



Operating Instructions and Parts Manual

Foot Shear

Model SF-5216E



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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 machine in damp or wet locations. Do not expose to rain. Keep work area well lighted.
16. Blade adjustments and maintenance. Always keep blades sharp and properly adjusted 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.

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 SF-5216E Foot Shear. 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

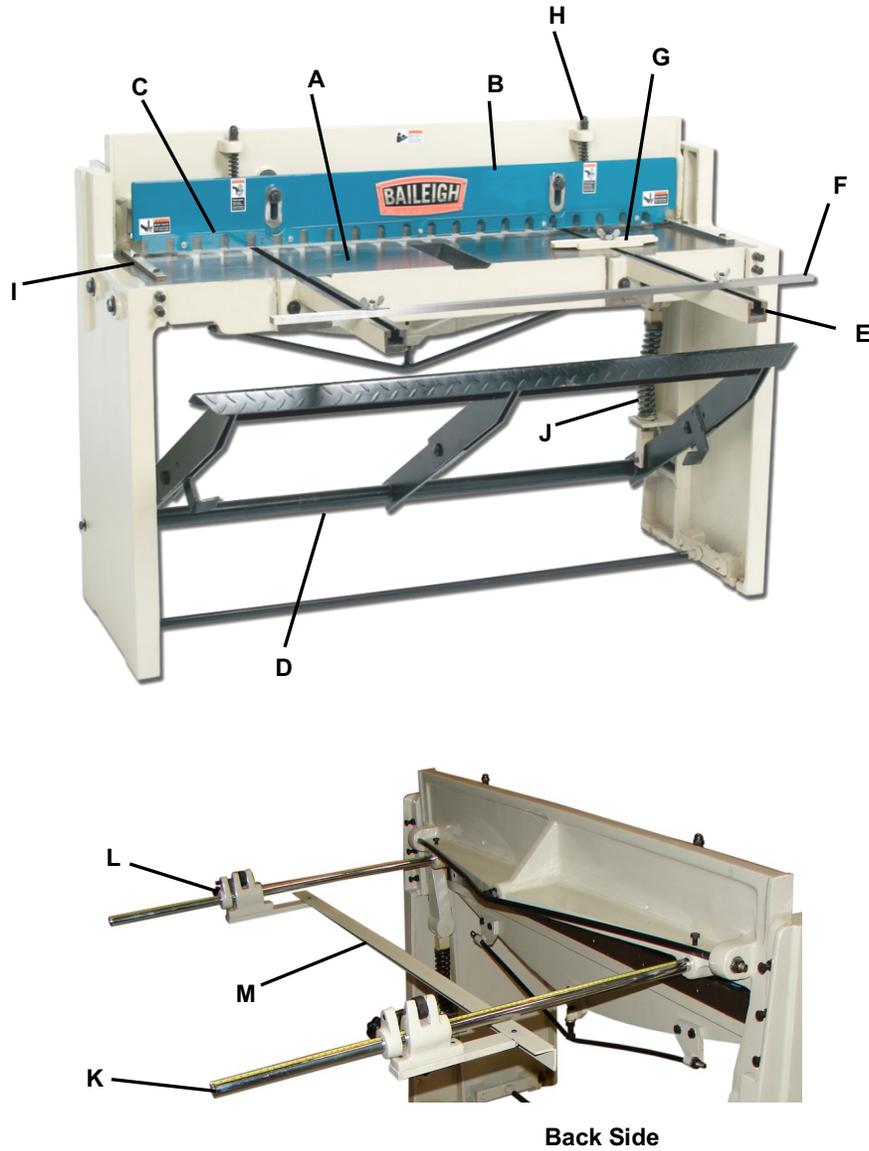


Figure 4-1

Table 4-1

Item	Description	Function
A	Table	Machined surface for loading material
B	Hold down	Spring loaded bar to secure material
C	Safety shield	Clear plastic guard attached to hold down
D	Foot pedal	Used to lower the top blade for shearing
E	Front arm extensions	Provides material support at load end
F	Front Stop	Adjustable with T-slot
G	Miter guide	Use for angled cuts of smaller material
H	Hold down adjusting springs	Allows hold down to adjust to various heights
I	Graduated side guide	Keeps material square to the shear blade
J	Blade return spring	Dual springs to raise top blade to up position

Item	Description	Function
K	Blade return spring	Used to support micro-adjust and back stop
L	Micro-adjuster	Use to accurately set back stop position
M	Back gauge stop	Set and use for repeat shearing

4.1 Overall Dimensions

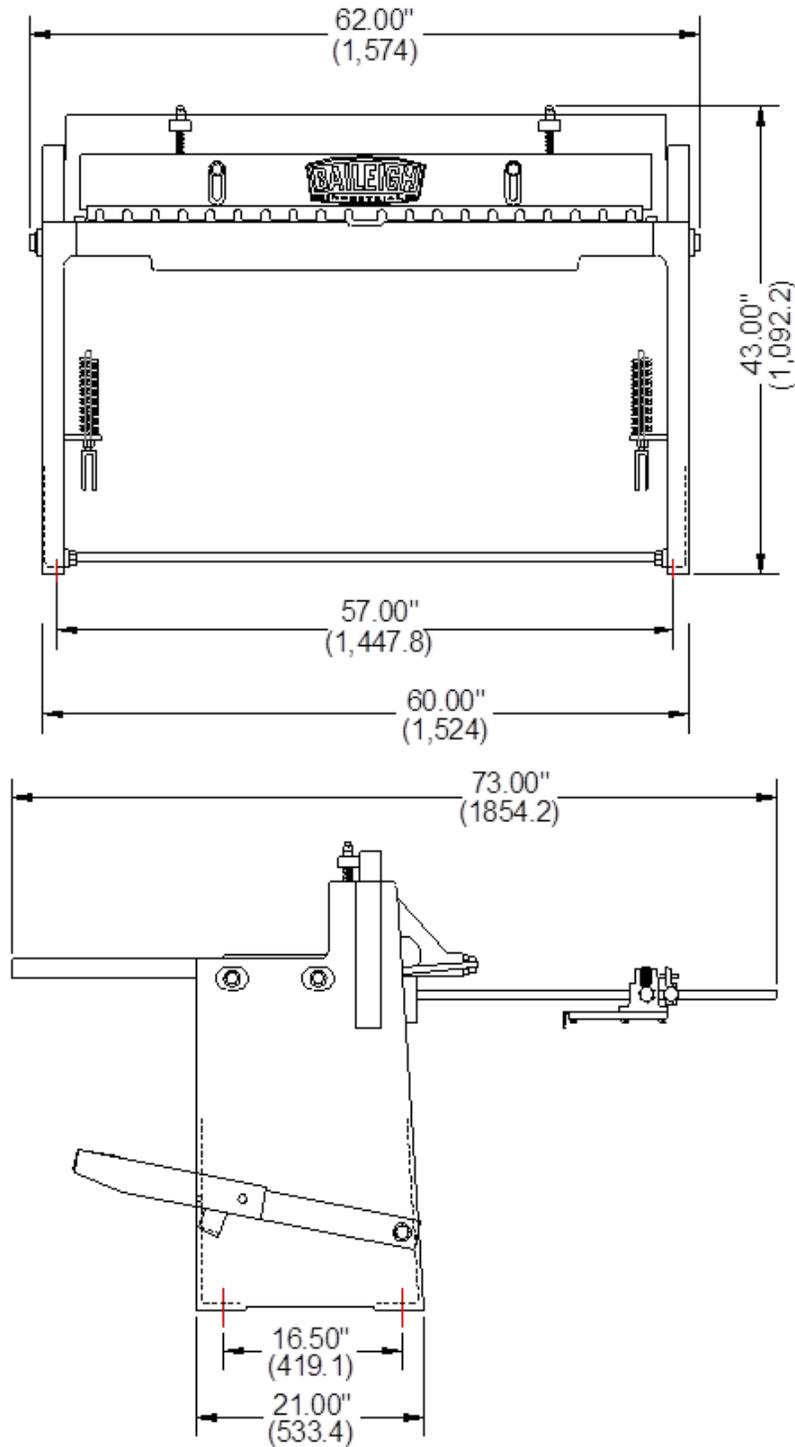


Figure 4-2

5.0 Specifications

Table 5-1

Model Number	SF-5216E
Stock Number	BA9-1007020
General Specifications	
Maximum Shear Length	52" (1321mm)
Maximum Material Thickness	16 ga. (1.52mm) mild steel* 20 ga. (.912mm) stainless steel**
Minimum Material Thickness	24 ga. (0.607mm)
Front Gate Length	20" (508mm)
Back Gate Length	33" (838mm)
Blade Angle	1° / 40ft (12.19 m)
Power Requirements	Manual
Weights and Dimensions	
Shipping Dimensions (L x W x H)	66" x 30" x 46" (1676 x 762 x 1168mm)
Shipping Weight	1199 lbs. (544 kg)
Based on a material tensile strength of *65000 PSI – mild steel **100000 PSI – stainless steel	

⚠️ 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.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.

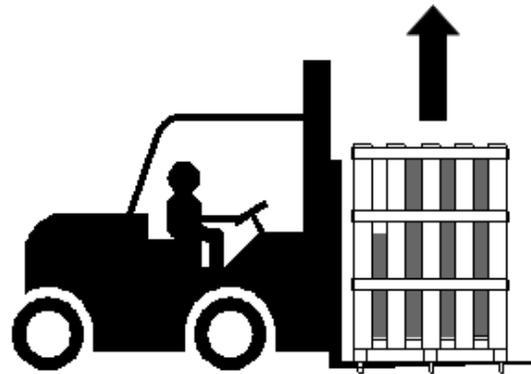


Figure 6-1

- Use a fork lift 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.

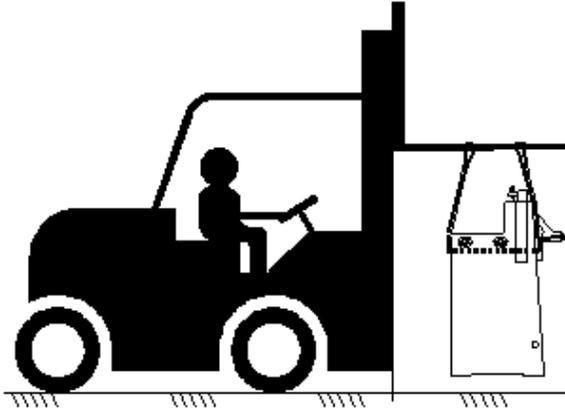


Figure 6-2

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, 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 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.

6.4.1 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.

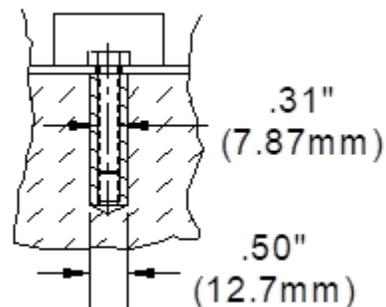


Figure 6-3

6.5 Assembly



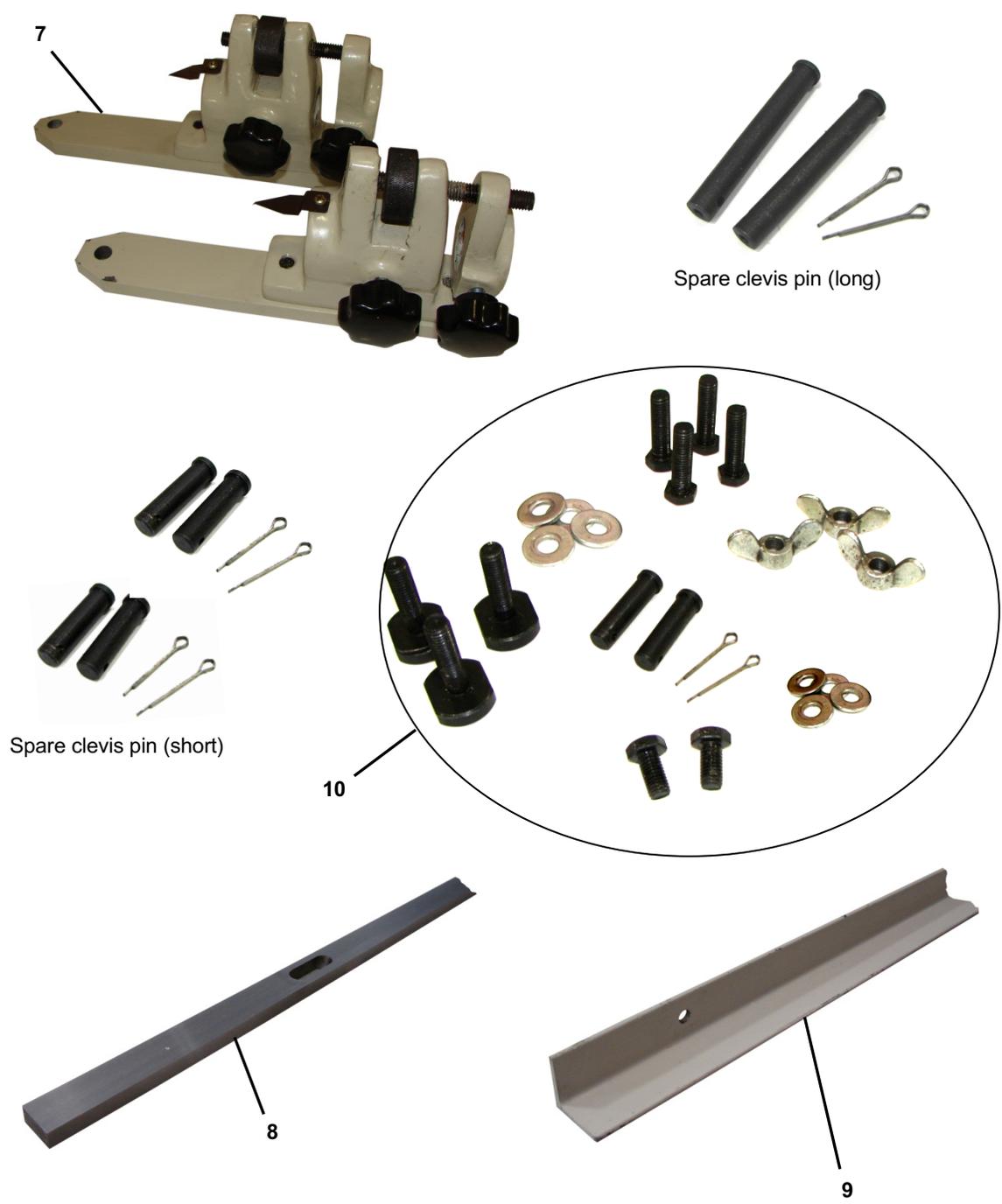


Figure 6-4

Table 6-1

Item	Description	Qty.
1	Shear Body	1
2	Foot Pedal	1
3	Pedal Pivot Shaft	2
4	Miter Guide	1
5	Back Gauge Shaft	2
6	Front Arm Extensions	2

Item	Description	Qty.
7	Micro adjuster Assembly	2
8	Front Stop	1
9	Back Gauge Stop	1
10	Hardware	1
	T-Bolt M12	3
	Flat Washer M12	8
	Wing Nut M12	3
	Hex Head Bolt M12 x 45mm	4
	Hex Head Bolt M10 x 20mm	2
	Clevis Pin (short)	1
	Cotter Pin 3/32 x 1" (2.36 x 25.4mm)	2
Spare Parts		
	Clevis Pin (Long)	2
	Clevis Pin (short)	4
	Cotter Pin 3/32 x 1" (2.36 x 25.4mm)	4

6.5.1 Machine Assembly

The foot pedal needs to be attached to the shear frame. See (fig.6-5) below for the finished pedal assembly.



Figure 6-5

Installation Procedure



Figure 6-6

1. Lay the pedal on the floor and insert (2) short clevis pins as indicated by the arrows in (fig.6-6). Secure with cotter pins.
2. Move the pedal into position between the legs of the shear and attach to the yokes with short clevis pins as in (fig.6-7). Secure with cotter pins.

3. Now line up the hole in the tube with the hole in the frame and insert the pivot pin. Do this on both ends of the pedal. Secure the pin with the hex capscrew.

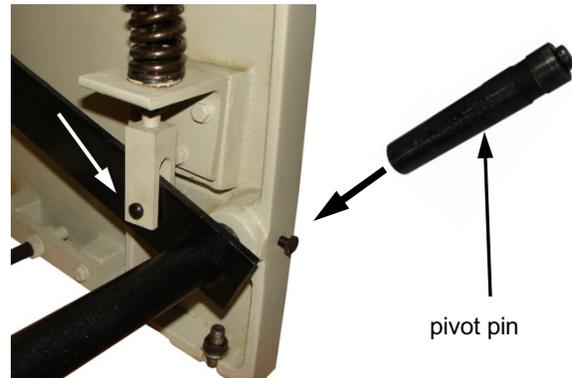


Figure 6-7

Note: Grease the pins before inserting.

6.6 Installing Front Extension Rails



Figure 6-8



Figure 6-9

1. Attach (4) M12 hex bolts and (4) flatwashers to the machined rail pads as in (fig. 6-8).
2. Slide the rail onto the capscrews and behind the flatwashers.
3. Line up the rail channel with the channel on the table, making sure the top machined surfaces are flush.
4. Tighten the capscrews making sure the rails stay aligned to the table.
5. Fig. 6-10 below shows the proper installation of the foot pedal, front rails, work stops, and small workpiece push plate (when needed).



Figure 6-10

6.7 Installing the Rear Gauge Shafts

1. Slide the gauge shafts into the housing hole with the scales facing up and tighten each capscrew as shown in (fig. 6-11).



Figure 6-11

2. Slide the micro-adjustment assemblies onto the shafts and position them at the same location using the scales as a reference. Secure them to the shaft using the hand knobs.



Figure 6-12

3. Set the stop angle on the mounting bars and bolt up from the bottom (fig. 6-13).



Figure 6-13

7.0 Machine Functions

7.1 Foot Pedal

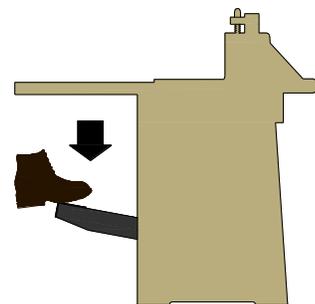


Figure 7-1

Stepping down on the foot pedal does two things. First it lowers the hold downs which keep the piece part from moving during a cut. Second it lowers the top blade past the lower blade to shear the material.

7.2 Front and Rear Extension Rods

The front extensions help support large sheets of material and the rear extensions provide support for the micro-adjusters.

7.3 The Rear Stop Angel

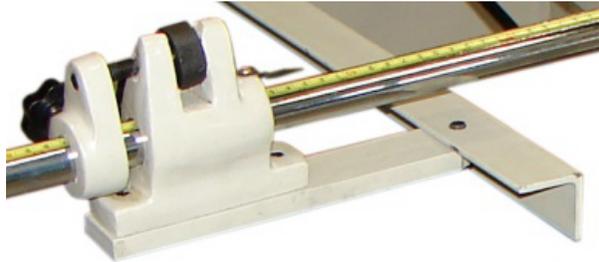


Figure 7-2

When doing repetitive shearing the stop angle can be set at a precise dimension using the scales and the micro-adjusters. It also helps to keep the piece part aligned to the blades.

7.4 Stops and Guides

The front stop and small piece push plate are easily adjusted with wing nuts. The front stop bar is slotted which allows it to be positioned at an angle while in the T-slot. The push plate slides in either T-slot and can be rotated for angle shearing of smaller piece parts.

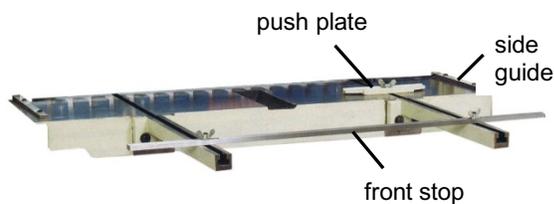


Figure 7-3

7.5 Miter Angle Guide

To use the miter angle guide:

1. Loosen the wing nut.
2. Lay your piece part against the straight edge.
3. Position the miter guide at the angle and distance you required from the shear blades.
4. Make the cut.



Figure 7-4

7.6 Material Support Arm

CAUTION

When handling large piece parts, you may require assistance in handling the piece as it exits the blades. Failure to adequately support the piece part may result in the piece falling and causing bodily injury.

The two material support arms (A) attach to the front of the shear as shown in (fig. 7-5). Remove the cap screws and washers, Position each arm and secure with the washer and cap screw. (Make sure the arms are centered to the table slots and are flush with the top of the table.) The front gauge (H) can now be inserted in the arm slots.



Figure 7-5

7.7 Micro-Adjusting Stop

These adjustable stops allow for accurate placement of the stop angle. Set the stop close to where you need to be on the graduated scale. Finger tighten knob "A" to secure the back housing to the shaft. Make sure knob "B" is loose. Turn the thumb wheel to position the front half of the housing which has the indicator. Turn knob "B" (cw) clockwise to hold in position. Repeat for the other side.

Note: When using for the first time, verify the dimension "X" from the face of the lower blade to the front edge of the stop angle. See (fig. 7-7).

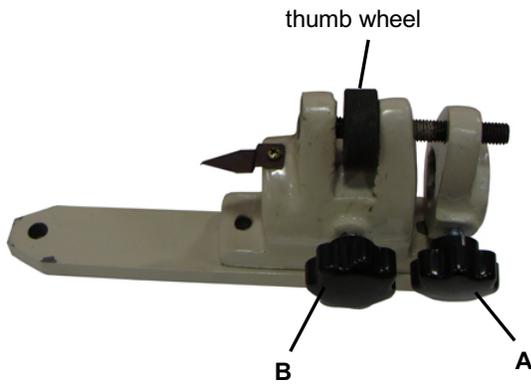


Figure 7-6

It should match the dimension shown on the scale indicator. If not, re-adjust the position of the gauge shafts in the mounting holes, either IN or OUT. Retighten the hex bolts.

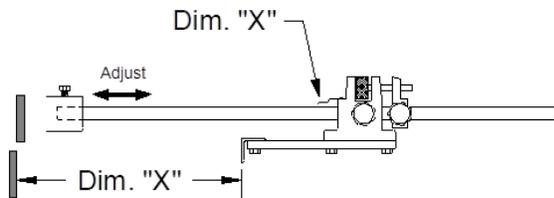


Figure 7-7

8.0 The Shearing Cycle

⚠ WARNING

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

⚠ WARNING

The shearing blade poses an amputation hazard. Make sure no body part or clothing is near the specific hazard. Failure to follow this warning could result in severed or crushed fingers.

⚠ WARNING

DO NOT remove the clear plastic finger guard under any circumstances. It is provided to keep your fingers away from the blades.

⚠ WARNING

NEVER put any part of your body under or behind this guard and in the path of the hold downs which can crush.

1. When planning your cut, either scribes a line on the material or use the side scale which measures the distance to the blade.
2. The scale is graduated in both inches and millimeters.

3. Place the piece part on the table top and slide over to the right guide bar. Align the scribed line with the edge of the lower blade.
4. Step down on the foot pedal until the cut has been completed.
5. If you are making multiple pieces of the same length, set the rear stop to the needed length. Each consecutive piece is then pushed up to the stop angle and sheared.
6. If the material exceeds the length of the extension arms, be sure and provide additional support.

8.1 Shearing Tips

- To achieve the best results, never shear a piece narrower than 8 times the thickness of the material. An example would be a 1/2" (12.7mm) strip of 16 ga. (.059") (1.5mm) mild steel.
- Keep the blade gap as narrow as possible. The blade gap is the space between the blades passing each other during a stroke. Tighter blade gaps cut material without rolling it over. Using a blade gap too narrow for thicker material prevents the material from moving between the blades and stalls the cut. On the other hand, a gap too wide will cause the material to fold over. The wide gap for thinner material does not set the blades close enough to cleanly cut the material.

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.

9.1 Material Equivalency Chart

	16 Ga.	18 Ga.	20 Ga.
Mild Steel	.060" (1.52mm)	.048" (1.22mm)	.036" (.91mm)
Stainless Steel	—	—	.031" (.78mm)
Cold Rolled Steel	.048" (1.22mm)	.035" (.89mm)	.030" (.76mm)
Aluminum	.100" (2.54mm)	.090" (2.28mm)	.063" (1.60mm)
Soft Brass	.072" (1.83mm)	.064" (1.63mm)	.051" (1.29mm)
Half Hard Brass	.064" (1.62mm)	.051" (1.29mm)	.036" (.91mm)
Hard Brass	.054" (1.37mm)	.051" (1.29mm)	.036" (.91mm)
Bronze, Annealed	.064" (1.62mm)	.051" (1.29mm)	.040" (1.02mm)
Soft Copper	.072" (1.83mm)	.064" (1.62mm)	.051" (1.29mm)
Hard Copper	.064" (1.62mm)	.051" (1.29mm)	.040" (1.02mm)

Figure 9-1

10.0 Blade Clearance

The blade gap on the shear was set at the factory. At this setting it will shear mild steel up to 16 ga. (1.52mm) and stainless steel up to 20 ga. (.912mm). To measure the blade gap, gradually lower the top blade and measure the gap going from left to right while facing the rear of the machine. The gap should be .005" (.12mm) with the blades perfectly parallel all the way across the cutting edges. The chart below shows the suggested blade clearances with .005" (.13mm) as the average between .002" (.05mm) and .009" (.23mm).

SUGGESTED BLADE CLEARANCE	
METAL THICKNESS	BLADE CLEARANCE
Up to 16 ga	.002" - .005" (.05mm - .13mm)
14 ga.	.003" - .006" (.07mm - .15mm)
12 ga.	.004" - .008" (.10mm - .20mm)
10 ga.	.006" - .009" (.15mm - .23mm)

Figure 10-1

Under no circumstances do you want the blades making contact with each other as this can cause blade breakage as well as premature dulling of the cutting edges.

SHEARING STRENGTH OF MATERIALS		
MATERIAL	TONS/SQ. IN.	FACTOR
Mild Steel (.25 Carbon)	25	1.00
Mild Steel (.50 Carbon)	30	0.83
Stainless Steel	38	0.65
Boiler Plate	30	0.83
Spring Steel (1.99 Carbon)	42	0.60
Tool Steel - Not Tempered (1.20 Carbon)	45	0.56
Tool Steel - Tempered (1.20 Carbon)	95	0.26
Nickel Steel (0.5% Nickel)	41	0.61
Aluminum Sheet	10	2.50
Brass	13	1.92
Copper	12.5	2.00
Lead	1.5	16.67
Tin - Coated Sheet Steel	25	1.00
Zinc	8.5	2.94
Galvanized Steel Sheet	25	1.00

Figure 10-2

Note: How to use this table: The shear is rated 16 ga. (.0598") in mild steel. What thickness can it cut of other materials?
 $(.0598) \times (\text{material factor}) = \text{materials thickness.}$

11.0 Adjustments

11.1 Hold down Adjustment

The hold down, when properly adjusted, secures the piece part while being sheared, and prevents the operator's fingers from getting in the cutting blades

path. The ideal adjustment allows only enough clearance to slide the piece part under the hold down. (Approximately .125" (3.17mm).

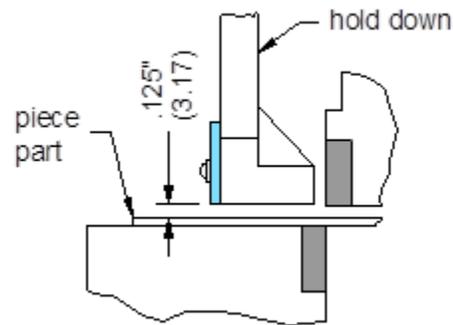


Figure 11-1

1. Turn the hex nuts on the spring's clockwise (**cw**) to raise the hold down plate.

Note: The fixing bolt must be loose enough to allow the hold down plate to travel up and down freely.

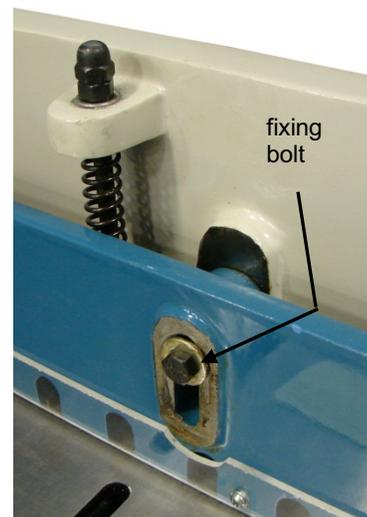


Figure 11-2

2. Insert adequate shim stock under the hold down. Turn the nuts on the spring counterclockwise (**ccw**) until the hold down rests on the shim.
3. Repeat step 2 for the other side.
4. Check that the gap distance is equal end to end.

Note: If material scratching is a problem you can apply a thin rubber pad to the bottom of the hold down feet.

11.2 Gib Adjustment



Figure 11-3

The gib adjustment is to remove unwanted slide movement and eliminate binding. Loose gibs can cause poor cuts on the piece part and unnecessary wear on the slides. Over tightening them can cause unnecessary wear of the slides and difficulty in lowering the foot pedal.

Loosen the jam nuts and tighten each gib bolt until snug. Now back off each bolt about 1/8 turn and retighten the jam nuts. Check for binding by pushing and pulling on the top of the cutting frame.

11.3 Adjusting the Blade

The blade adjustment was set at the factory. Try a few test cuts to see if it is adequate for your needs. Follow the procedure that follows if an adjustment is required.

1. Loosen, but do not remove the four table adjustment bolts, located at the front of the shear, and the four table slide bolts located at each end of the shear.
2. Have an assistant step on the foot pedal to lower the blade into position.
3. Turn the table adjustment screws to move the table with the fixed blade either in or out until it makes light contact with the upper moving blade.

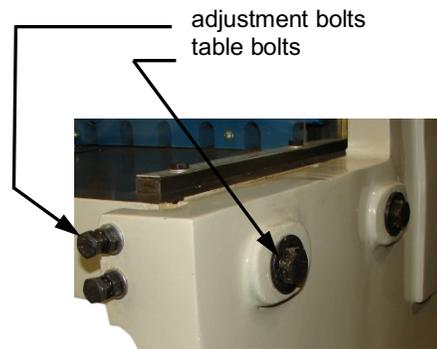


Figure 11-4

CAUTION

To avoid blade damage, the upper (moving) blade must NEVER overlap the lower (fixed) blade.

4. With the upper blade still in the down position, look down at the blades from behind the hold down. They should be parallel and make light contact across the full length. If they do, proceed to step 5. If you notice a gap between the two blade surfaces, contact the service department at Baileigh Industrial (920.684.4990) for assistance in adjusting the bow.
5. Using a sheet of paper, make a series of cuts along the length of the blade. The paper should cut cleanly.
6. Turn the table adjustment screws counterclockwise (**ccw**) to move the fixed blade away from the moving blade. Using a feeler gauge set the gap to .002" (.051mm).
7. Check the .002" (.051mm) gap along the entire length.
8. Tighten the four table bolts and recheck the gap.

11.4 Blade Replacement and Sharpening

Blade bolts



Figure 11-5

To remove either blade from the casting you must loosen and remove the cap screws and washers.

The upper (moving) blade has two cutting edges each with a 2° edge relief. The blade can be sharpened by surface grinding both wide sides. The lower (fixed) blade has one cutting edge with a 2° edge relief and a 1° face relief. It can be sharpened by surface grinding the wide side of the blade.

12.0 Maintenance

⚠ 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.

12.1 Daily Maintenance

- Check daily for any unsafe conditions and fix immediately. (Cracked castings, welds, worn pins and shafts)
- Check that all bolts and nuts are secure.
- Keep area around machine clear of debris.

12.2 Weekly Maintenance

- Clean the machine and the area around it.
- Apply rust inhibitive lubricant to all non-painted surfaces.
- Keep threads, T-slots, shafts, and pivot pins properly lubricated.
- Keep guards attached and in good working order.
- Make sure grease fitting locations are kept lubricated.
- Check back gauge components for lubrication.

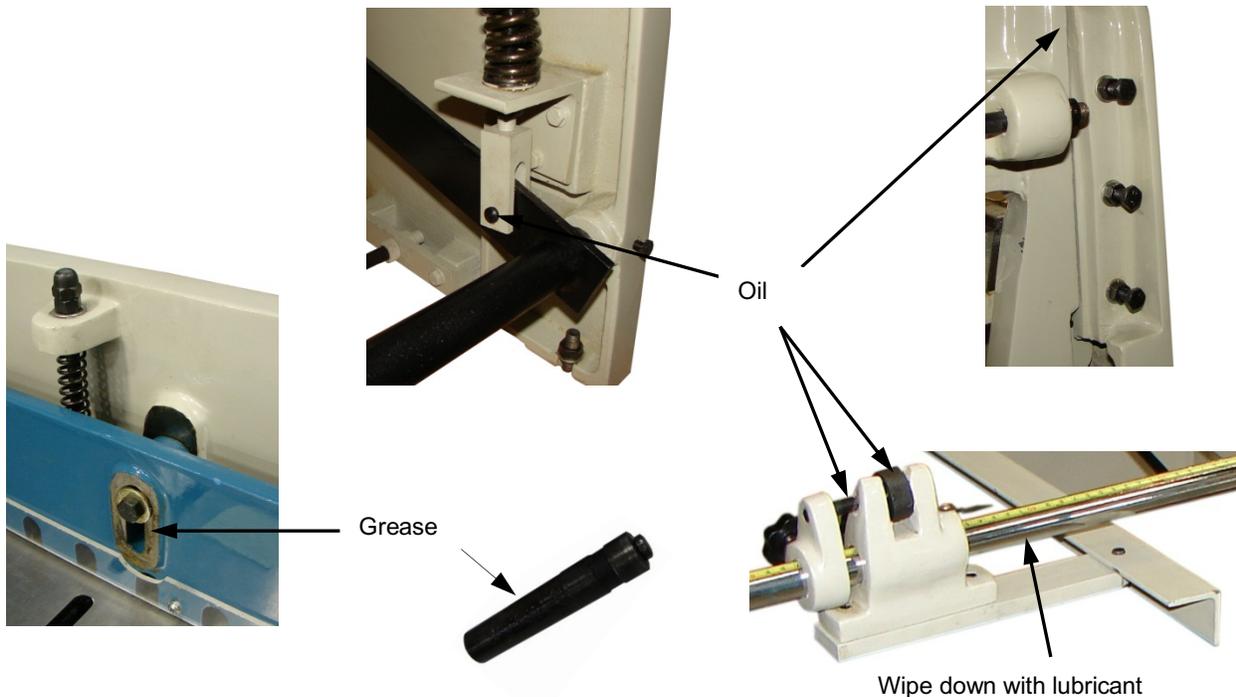


Figure 12-1

13.0 Troubleshooting

Table 13-1

FAULT	PROBABLE CAUSE	REMEDY
CUTS NOT SQUARE	Contact with guides is uneven.	Check and maintain consistency.
	Not enough hold down force.	Adjust hold down gap.
	Blade gap is unequal along length.	Adjust blade gap.
	Blade has a bow.	Consult the Baileigh service department. (920.684.4990)
CAN NOT CUT MATERIAL	Improper blade gap.	Widen gap for thicker material.
	Material thickness beyond machine capacity.	Stay within machine capabilities.
POOR QUALITY SHEARING	Blades are dull.	Either sharpen blades or replace them.
	Blade gap not set properly.	Check and reset gap.
	Gibs are loose.	Adjust gib bolts.

14.1.2 Foot Shear Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	BA9-1022694	Work Table		1
2	BA9-1013926	Frame		1
3	BA9-1022695	Pressing Plate		1
4	**	Right Stand		1
5	**	Left Stand		1
6	BA1-9690	Connecting Rod		2
7	JT9-TS-1492021	Hex Cap Screw	M12X30	2
8	BA9-1021366	Spring		2
9	BA9-1007028	Threaded Stud		2
10	JT9-TS-2331121	Acorn Nut M12	M12	2
11	JT9-TS-1499141	Hex Cap Screw	M12X80	2
12	**	Flat Washer	M12	6
13	BA9-1010956	Finger Guard		1
14	JT9-TS-1534052	MACH Screw, Pan HD, Phillips	M6X16	5
15	**	Workpiece Stop		2
16	**	Scale		2
17	JT9-TS-1490041	Hex Cap Screw	M8X25	4
18	JT9-TS-1491101	Hex Cap Screw	M10X60	2
19	**	Hex Cap Screw	M10X55	2
20	**	Flat washer	M10	22
21	**	Hex Cap Screw	M16X120	4
22	**	Flat Washer	M16	4
23	**	Hex Nut	M16P2.0	4
24	**	Upper Blade		1
25	**	Lower Blade		1
26	JT9-TS-1505071	Socket Head Cap Screw	M10X45	9
27	JT9-TS-1505081	Socket Head Cap Screw	M10X50	8
28	**	Flat Washer	M10	9
29	**	Flat Washer	M6	8
31	BA9-1022696	Gib Plate		2
32	JT9-TS-1491101	Hex Cap Screw	M10X60	6
33	BA1-4401	Hex Nut	M10P1.5	10
34	BA9-1007022	Straightener Rod		1
35	JT9-TS-155009	Flat Washer	M14	2
36	JT9-TS-154009	Hex Nut	M14P2.0	2
37	BA9-1009764	Adjusting Bolt	M16X60	1
38	JT9-TS-1540081	Hex Nut	M12P1.75	2
39	**	Flat Washer	M16	5
40	**	Hex Cap Screw	M10X40	2
41	BA9-1231470	Spring		2
42	**	Spring seat		4
43	BA9-1007023	Upper Connecting Block		2
44	BA9-1017487	Lower Connecting Block		2
45	BA9-1017488	Threaded Stud		2
46	**	Flat Washer	M16	2
47	**	Hex Nut	M16P2.0	2
48	BA9-1225186	Connecting Angle		2
49	CM9-TS-1491031	Hex Cap Screw	M10X25	6
50	JT9-TS-2310201	Hex Nut	M20P2.5	4
51	BA9-1017576	Upper Pin		4
52	**	Lower Pin		6
53	BA9-1017492	Foot Stand Pin		2
54	BA9-1017493	Foot Stand Frame		1
55	BA1-9631	Draw bar		1
56	**	Upper Pin		3
57	JT9-TS-1492011	Hex Cap Screw	M12X25	4
58	CM9-TS-1491031	Hex Cap Screw	M10X25	2
59	BA9-1012526	Stop Angle		1
60	BA9-1007024	Mounting Bar		2

Index No.	Part No.	Description	Size	Qty
61	**	Adjustment Housing		2
62	**	Adjusting Nut		2
63	**	Threaded Shaft		2
64	JT9-TS-1491041	Hex Cap Screw	M10X30	2
65	**	Hand Knob	M8X25	4
66	**	Fine Adjustment Housing		2
67	**	Straightener Rod		2
68	JT9-TS-1491021	Hex Cap Screw	M10X20	4
69	BA9-1007026	Gauge Shaft		2
70	**	Hex Nut	M16P2.0	1
71	BA9-1009737	Workpiece Pushing Plate		1
72	**	Flat Washer	M12	9
73	BA9-1007027	T-Style Bolt	M12	3
74	BA9-1231439	Wing Nut	M12	3
75	BA9-1008799	Small Workpiece Push Plate		1
76	**	Cotter Pin	3X30	10
77	**	Flat Washer	M6	5
78	**	Scale		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.

15.0 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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