-4-3-32)		1
G19	**	Screw	M4x20	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.

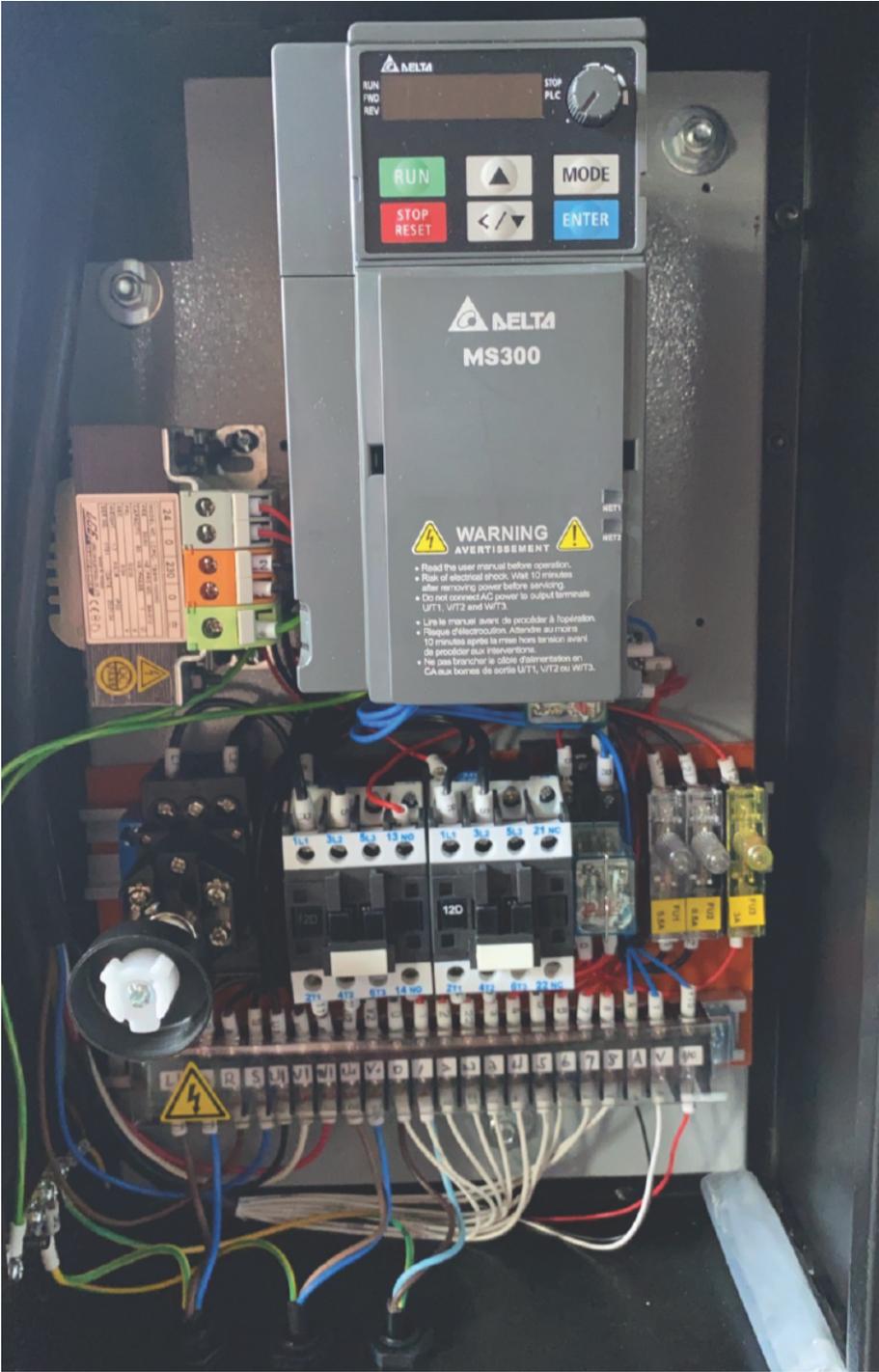
15.0 Wiring Diagram

15.1 Electrical Schematic



L1	L2	L3	R	S	U1	V1	W1	U2	V2	W2	0	1	2	22	3	4	5	6	7	8	9	C	V	+10V
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15.2 Electrical Enclosure Components



15.3 Electrical Component Parts List

Index No.	Part No.	Description	Size	Qty
Q1	**	Main Disconnect Switch		
FU1	**	Fuses		
FU2	**	Fuses		
FU3	**	Fuses		
KM1	**	Contactor		
KM2	**	Contactor		
FR	**	Over Relay		
KR	**	Relay, Reversing		
TR	**	Transformer		
MS-300	BA9-1232455	Variable Speed AC Motor Driver		
BR	**	Braking Resistors		
VR	**	Adjust-Speed Switch		
SB2	**	Push Button, Stop		
SB3	**	Push Button, Start		
SB1	**	Emergency Stop		
SB4	**	Drill / Tapping Switch		
SB5	**	Push Button, Reverse		
SB6	**	Pump Switch, Coolant		
XB	**	Terminal Block		
QS1	**	Limit Switch, Chuck Guard		
QS2	**	Micro Switch, Reverse		
QS3	**	Micro Switch, Forward		
M1	**	Motor, Drilling/Tapping		
M2	**	Motor, Coolant		
	BA9-1002868	24V, 20W, G4 Base, T3 Body, 320 Lumens, Halogen Light Bulb		
	BA9-1228483	3PH POWER CORD		
	BA9-1014633	Braking Resistor		
A	BA9-1020089	Motor Cover		
F	BA9-1224787	Handle		
	**	DP-915AHE 220 Single Phase-Head Assembly		

** 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.

16.0 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



BAILEIGH INDUSTRIAL

1625 DUFEK DRIVE MANITOWOC, WI 54220
PHONE: 920.684.4990 FAX: 920.684.3944

www.baileigh.com