Operating Instructions and Parts Manual

Manual Roll Bender

Model R-M10

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

BA9-1006846
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1.0 Table of Contents

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.

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 R-M10 Manual Roll 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 Product Identification

4.1 Overall Dimensions

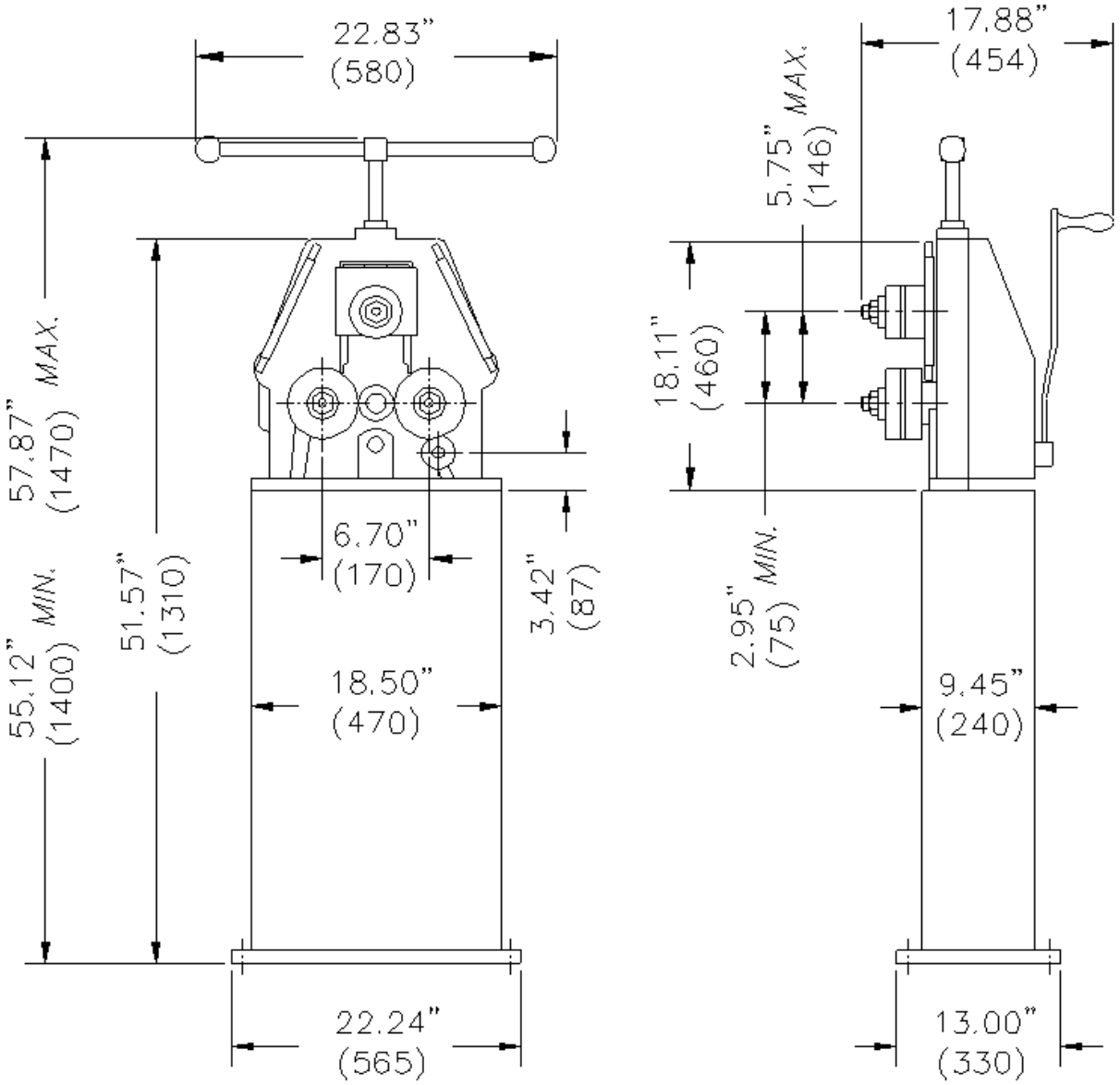


Figure 4-1

4.2 Standard Roller Dimensions

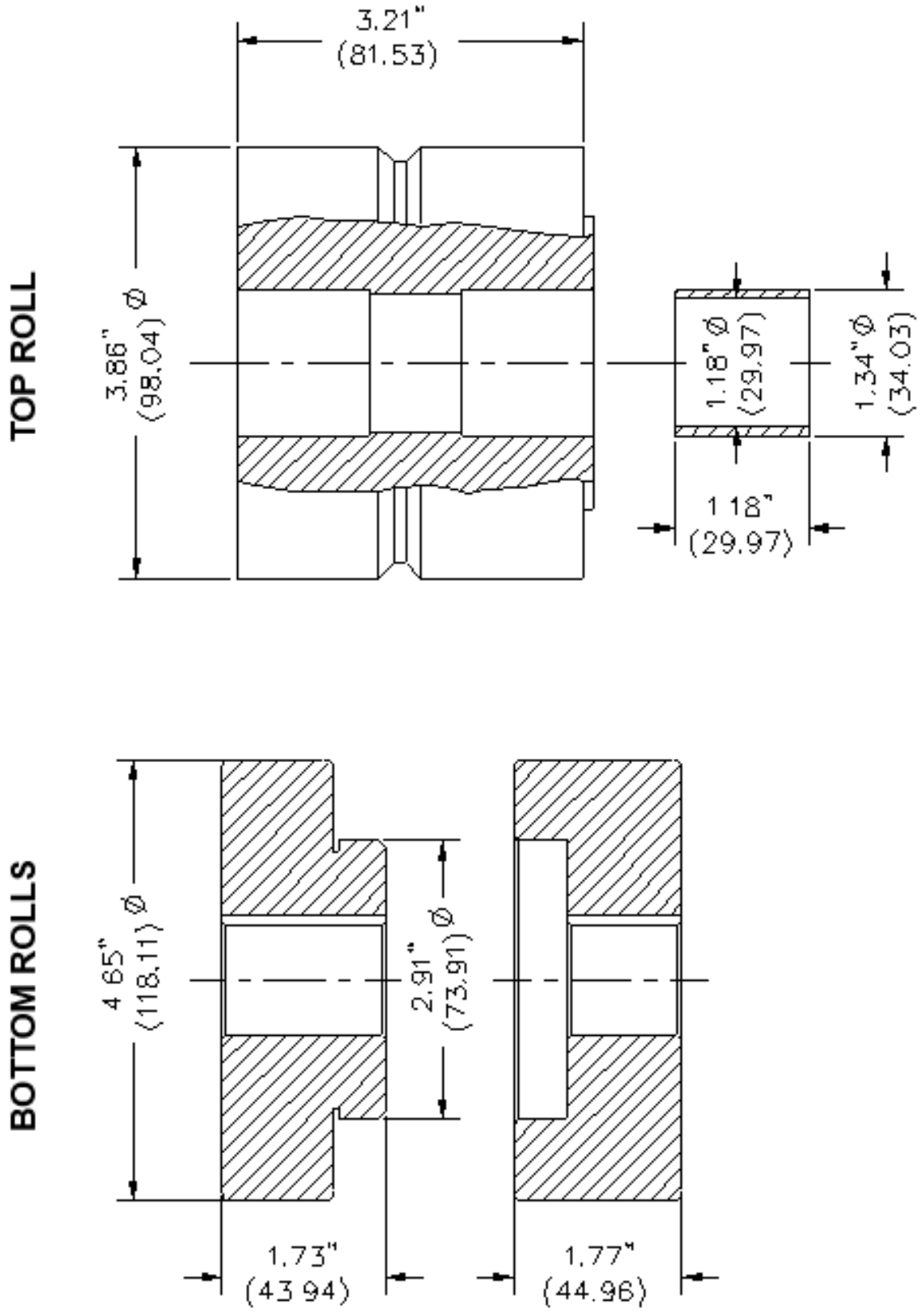


Figure 4-2

Roll material SAE 1050 hardened to 56 HRC

Note: Special rollers are available from Baileigh Industrial Inc.

5.0 Specifications

Table 5-1

Model number	R-M10
Stock Number	BA9-1006846
Power	
Power	Manual
General Specifications	
Shaft Center Distance	6.7" (170mm)
Shaft Diameter	1.181" (30mm)
Roll Adjustment	Manual
Lower Roll Diameter	4.65" (118mm)
Pinch	Single
Round Tube Capacity	Size: 1.25" (.078") / Min. Dia.: 31.5" [31.75mm (2mm) / Min. Dia.: 800mm]
Solid Round Capacity	Size: .875" / Min. Dia. 20" [22mm / Min. Dia. 508mm]
Pipe Capacity (sch. 40)	Size: 1" / Min. Dia.: 28" [25.4mm / Min. Dia.: 711mm]
Square Capacity	Size: 1.25" / Min. Dia.: 10" [31.75mm / Min. Dia.: 254mm]
Square Tube Capacity	Size: 1.25" (.078") / Min. Dia.: 35" [31.75mm (2mm) / Min. Dia.: 889mm]
Angle Iron Capacity	Size: 1.25" (.157") / Min. Dia.: 30" [31.75mm (4mm) / Min. Dia.: 762mm]
Flat Bar Easy Way	Size: 1.96" (.39") / Min. Dia.: 15.75" [50mm (9.9mm) / Min. Dia.: 400mm]
Flat Bar Hard Way	Size: 1.18" (.39") / Min. Dia.: 19.685" [29.9mm (9.9mm) / Min. Dia.: 500mm]
Weights and Dimensions	
Shipping Weight	435 lbs. (197kgs)
Shipping Dimensions	60" x 44" x 68" (1524 x 1118 x 1727mm)
Based on a material tensile strength of *60000 PSI – mild steel	

5.1 Available Options

- Special rolls for pipe, tube, and profile bending
- Extended roll shafts

Many different profiles, pipes, and tubes can be bent by your Baileigh R-M10 manually powered roll bender. To achieve consistent results you must also use good quality materials. Find a reputable steel distributor in your area to supply all your steel needs.

⚠WARNING **DO NOT feed profiles having a thickness greater than specified for the capacity of the machine. DO NOT feed more than one piece at a time. DO NOT use machine for purposes other than designed for.**

⚠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.
- 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.

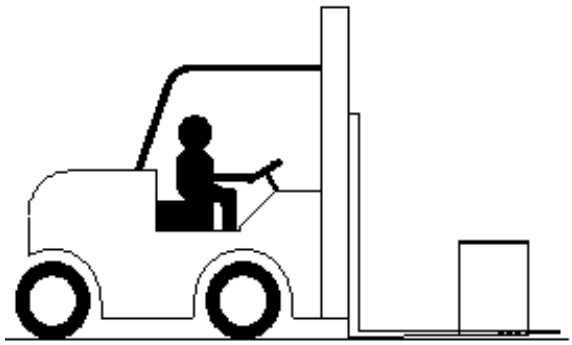


Figure 6-1

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.

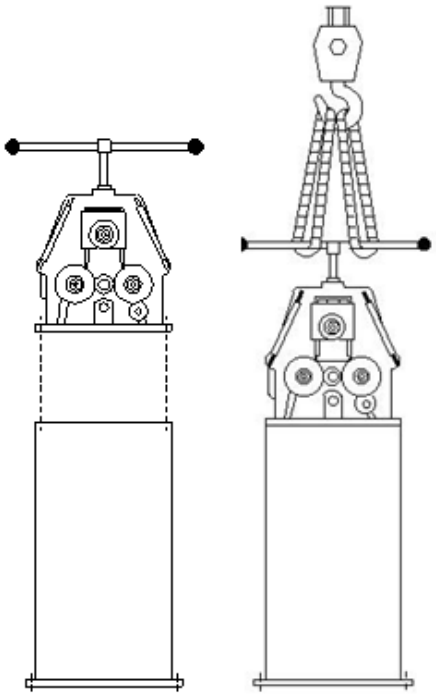


Figure 6-2

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.

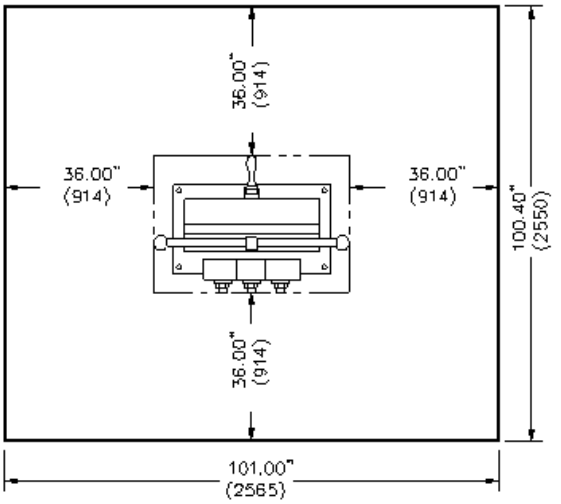


Figure 6-3

6.4.1 Securing the Base

⚠WARNING

Before operating, make sure it is positioned firmly on a solid level floor. If it tips over on you, it could cause severe injury or death.

The accuracy of any machine depends on the precise placement of it to the mounting surface.

Place shims under the four feet mounted in the base as required for leveling.

- For safe operation, the machine needs to be bolted to the floor with anchor bolts.
- Because the R-M10 does not run at high speed, it is not necessary to use vibration dampers.
- For proper operation the machine must be placed on a flat, preferably concrete surface and properly leveled.

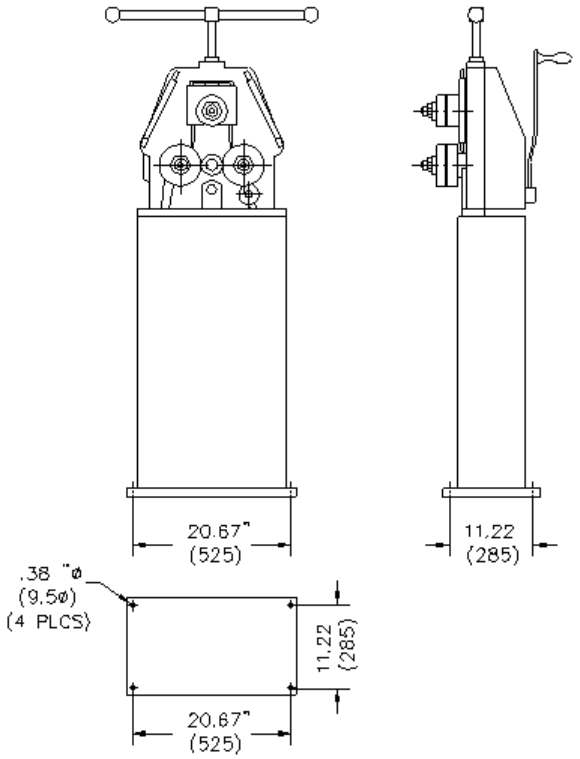


Figure 6-4

6.4.2 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.

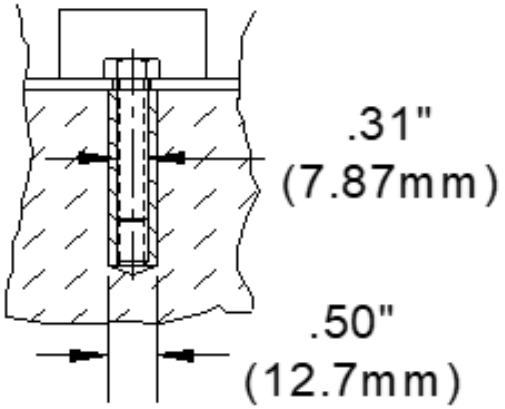


Figure 6-5

6.5 Assembly

⚠WARNING

For your own safety, DO NOT connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.

- After preparing the base to be secured to the floor, mount the head to the base using the bolts provide.
- Clean the rust inhibitor off of the entire machine and lubricate the moving and bare metal parts with 30 or 40 weight non-detergent motor oil or equivalent.
- Open the back cover and lightly grease the gears and pinch adjustment screw using a general purpose grease.

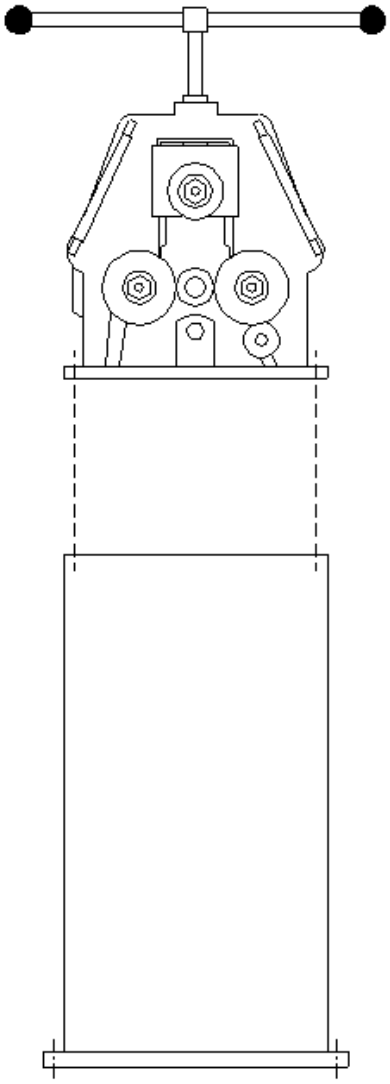


Figure 6-6

7.0 Mounting the Rolls

Rolls must be mounted correctly, depending on the type of profile to be bent. This will save the machine from undue stress and limit defects in the profile.

To change rolls, use the (supplied) wrench to remove the nuts. The two lower shafts are connected to the drive so they will not spin. The upper freewheeling shaft can be manually held with a wrench. After changing rolls, replace and tighten nut to shaft.

To find the distance needed between the top and bottom rolls, place a sample of the material to be bent in between the rolls. The groove of the upper roll should be 2-4 mm (.078”-.156”) larger than the thickness of the material. Make a test bend with a sample of your material. This allows you to find the material spring back, and to determine the number of passes needed to achieve the desired radius.

Rolls are keyed to the shaft. When feeling vibrations during the bending process, remove the key from the lower right roller shaft to make the rolls freewheeling.

8.0 Start – Up Instructions

1. Select the proper rolls for material being formed.
2. Place the material on lower rolls.
3. Move the upper roll down, by turning the threaded rotating lever clockwise (cw), until the upper roll contacts the material to be bent.
4. Begin rotating the lower rolls, by turning the hand lever arm that rotates the main powering shaft.
5. It is possible to rotate lower rolls in alternating directions with the turning arm.
6. Bending radius is adjusted by positioning the upper roll at desired level.
7. If a jam or problem occurs, you can immediately stop rotating the hand lever.

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 sheets make sure they are properly supported.

9.1 Operating Instructions

Place the material flat on the rolls as shown in (figure 9-1). Make sure that material is placed parallel to the floor and touching all three rolls at the same time. This condition is called “zero position”.

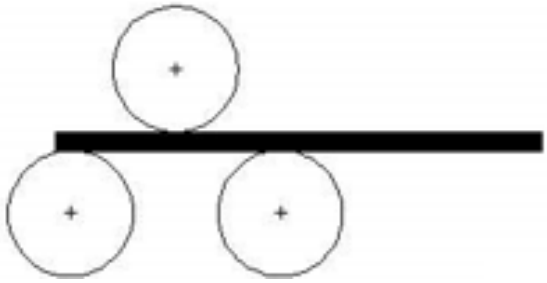


Figure 9-1

Rotate the hand lever to move the upper roll down, as in (figure 9-2), and position it to apply enough force to bend the material. To avoid deforming the piece, DO NOT apply more force than necessary.

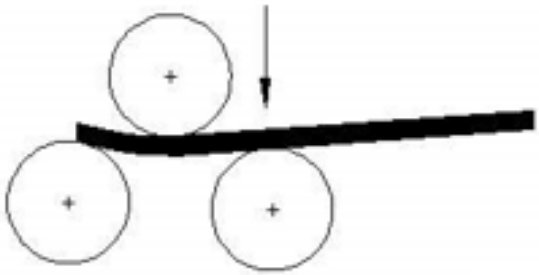


Figure 9-2

To get desired radius, make consecutive passes through rolls (see figure 9-3) using left and right foot pedals and gradually lower the upper roll after each pass. If the radius is larger than needed, move the upper roll down to apply more force. Keep track of your up/down position using the calibrated scale as a guide. This will help ensure consistency of parts.

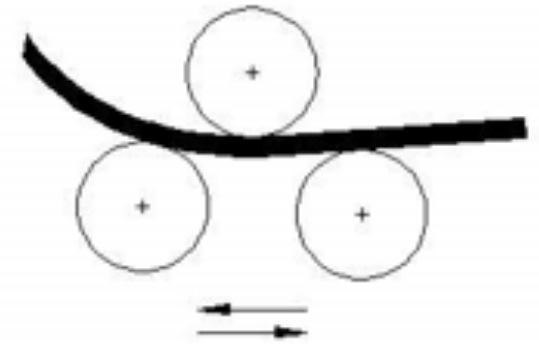


Figure 9-3

To prevent material from bending left or right you must adjust the guide rolls as shown in (figures 9-4).

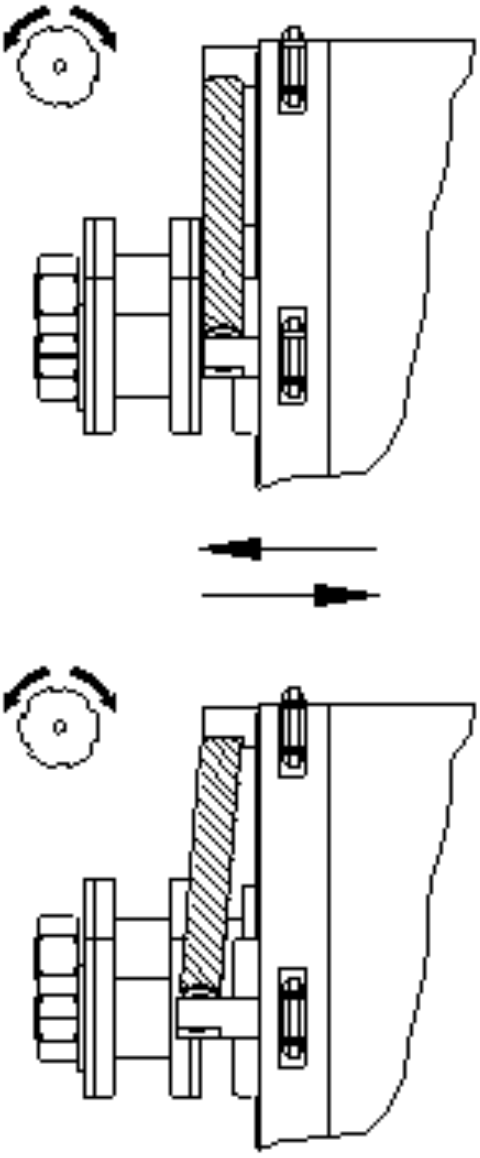


Figure 9-4

As the guides are adjustable on top and bottom, you can arrange them to the opposite direction that the material is inclined to go.

Note: To get a circular profile, side guide joints must be parallel to the machine face, otherwise, you get spiral profiles.

Using optional specials rolls, (figure 9-5) many material profile configurations are possible.

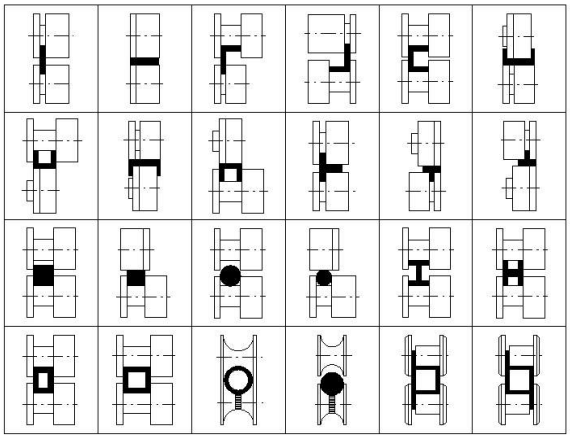


Figure 9-5

When bending long materials, an adjustable feeder conveyor is recommended to keep work piece parallel to floor, allowing for easier loading of Roll Bender. If necessary, the machine can be laid on its back to operate in a horizontal position.

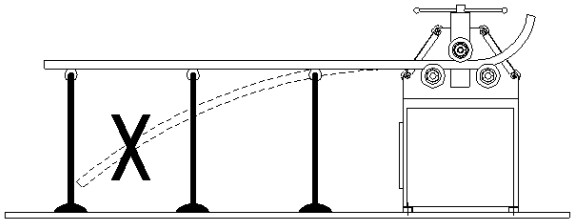


Figure 9-6

10.0 Material Selection

⚠CAUTION

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

When selecting materials keep these instructions in mind:

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

Note: Thorough cleaning of the rolls is necessary to avoid possible sliding of the profile through the rolls.

When bending pipe or tube the outer part of the bend is stretched and the inner section compressed. The result of these opposite and unequal stresses is that the pipe or tube tends to flatten or collapse. To prevent such distortion, the common practice is to support the wall of the pipe or tube in some manner during the bending operation. One such method is to fill the piece with sand and plug the ends. Other methods can be found to achieve favorable results.

Listed below are some of the factors that control or influence the success of a bending operation.

- Mechanical properties of the material being bent
- Thickness of the material to be bent
- Size of the inside bend radius
- Speed at which the bend occurs
- Grain direction of the steel to be bent
- Coefficient of friction
- Roller design

11.0 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.

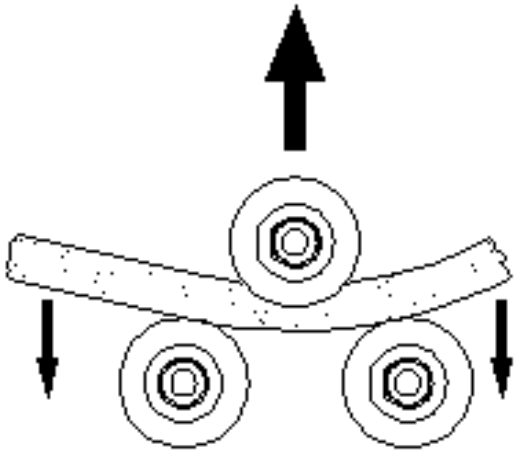


Figure 11-1

12.0 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 of the machine.
- Gears, threaded shafts, and bearings should be greased once a month.
- Also check that all nuts and bolts are properly tightened.

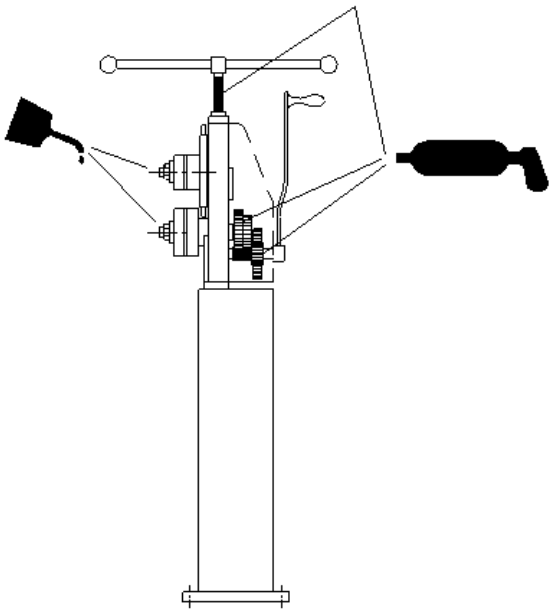
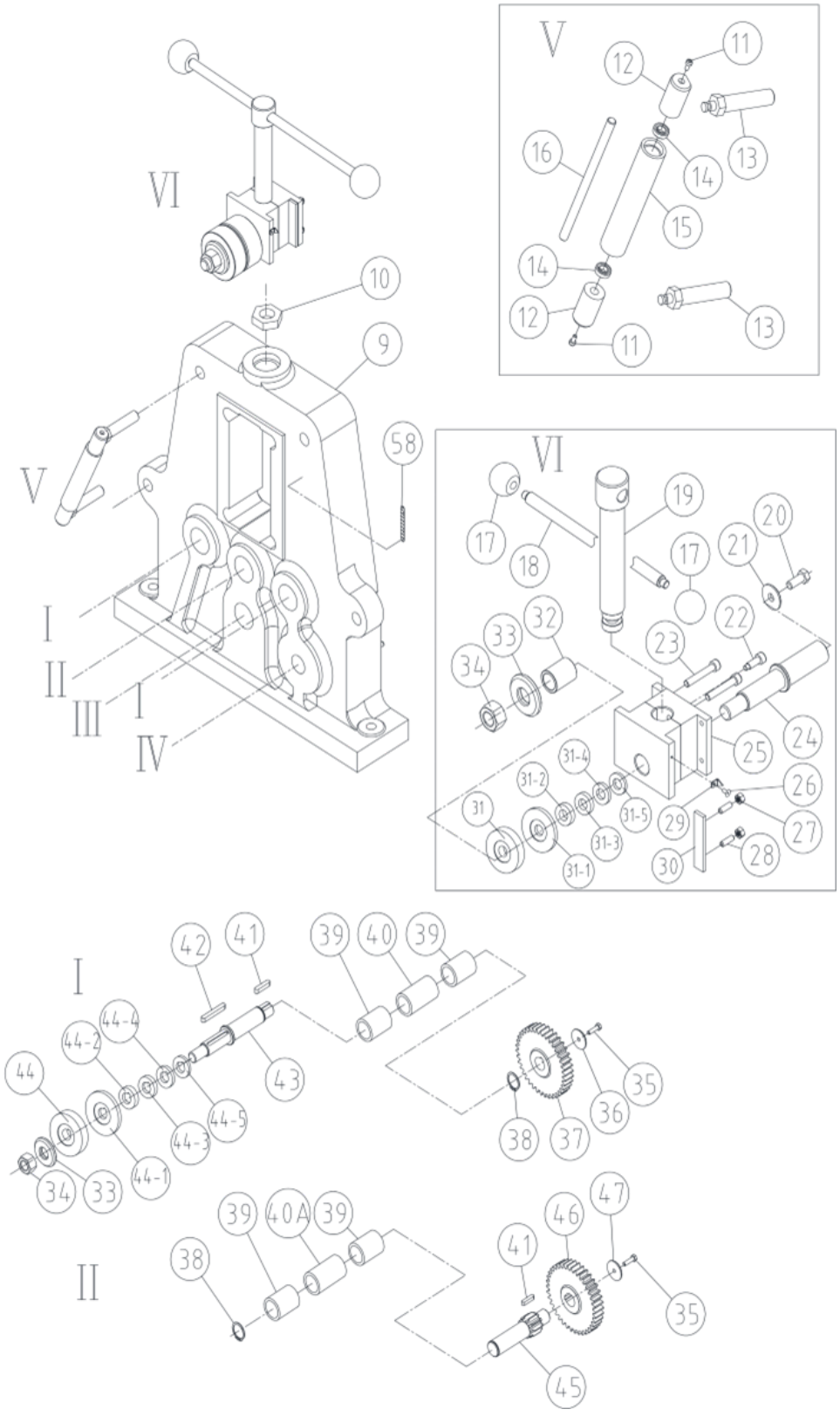


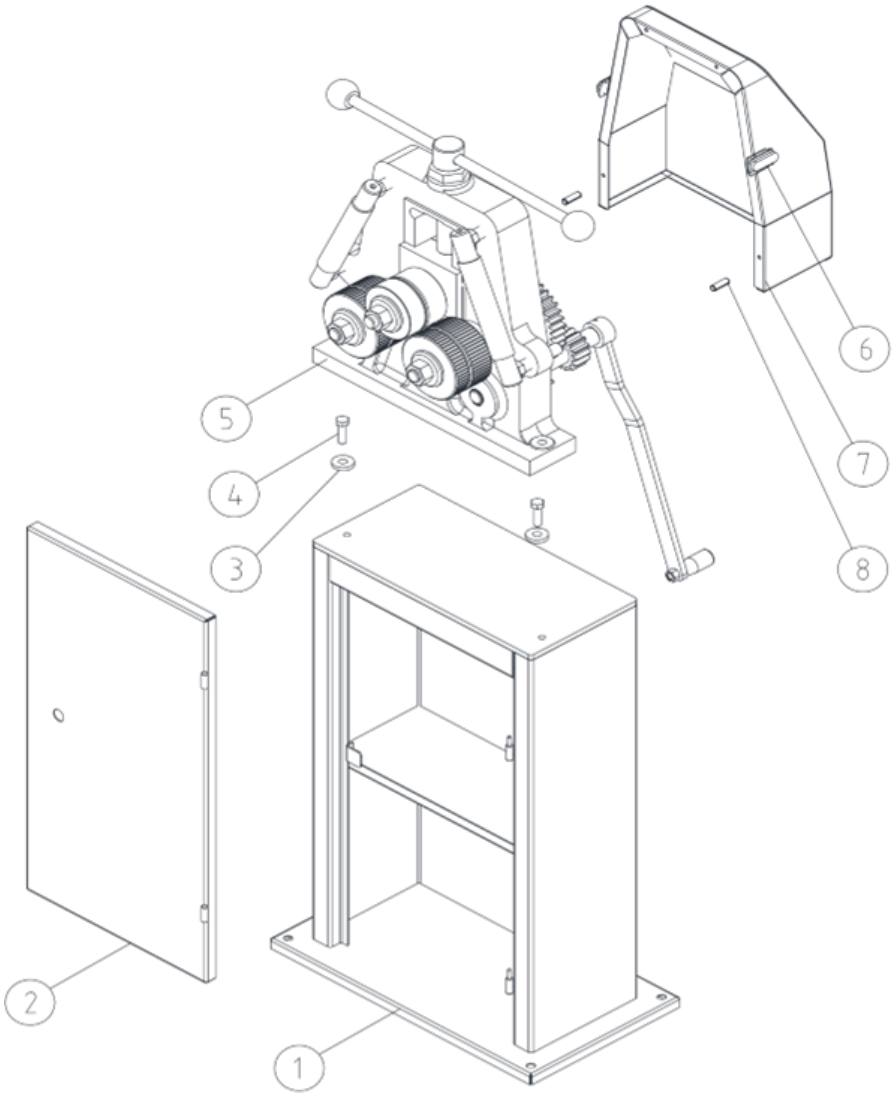
Figure 12-1

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

13.0 Replacement Parts

13.1.1 Manual Roll Bender Assembly – Exploded View

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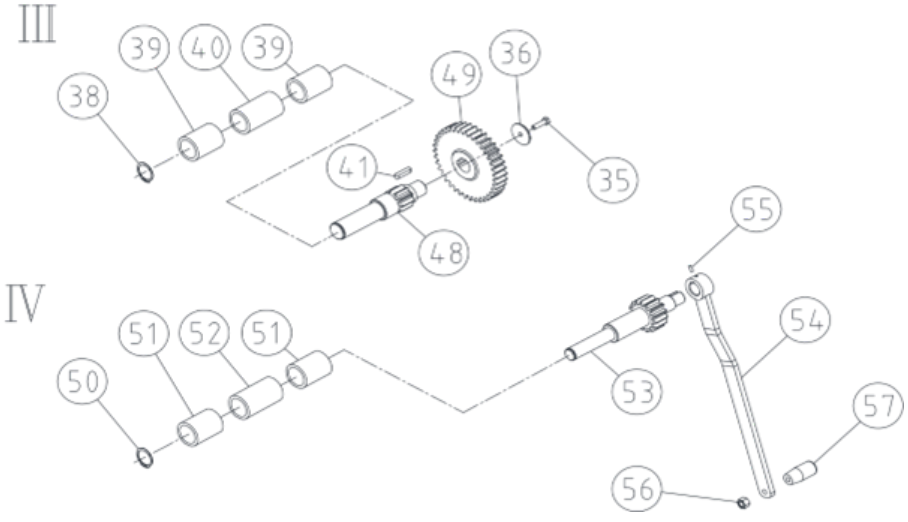
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13.1.2 Manual Roll Bender Assembly - Parts List

Index No	Part No	Description	Size	Qty
1	BA9-1005030	Stand		1
2	BA9-1005039	Door		1
	BA9-1014659	Lock and Key (not shown)		
3	**	Flat Washer	M12	2
4	**	Hex Cap Screw	M12X45	2
5	**	Body		1
6	**	Lock Buckle		2
7	BA9-1231781	Shield		1
8	**	Spring Pin	6X35	4
9	**	Body		1
10	**	Hex Thin Nut	M36P4.0	1
11	**	Socket Head Cap Screw	M5X10	4
12	BA9-1005032	Side Guide Joint		4
13	BA9-1005033	Side Guide Bolt		4
14	BA9-1018622	Bearing 6001ZZ	6001-2Z	4
15	BA9-1018623	Powering Gear Shaft		2
16	BA9-1018624	Side Guide Shaft		2
17	BA9-1005037	Lever Ball		4
18	**	Rotating Lever		1
19	BA9-1013846	Turning Shaft		1
20	BA9-1018625	Hex Cap Screw	M12X30	1
21	BA9-1018626	Washer		1
22	BA9-1013847	Bolt		1
23	**	Socket Head Cap Screw	M10X60	4
24	BA9-1010713	Top Roll Shaft		1
25	BA9-1015571	Middle Bedding		1
26	BA9-1016462	Socket Head Cap Screw	M5X10	1
27	**	Hex Nut, Nylon Lock	M8P1.25	4
28	**	Socket Set Screw, Cup Point	M8X25	4
29	BA9-1018627	Finger		1
30	**	Middle Bedding Slide		2
31	BA9-1229910	Lower Roll Spacer 26.9mm Thick		1
31-1	BA9-1229911	Lower Roll Spacer 12mm Thick		1
31-2	BA9-1229912	Lower Roll Spacer 16.5mm Thick		1
31-3	BA9-1229913	Lower Roll Spacer 13.7mm Thick		1
31-4	BA9-1229914	Lower Roll Spacer 10.4mm Thick		1
31-5	BA9-1229915	Lower Roll Spacer 8.7mm Thick		1
32	BA9-1020490	Bearing Bushing		2
33	BA9-1014634	Tooling Washer M24		3
34	BA9-1014617	Hex Nut	M24P3.0	3
35	**	Hex Cap Screw	M8X30	4
36	**	Washer		3
37	**	Main Gear		2
38	BA9-1228890	Retaining Rings, EXT	M35	4
39	BA9-1016934	DU Graphite Bearing (1) 35 x 30		8
40	BA9-1010401	Steel Sleeve (2) 35 x 39		2
40A	**	DU Graphite Bearing (1) (39OD x 35ID x 27.5L)		2
41	BA9-1016453	Flat Key	8X30	4
42	BA9-1016454	Flat Key	8X63	2
43	**	Lower Gear Shaft		2
44	**	Lower Roll		2
44-1	**	Lower Roll		2
44-2	**	Lower Roll		2
44-3	**	Lower Roll		2
44-4	**	Lower Roll		2
44-5	**	Lower Roll		2
45	BA9-1224857	Middle Gear Shaft		1
46	**	Middle Gear		1
47	**	Washer		1

Index No	Part No	Description	Size	Qty
48	BA9-1013087	Lower Gear Shaft		1
49	**	Gear		1
50	**	Retaining Rings, EXT	M25	1
51	**	Graphite Bearing (1)		2
52	**	Graphite Bearing (2)		1
53	**	Turning Hand Lever		1
54	BA9-1018628	Handle		1
55	BA9-1018629	Socket Set Screw, Flat Point	M6X12	1
56	**	Hex Nut	M12P1.75	1
57	BA9-1005042	Hand Bar Holder	M12x100	1
58	**	Scale		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.

14.0 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 INCIDENTIAL, 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 DUFEKDRIVEMANITOWOC, WI 54220
PHONE: 920.684.4990 FAX: 920.684.3944
www.baileigh.com