



Operating Instructions and Parts Manual

Compact Flat Bar Bender

Model MCB-650



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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 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.
16. Keep children away. Children must never be allowed in the work area. DO NOT let them handle machines, tools, or extension cords.
17. Keep visitors a safe distance from the work area.
18. 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.
19. 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.

⚠ WARNING

- **Make certain the stand is securely mounted to a solid surface.**
- **Make sure pins are fully inserted before making bends.**
- **Do Not attempt to bend material larger than hot rolled mild steel up to 1/4" x 2" (6.35 x 50.8mm). For bending up to 1/2" (12.7mm) solid round use the 3" (76.2mm) die.**
- **Do Not bend material greater than 1/4" (6.35mm) in thickness around the center pin. Use the 1" (25.4mm) die so as not to bend the pin.**
- **Do Not use the sharp right-angle bend attachment to bend round stock.**
- **When using the right-angle bend attachment, use only hot rolled mild steel up to 3/16" x 2" (4.76 x 50.8mm) or 1/4" x 1 1/4" (6.35 x 31.75mm).**
- **Be sure an adequate amount of material protrudes past both the stop block and the forming die when making bends. This will prevent the material from slipping off the stop block or the forming die, causing sudden loss of pressure when pulling on the handle.**

⚠ WARNING

FAILURE TO OBSERVE THESE WARNINGS COULD RESULT IN SERIOUS PERSONAL INJURY

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 MCB-650 Compact Flat Bar Bender. 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 number	MCB-650
Motor and Electrical	
Power	Manual
General Specifications	
Angle Capacity	0° – 200°
Bend Capacity	.236" x 2" (6 x 50.8mm)
Weights and Dimensions	
Shipping Weight	53 lbs. (24kgs)
Shipping Dimensions	35" x 10.5" x 10.5" (889 x 267 x 267mm)

⚠ 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.

The Baileigh Model MCB-650 Ornamental Bender requires some assembly. After opening the box, carefully take out all the pieces shown below and do a visual inventory / inspection.



Figure 5-1

5.3 Installation

IMPORTANT:

Before beginning assembly, take note of the following precautions and suggestions when looking for a suitable location to place the machine:

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 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.

- Overall weight of the machine.
- Weight of material being processed.
- Keep the floor free of oil and make sure it is not slippery.

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.

- 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.
- 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.

5.3.1 Anchoring the Machine

- Position the machine on a firm and level concrete floor.
- Maintain a safe operating distance around the machine.

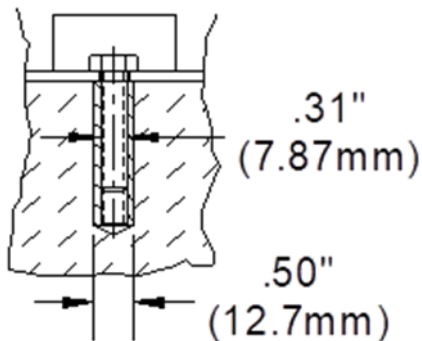


Figure 5-2

- Anchor the machine to the floor, as shown in the diagram, using bolts and expansion plugs or sunken tie rods that connect through holes in the base of the stand.

5.4 Assembly

5.5 Stand and Ring Assembly

1. Secure the Stand (#11) to a stable surface during assembly.
2. Place the three Mounting Spacers (#13) over the three holes on the top of the stand as shown in fig.5-3.
3. Place the Ring Assembly / Die Receiver (#10) over the three Mounting Spacers and secure using the two bolts (#16), lock washers (#27), and nuts (#14).
4. Place Ring Assembly Spacer (#6) between the back two holes of the Ring Assembly and

secure this assembly to the Stand using bolt (#15), lock washer (#27), and nut (#14).

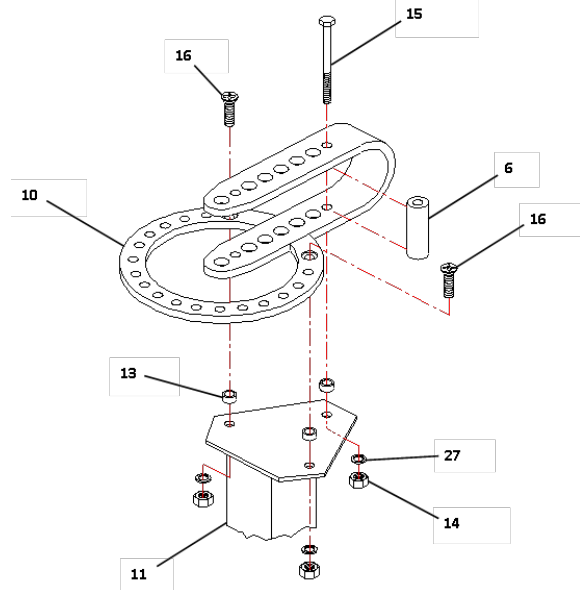


Figure 5-3

5.6 Handle Assembly

1. Place the Outer Handle Die Receiver (#9) between the Ring Assembly / Die Receiver (#10) and secure in place using one of the long hitch pins (#1) as shown in (fig. 5-4). Insert the inner handle (#8) into the outer handle (#9) at the fully extended position and secure with the pin (#12) and clip.
2. Rotate the bender arm around; in as big an arc as possible to be sure sufficient room exists for the operator to make bends free from obstructions.
3. Check that there is adequate room behind the bender to insert longer material.

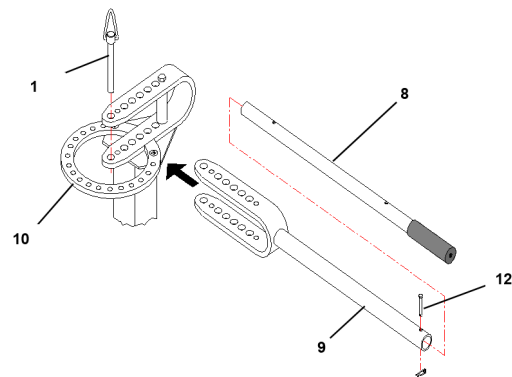


Figure 5-4

6.0 Operation

CAUTION

Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges. Keep hands and fingers clear of the clamping beam. Stand off to the side of the machine to avoid getting hit with the bending apron as it comes up to bend.

CAUTION

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

6.1 Using the Stop Block

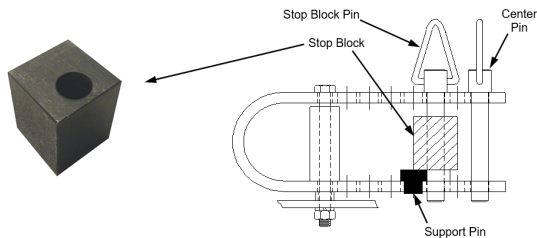


Figure 6-1

The stop block holds the material in position while the forming die in the handle bends it around the center pin or the die being used. The stop block has only four possible positions. Use the position which will place the stop block as close to the center pin or center die as possible, yet allowing room to insert the material. If the material slips, try rotating the block to a different position.

When larger dies are used on the center pin, the stop block and the support pin are moved back to the appropriate holes to hold the material. If necessary, a vise grip can be clamped to hold the material against the stop to prevent slipping.

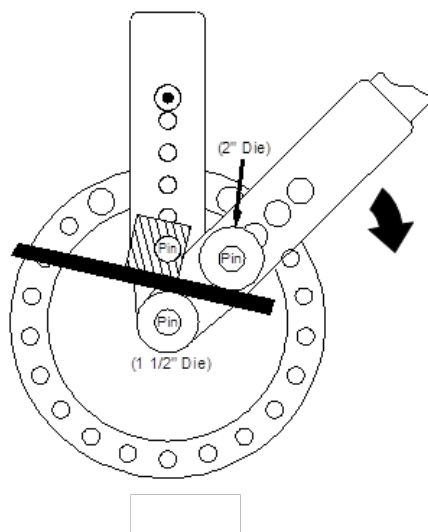


Figure 6-2

The stop block and the support pin must be moved forward or backwards to whichever hole is necessary, in order to accommodate the various die and material sizes.

6.2 Using the Right-Angle Bend Attachment

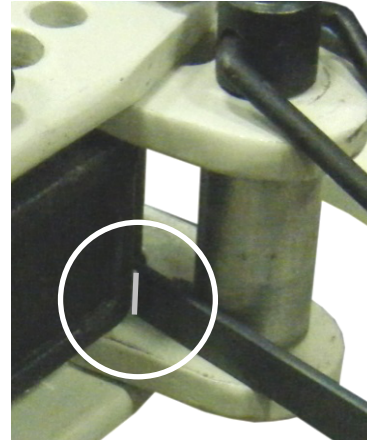


Figure 6-3

- When making sharp right angle bends, make thin clear chalk lines on the flat stock at the points where you plan to make the bends (fig. 6-3).
- When placing the flat stock in the bender, leave only one half of the chalk mark showing.
- The bending edge on the right-angle attachment will cover the other half of the chalk line.
- If two right angle bends are made on the same side of the flat stock (for example 3/16" x 1" [4.76 x 25.4mm]), the chalk lines will need to be spaced approximately 1/8" (3.1mm) further apart than the desired inside dimension.
- If precise dimensions are required, make a test piece before the final part. You may need to move the chalk lines slightly or alter the length of the material.
- Locate the Right Angle Bending Attachment as shown in fig.6-4. If the handle hits the stock, due to its length, position it to the left of the handle.
- Always pull the handle in a clockwise (cw) direction.
- Use a protractor to measure precise angles.

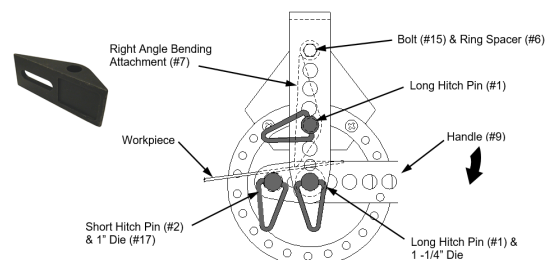


Figure 6-4

6.3 Bending Angle Stops

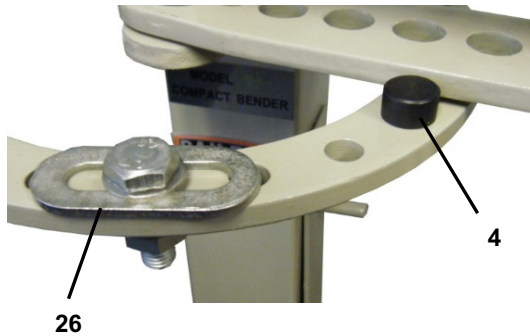


Figure 6-5

- To control the bending angles for multiple piece parts, use either the stop button (#4) or the adjustable stop (#26).
- When using the stop button, simply select a hole which gives the desired bend angle, and drop in the stop.
- The adjustable stop allows for more precise bend angles.
- Slide the slotted washer either left or right as needed, and tighten the bolt.

7.0 Bending Allowance

In order to bend sheet metal accurately, you will need to consider the total length of each bend. This is referred to as bend allowance. Subtract the bend allowance from the sum of the outside dimensions of the piece part to obtain the actual overall length or width of the piece. Because of differences in sheet metal hardness, and whether the bend is made with the grain or against it, exact allowances must sometimes be made by trial and error. However bend allowances for general use can be obtained from metal working books or from the Internet.

8.0 Understanding Springback

Springback, also known as elastic recovery, is the result of the metal wanting to return to its original shape after undergoing compression and stretch. After the bending leaf is removed from the metal and the load is released, the piece part relaxes, forcing the bent portion of the metal to return slightly to its original shape. The key to obtaining the correct bend angle is to over bend the metal a little and allow it to spring back to the desired angle. All metals exhibit a certain amount of spring back.

9.0 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.

10.0 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

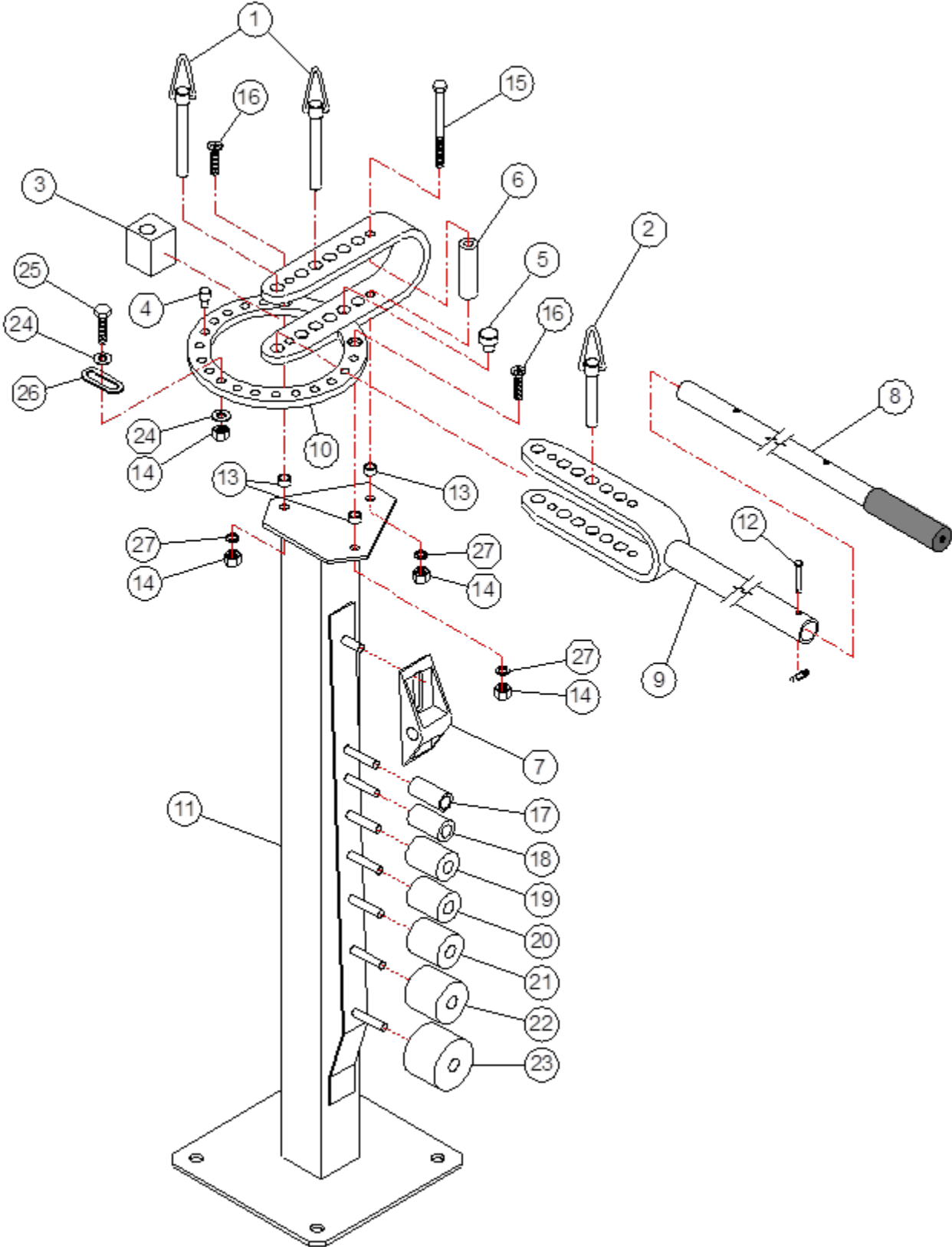
Always follow proper safety precautions when working on or around any machinery.

- 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.
- Regularly inspect, clean, and lubricate the moving parts, with good quality oil. Check that all nuts and bolts are properly tightened.

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

11.0 Replacement Parts

11.1.1 Compact Flat Bar Bender Assembly – Exploded View



11.1.2 Compact Flat Bar Bender Assembly – Parts List

Item	Part No.	Description	Size	Qty.
1	BA9-1232387	Long Hitch Pin		2
2	BA9-1232397	Short Hitch Pin		1
3	BA9-1005427	Square Stop Block		1
4	BA9-1005428	Stop Shoulder Pin	25 x 10, 15.5 x 10mm	1
5	BA9-1005429	Support Pin	15OD x 21.5mmL, 9.5 x 10mm	1
6	BA9-1232402	Ring Assembly Spacer		1
7	BA9-1009443	Right Angle Bending Attachment		1
8	BA9-1232403	Inner Handle		1
9	BA9-1232404	Outer Handle / Die Receiver		1
10	BA9-1232388	Ring Assembly / Die Receiver		1
11	BA9-1232389	Stand		1
12	BA9-1232390	Handle Pin and Hair Clip		1
13	BA9-1231307	Mounting Spacer		3
14	BA9-1232391	Hex Nut	M10P1.5	4
15	BA9-1232392	Hex Cap Screw	M10X120	1
16	BA9-1232393	MACH Screw, Flat HD	M10X40	2
17	BA9-1232394	Die	1" (25.4mm)	1
18	BA9-1232395	Die	1-1/4" (31.75mm)	1
19	BA9-1232396	Die	1-1/2" (38.1mm)	1
20	BA9-1232398	Die	1-3/4" (44.45mm)	1
21	BA9-1232399	Die	2" (50.8mm)	1
22	BA9-1232400	Die	2-1/2" (63.5mm)	1
23	BA9-1232401	Die	3" (76.2mm)	1
24	BA9-1232405	Flat Washer	M10	4
25	BA9-1232406	Hex Cap Screw	M10X35	1
26	BA9-1005426	Adjusting Washer		1
27	BA9-1232407	Lock Washer	M10	3
	BA9-1005430	Full Roll Set		

12.0 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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