



Operating Instructions and Parts Manual Gear Drive Drill Press

Model DP-1000G



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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. DO NOT use electrically powered tools in the presence of flammable gases or liquids.
16. Tooling maintenance. Always keep drill bits sharp for optimum performance.
17. Keep children away. Children must never be allowed in the work area. DO NOT let them handle machines, tools, or extension cords.
18. Keep visitors a safe distance from the work area.
19. Store idle equipment. When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
20. DO NOT operate machine if under the influence of alcohol or drugs. Read warning labels on prescriptions. If there is any doubt, DO NOT operate the machine.
21. Turn off power before checking, cleaning, or replacing any parts.
22. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
23. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
24. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. Bare wiring can kill! DO NOT touch live electrical components or parts.
25. DO NOT bypass or defeat any safety interlock systems.

Familiarize yourself with the following safety notices used in this manual:

⚠ CAUTION

This means that if precautions are not heeded, it may result in minor injury and/or machine damage.

⚠ WARNING

This means that if precautions are not heeded, it may result in serious injury or death.

⚠ DANGER

This means that if precautions are not heeded, it will result in serious or fatal, injury.

Save the Instructions

3.0 About This Manual

This manual is provided by Baileigh Industrial, covering the safe operation and maintenance procedures for a Baileigh Model DP-1000G Gear Drive Drill Press. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

Technical Support handles questions on setup, operation, schematics, warranty issues, and individual parts needed. Our Technical Support department can be reached at 920-684-4990.

If there are questions or comments, please contact your local supplier or Baileigh Industrial. We can also be reached at our web site: www.baileigh.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

⚠ WARNING

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

Register your product online -

<https://baileigh.com/product-registration>



4.0 Product Identification



Figure 4-1

Table 4-1

Item	Description	Function
A	Base	Support the drill press
B	Table Rotation Lock	Loosen to allow the table to rotate on its center axis. NEVER OPERATE THE MACHINE WHEN UNLOCKED.
C	Work Table	Work surface with T-slots.
D	Chuck	Holds various tools for drilling and tapping.
E	Drill Guard	Adjustable guard to cover the chuck and restrict access during operation.
F	Depth Adjustment	Moves the depth stop up and down.
G	Rotation Selector Switch	Selects if the chuck will rotate clockwise or counterclockwise. DO NOT change rotation direction until the spindle has stopped completely.
H	Emergency Stop Button	Press to stop machine in the event of incorrect operation or dangerous condition. Twist the emergency stop button clockwise (cw) to reset.

Item	Description	Function
I	Stop Button	Press to stop the motor.
J	Start Button	Press to start the motor.
K	Speed (RPM) Selection Chart	Shows a visual representation of the handle positions for each of the four RPM settings.
L	Speed (RPM) Selection Handles	Position the handles to match the chart diagram to run the chuck at the RPM setting. DO NOT change spindle RPM until the spindle has stopped completely.
M	Drill Head Position Lock	Loosen to allow the drill head to move on the column. NEVER OPERATE THE MACHINE WHEN UNLOCKED.
N	Drill Head Adjustment Drive	Raises and lower the drill head on the column.
O	Feed Handle	Operator control to lower and raise the drill spindle.
P	Drill Head Gear Rack	Engages the drill head for height adjustment.
Q	Power Cord	Connects to the proper power supply to provide power to the machine.
R	Work Lamp	Provides additional lighting to the work area.
S	Table Gear Rack	Engages the table support arm for height adjustment.
T	Table Position Lock	Loosen to allow the table to move on the column. NEVER OPERATE THE MACHINE WHEN UNLOCKED.
U	Table Adjustment Drive	Raises and lower the table on the column.

4.1 The Drill Head

The drill head attaches to the upper column. It houses the motor, spindle, and speed controls. Attached to it is the electrical enclosure, the protective guard, the work light. The drill head can be lowered, raised, and rotated on the column as needed. Always unlock the head clamp before changing position and then lock the head in the new position.

4.2 The Work Table

The sturdy work table can be positioned at varying heights and rotated 180° in either direction. It has T-slots to allow the use of 1/2" or M14 bolts. Below the work table are two lock handle and a crankshaft. The crankshaft and lock handle near the column control the up/down and swing positions of the table and support arm. The front lock handle under the table controls the rotation of the table. Always unlock the table before changing the height or rotating it. Then lock the work table to secure in position.

4.3 The Machine Base

The machine base supports the entire machine and should be secured to the work surface.



Figure 4-2

4.4 Overall Dimension

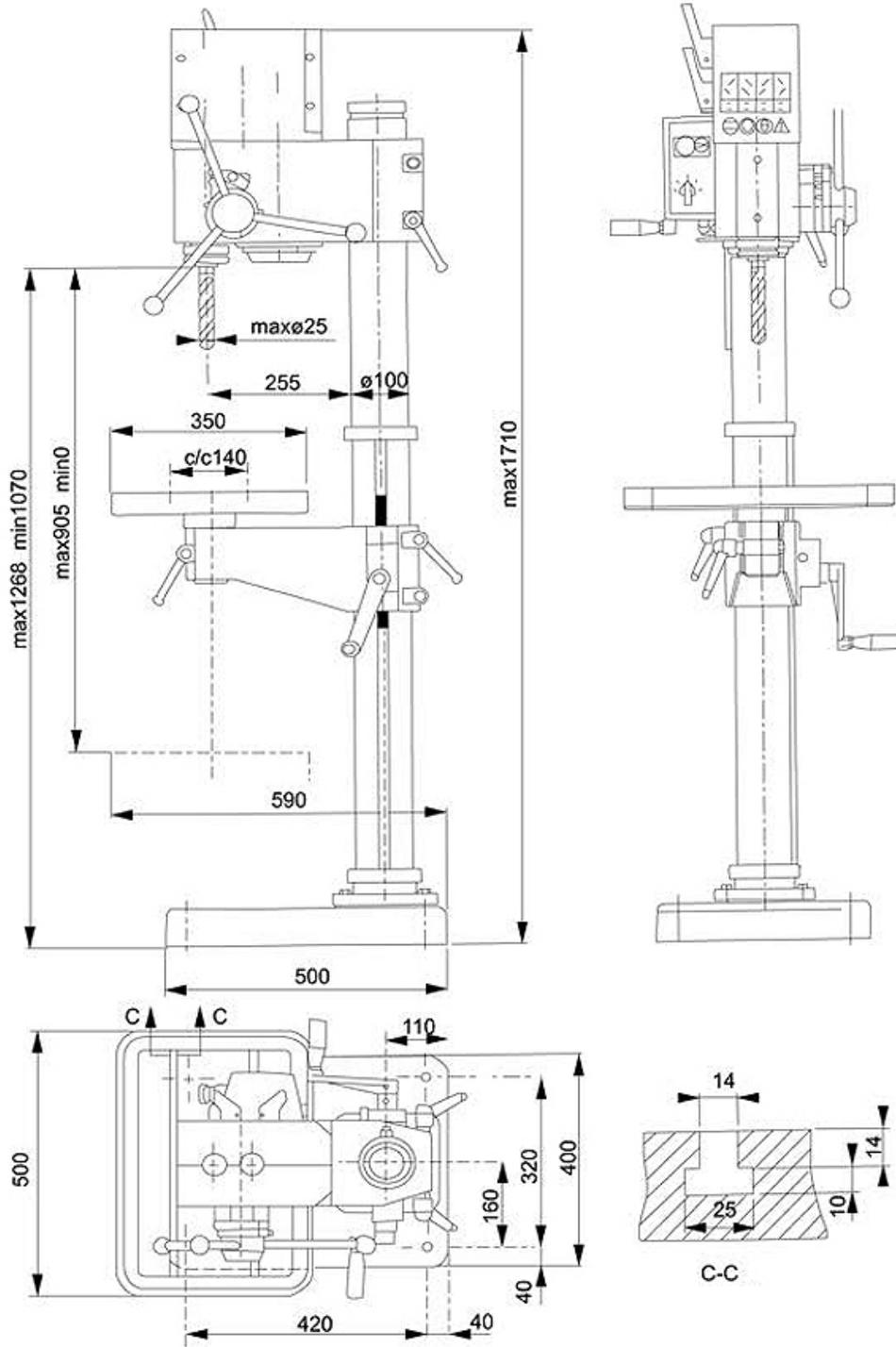


Figure 4-3

5.0 Specifications

Table 5-1

Model Number	DP-1000G
Stock Number	BA9-1002827
Motor and Electrical	
Motor	1.5HP (1.12kW), 110V, 60Hz, 14A
Power Supply	110V, 60Hz
General Specifications	
Drill Capacity	1" (25.4mm)
Tapping Capacity	.625" (15.875mm)
Spindle Speed	125, 420, 535, or 1740 rpm
Spindle Taper	MT 3
Spindle Travel	5.3" (135mm)
Weights and Dimensions	
Tables Dimensions (L x W)	19.75 x 13.75 (501 x 350mm)
Base Dimensions (L x W)	15.5 x 19.5 (393 x 495mm)
Shipping Dimensions (L/W/H)	66" x 23" x 29" (1676 x 584 x 737mm)
Shipping Weight	484 lbs (220kg)

5.1 Machine Description

The Baileigh DP-1000G is a very economical gear head drill press that can run in any fabrication or machine shop using only 110 volts of power. It can drill through mild steel with up to a 1" (25.4mm) drill bit. It comes standard with a heavy cast iron base and adjustable table.

To reduce flexing this gear head drill press uses a column with a 4" (101.6mm) diameter. The gear head also can be adjusted up or down on the column. The transmission offers multiple speeds that are perfect for drilling and tapping an array of different materials. The DP-1000G comes standard with a halogen light and protective guarding.

⚠ WARNING

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

6.0 Setup and Assembly

6.1 Unpacking and Checking Contents

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

⚠ WARNING

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

⚠ WARNING

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

6.2 Cleaning

⚠ WARNING

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

⚠ CAUTION

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

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

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

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

6.3 Transporting and Lifting

NOTICE

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

Follow these guidelines when lifting with truck or trolley:

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

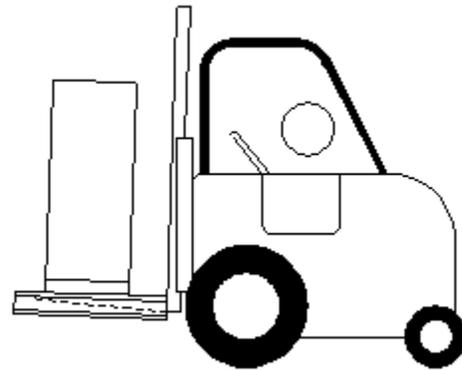


Figure 6-1

- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a forklift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.

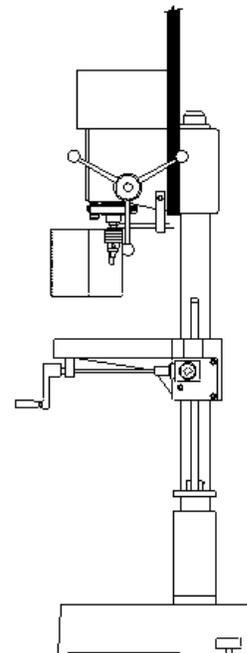


Figure 6-2

- 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.

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 can support the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

6.5 Anchoring the Machine

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

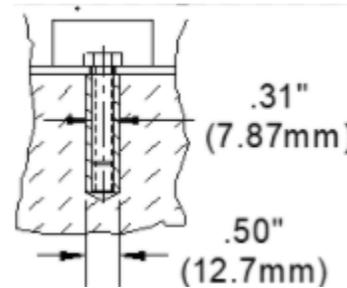


Figure 6-3

7.0 Electrical Connection

CAUTION

HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!

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

WARNING

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

7.1 Power Specifications

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

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

7.2 Considerations

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

WARNING

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

- Improper connection of the equipment-grounding conductor can result in risk of electric

shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

- Check with qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

7.3 Extension Cord Safety

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

Table 7-1

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

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

7.4 Power Cord Connection

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

8.0 Operation

CAUTION

Always wear proper eye protection with side shields. Restrain and contain long hair, loose or baggy clothing and remove jewelry to prevent entanglement.

Safety guard must be properly positioned.

1. Load and secure the piece part to the table.
2. Secure drill or tapping bit in the chuck.
3. Unlock the table, set to desired position, and re-lock. Adjust the safety guard as necessary.
4. To set the depth stop, use the feed handle (O), to bring the tip of the drill or tapping bit to the surface of the piece part and hold as in (fig. 8-2). This is zero position.
5. While holding the zero position, loosen the depth lock knob (F) counterclockwise (ccw) to release depth stop.



Figure 8-1

6. Lower or raise the depth stop to contact the stop plate (AA) to set the drill depth. Tighten lock knob (F) clockwise (cw).
7. Raise the drill or tapping bit off the piece part.
8. Position the spindle speed handles (L) to match the desired rpm setting as indicated on the speed selection chart (K). **DO NOT** change spindle RPM until the spindle has stopped completely.
9. Select either clockwise or counterclockwise spindle rotation with selector switch (G). **DO**

NOT change rotation direction until the spindle has stopped completely.

10. Verify that the chuck is clear of any entanglements and press start button (J) to begin spindle rotation.



Figure 8-2

11. Use the feed handle to start drilling or tapping.
12. While tapping, pause the spindle down-feed at the bottom of the operation to allow the breaking and reversal of rotation of the spindle. **DO NOT** change rotation direction until the spindle has stopped completely.

Note: In general, use low speeds for tapping. By tapping at high RPM there is a danger of damage to the piece part or the tooling. While tapping, the tool can be backed out at any time by stopping the spindle rotation and changing the selector switch (G).

13. At the end of a drilling or tapping operation, press the stop button (I) to turn **OFF** the machine.

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button (H). Twist the button clockwise (cw) to reset.

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.

10.1 Daily Maintenance

- Inspect the power plug and cord.
- Keep area around machine clear of debris.
- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.

10.2 Weekly Maintenance

- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.
- On a weekly basis clean the machine and the area around it.

10.3 Monthly Maintenance

- Check that all screws on the motor and the guard are tight and secure.
- Check that the guard is operating properly.
- Grease the gear rack on the column so the table moves up and down smoothly.

10.4 Greasing the Machine

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

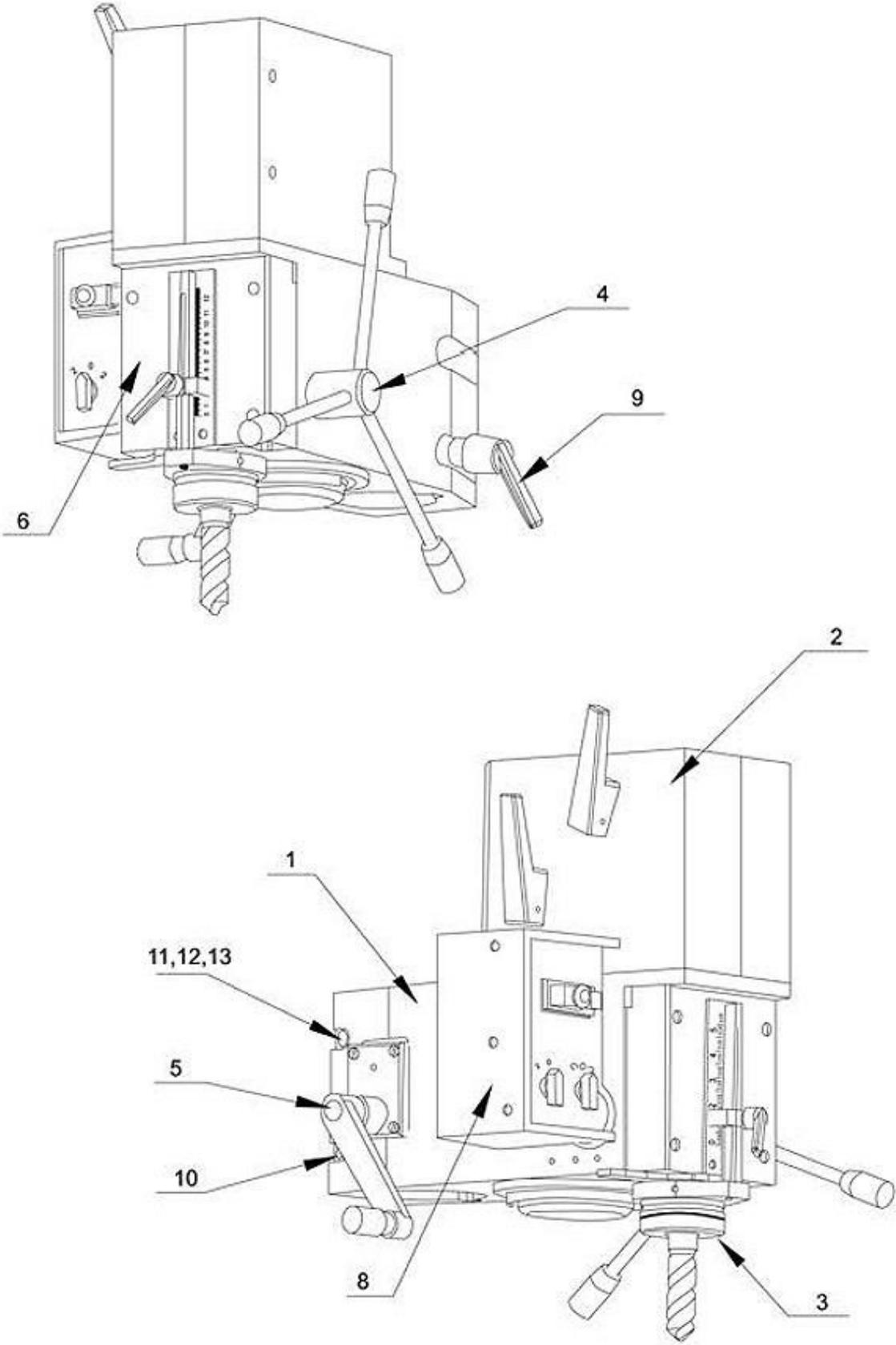
10.5 Storing Machine for Extended Period of Time

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

- Detach the plug from the electrical supply panel.
- Clean and grease the machine.
- Cover the machine.

11.0 Replacement Parts

11.1.1 Drill Head – Exploded View A

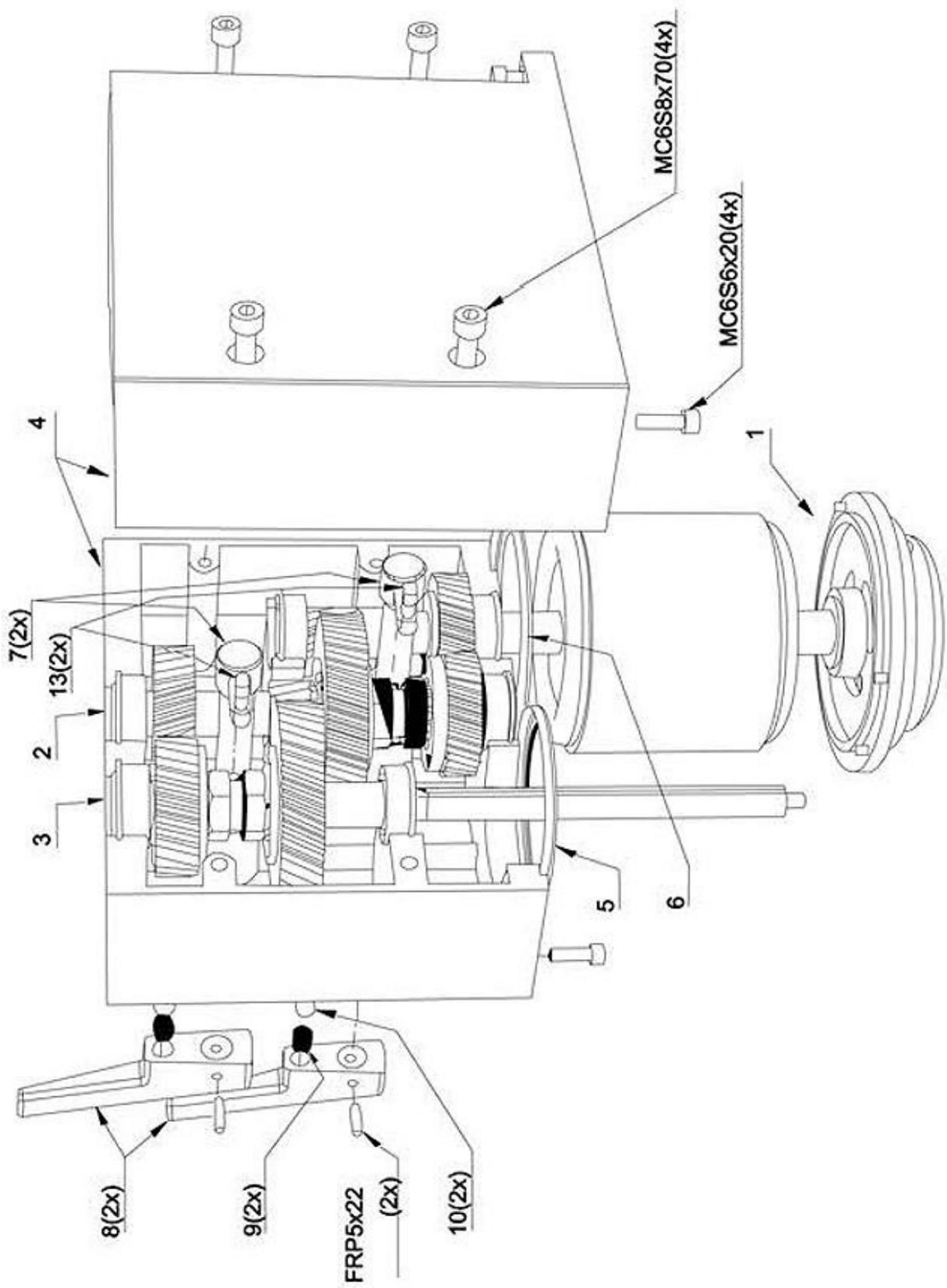


11.1.2 Drill Head – Parts List A

Index No	Part No	Description	Size	Qty
1	BA9-1013177	Spindle Housing		1
2	**	Gearbox		1
3	BA9-1013699	Spindle Sleeve		1
4	BA9-1017749	Feed Shaft Complete		1
5	**	Worm Gear Unit		1
6	BA1-9378	Front Cover		1
8	**	Electric Box Cover		1
9	BA9-1016621	Locking Lever	M12×95	2
10	**	Hex Cap Screw	M12×120	1
11	**	Hex Cap Screw	M12×130	1
12	**	Hex Nut, Nylon Lock	M12P1.75	2
13	**	Flat Washer	M12	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.

11.1.3 Gearbox – Exploded View B

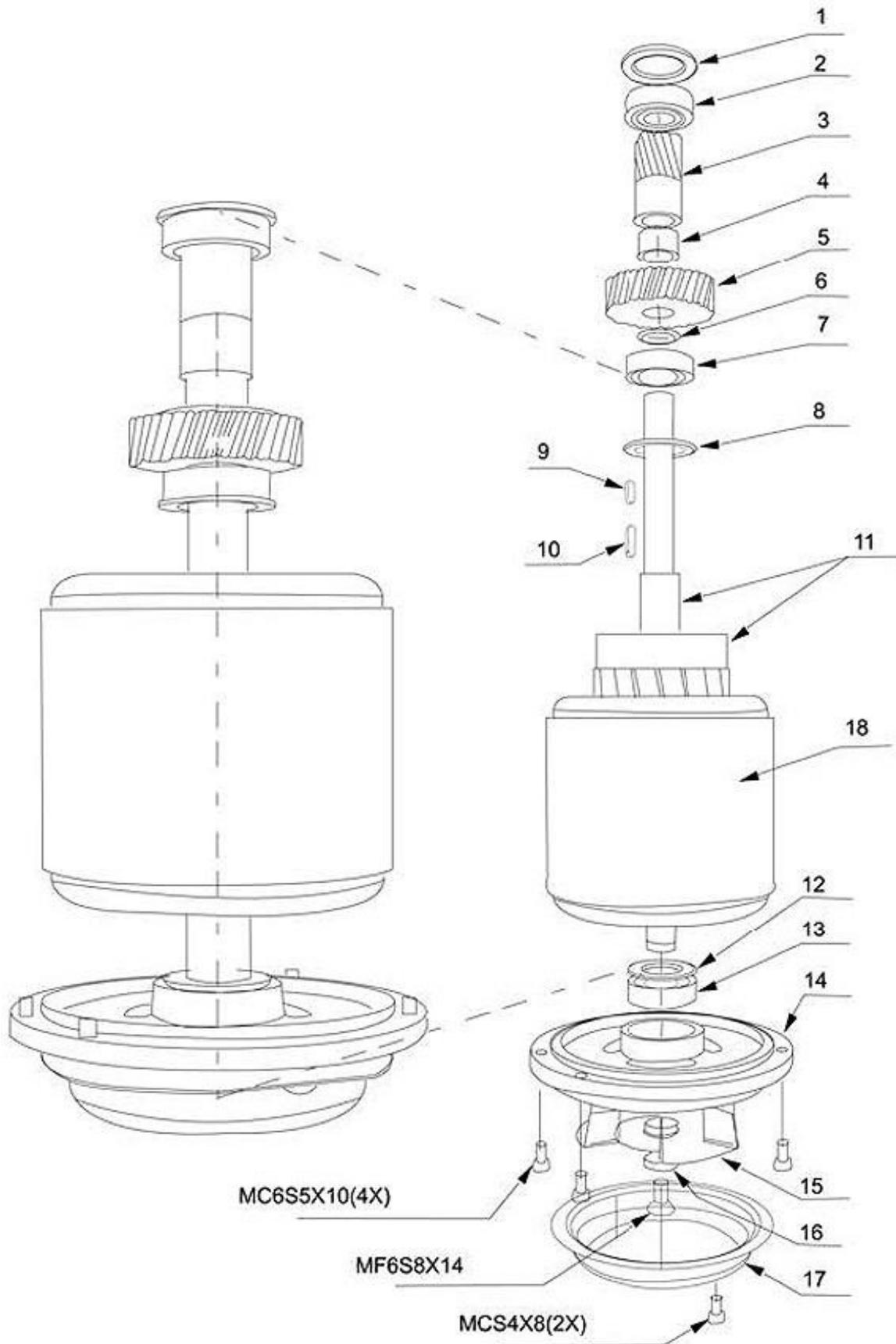


11.1.4 Gearbox – Parts List B

Index No	Part No	Description	Size	Qty
1	**	Rotor shaft		1
2	BA9-1224740	2nd Shaft complete		1
3	BA9-1020849	3rd Shaft complete		1
4	BA9-1020850	Gear box complete		1
5	BA1-70	Ring		1
6	BA1-71	Ring		1
7	BA9-1002843	Gear selector arm		2
8	BA9-1008906	Gear lever		2
9	BA9-1002844	Compression Spring		2
10	BA9-1002845	Steel ball	8mm	2
13	BA9-1002834	Shift pin		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.

11.1.5 Rotor Shaft – Exploded View C

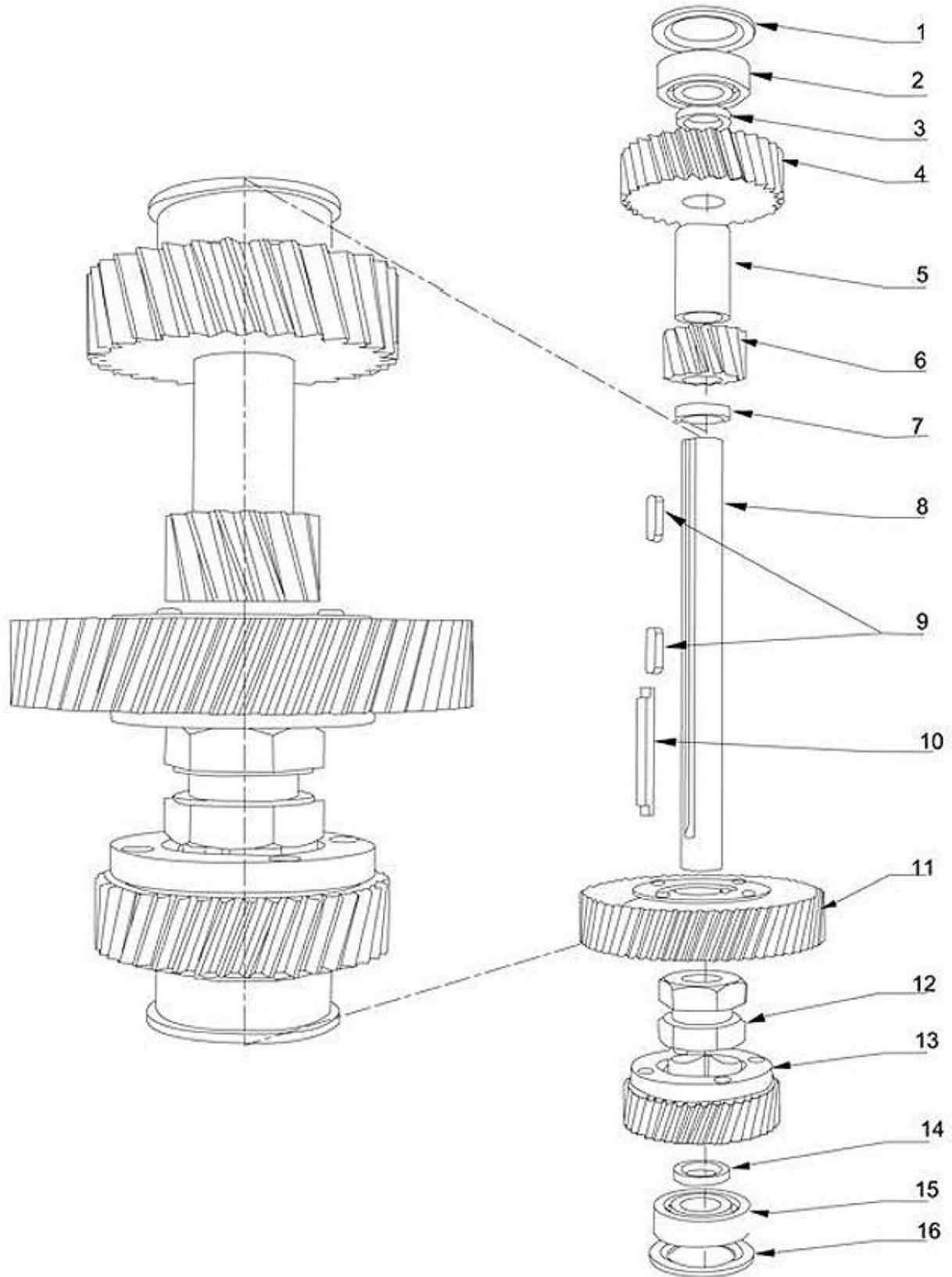


11.1.6 Rotor Shaft – Parts List C

Index No	Part No	Description	Size	Qty
1	**	Washer		1
2	**	Ball bearing	6203	1
3	BA9-1018538	Gear 15-1, 5		1
4	BA1-10132	Spacing sleeve 17x14		1
5	BA9-1013292	Gear 39-1, 5		1
6	**	Spacing sleeve 17x2		1
7	**	Ball bearing	6203	1
8	**	Washer		1
9	**	Flat Key	5×5×14	1
10	**	Flat Key	5×5×20	1
11	BA9-1013516	Rotor Shaft		1
12	**	Washer FB 6203		1
13	**	Ball bearing	6203	1
14	BA1-72	Bearing cover B-1889		1
15	BA9-1021521	Fan B-175		1
16	**	Washer C-3449		1
17	BA9-1226255	Fan cover C-1890		1
18	**	Stator 80/2-4-70 380-440		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.

11.1.7 2nd Shaft – Exploded View D

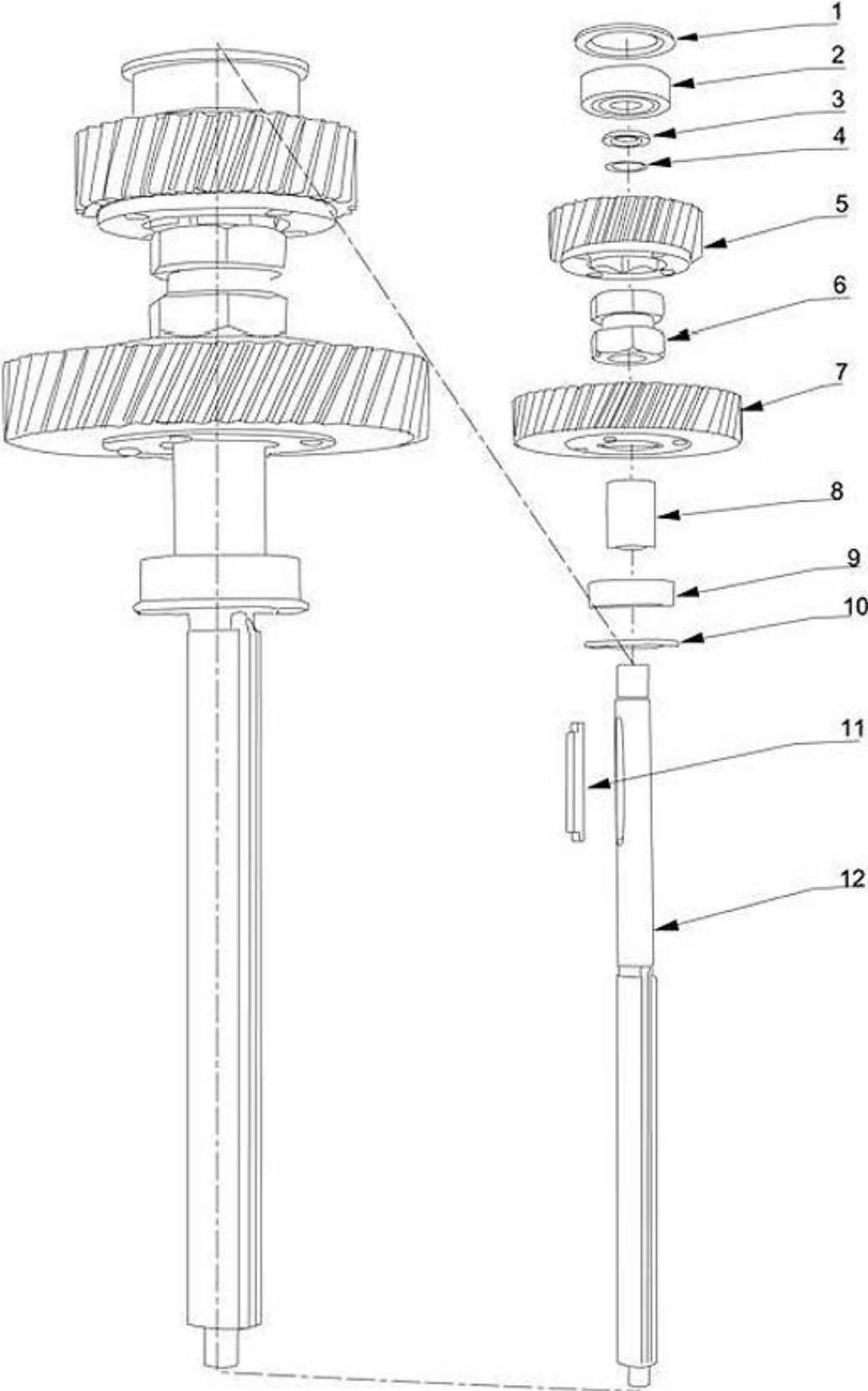


11.1.8 2nd Shaft – Parts List D

Index No	Part No	Description	Size	Qty
1	**	Washer C-138		1
2	**	Ball bearing	6203	1
3	**	Spacing sleeve 17x3, 5		1
4	BA9-1008750	Gear 32-2		1
5	**	Spacing sleeve 17x38		1
6	BA9-1008751	Gear 15-2		1
7	**	Spacing sleeve 17x5		1
8	**	2nd Shaft C-4871		1
9	**	Key 5x5x20	5x5x20	2
10	BA1-73	Key C-6615		1
11	**	Gear Complete 64-1, 5		1
12	**	Clutch C-4254		1
13	BA9-1018537	Gear complete 40-1, 5		1
14	**	Spacing sleeve 17x3, 5		1
15	**	Ball bearing	6203	1
16	**	Cover C-138		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.

11.1.9 3rd Shaft – Exploded View E

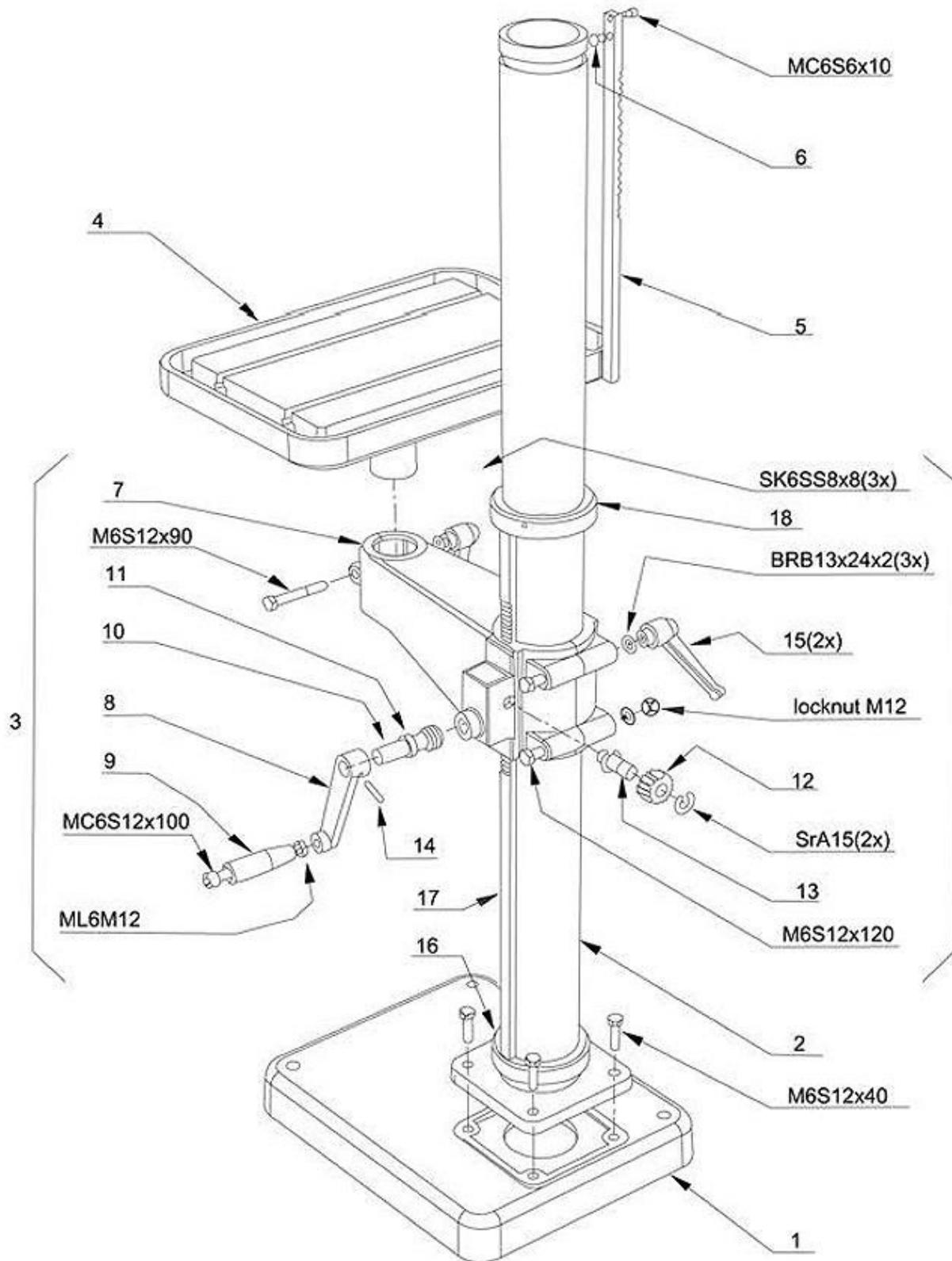


11.1.10 3rd Shaft – Parts List E

Index No	Part No	Description	Size	Qty
1	**	Cover C-138		1
2	BA1-3604	Ball bearing	6302	1
3	BA9-1017058	Spacing sleeve 15x2		1
4	BA1-3606	Circlip SgA 15	15	1
5	BA9-1002840	Gear complete 32-2		1
6	**	Clutch C 4254		1
7	**	Gear complete 49-2		1
8	**	Spacing sleeve 17x31, 5		1
9	**	Ball bearing	6203	1
10	**	Cover C-137		1
11	BA1-1605	Key C-6615		1
12	BA9-1002831	3rd Shaft B-8410		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.

11.1.11 Column – Exploded View F

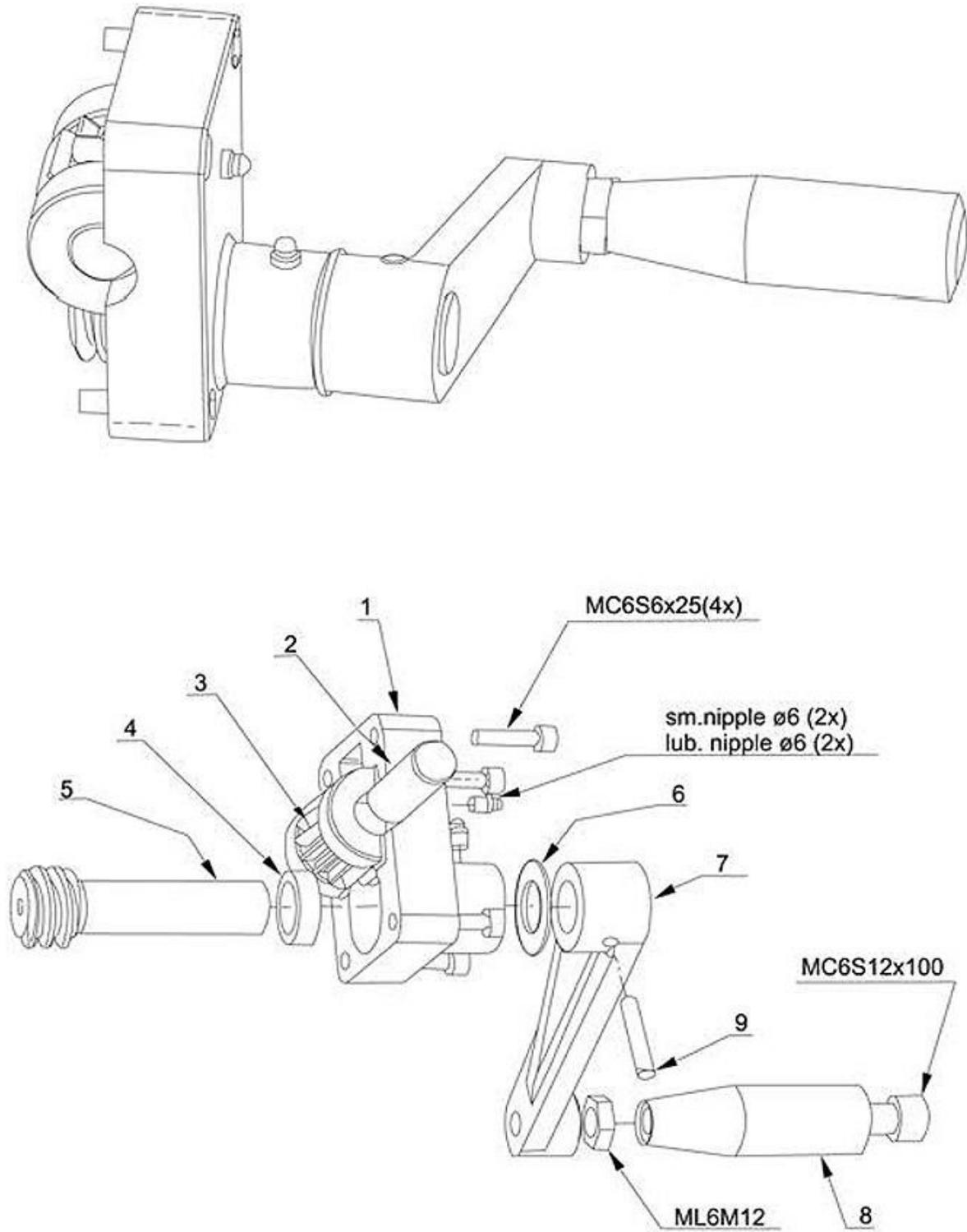


11.1.12 Column – Parts List F

Index No	Part No	Description	Size	Qty
1	BA9-1013880	Base plate		1
2	BA9-1009633	Column L=1500		1
3	**	Table arm complete		1
4	**	Table		1
5	**	Rack		1
6	**	Pin		1
7	BA9-1019427	Table arm		1
	**	Worm gear complete		
8	BA9-1015678	Crank handle		1
9	BA9-1015678	Handle	M12×100	1
10	BA9-1008913	Worm shaft		1
11	**	Spacer 20x8		1
12	BA9-1002832	Gear		1
13	**	Shaft		1
14	**	Socket Set Screw, Flat Point	M8×8	1
15	**	Locking handle	M12×95	2
16	BA9-1010984	Lower ring		1
17	BA9-1002836	Rack		1
18	BA9-1013461	Upper ring		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.

11.1.13 Worm Gear Box Complete – Exploded View G

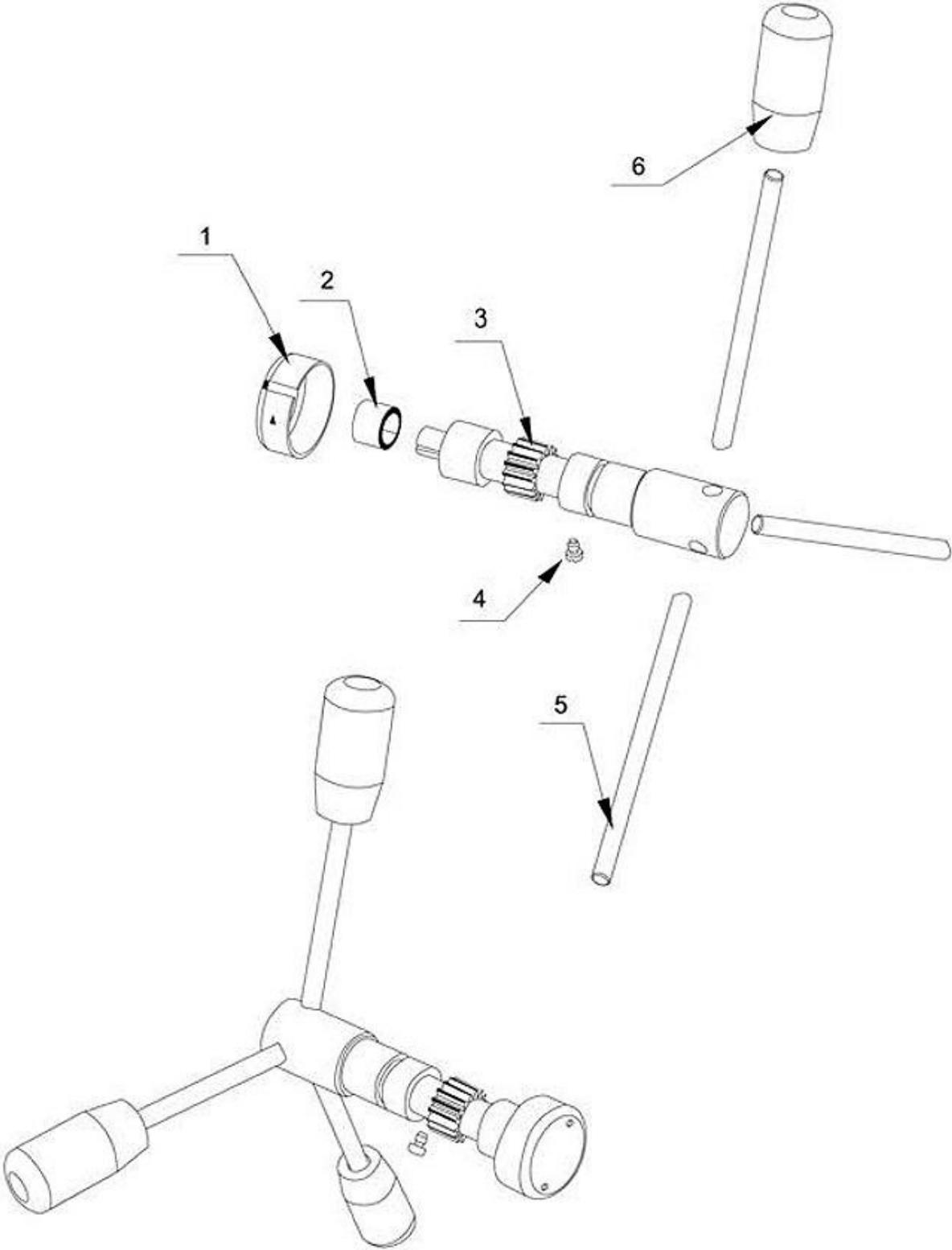


11.1.14 Worm Gear Box Complete – Parts List G

Index No	Part No	Description	Size	Qty
.....	BA9-1016469	Worm gear box Complete.....		1
1	**	Worm gear box		1
2	**	Shaft		1
3	BA9-1002832	Gear		1
4	BA9-1002830	Spacer 20x8		1
5	BA9-1002828	Worm shaft		1
6	**	Washer		1
7	**	Crank		1
8	**	Handle	M12×100.....	1
9	**	Socket Set Screw, Flat Point.....	M8×8.....	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.

11.1.15 Feed Shaft – Exploded View H



11.1.16 Feed Shaft – Parts List H

Index No	Part No	Description	Size	Qty
1	BA9-1009854	Spring housing		1
2	BA9-1009535	Clock Spring w/Housing		1
3	**	Feed shaft		1
4	BA9-1019143	Socket Set Screw, Dog Point	M8×16	1
5	BA9-1020436	Feed lever		3
6	**	Handle ball	BM10×32	3

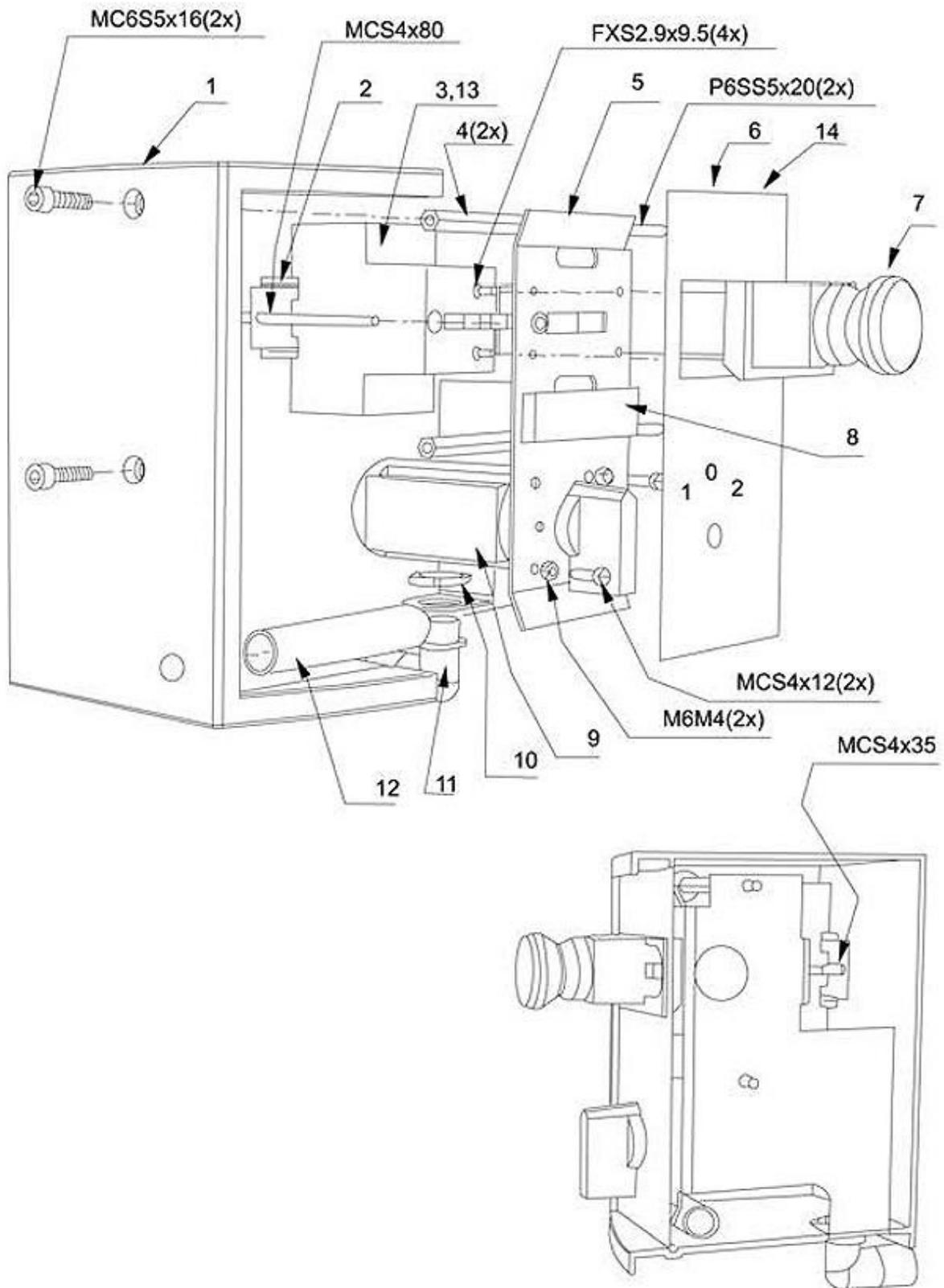
** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

11.1.18 Spindle Sleeve – Parts List I

Index No	Part No	Description	Size	Qty
1	**	Round Nuts	M25×1.5	1
2	**	Locking washer		1
3	**	Ball bearing	6205	1
4	BA1-9450	Spindle sleeve		1
5	**	Rack		1
6	**	Washer		1
7	**	Taper roller bearing	30206	1
8	**	Roller bearing cover		1
9	BA9-1226887	Key		2
10	**	Spindle		1
11	BA1-9385	Spacing sleeve		1
12	**	Wave Spring Washers	M10	1
13	**	Stop		1
14	BA1-1335	Socket Set Screw, Flat Point	M16X25	1
15	BA1-1336	Collet Jaw		1
	**	Socket HD Flat Screw	M5×20	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.

11.1.19 Electric Box – Exploded View J

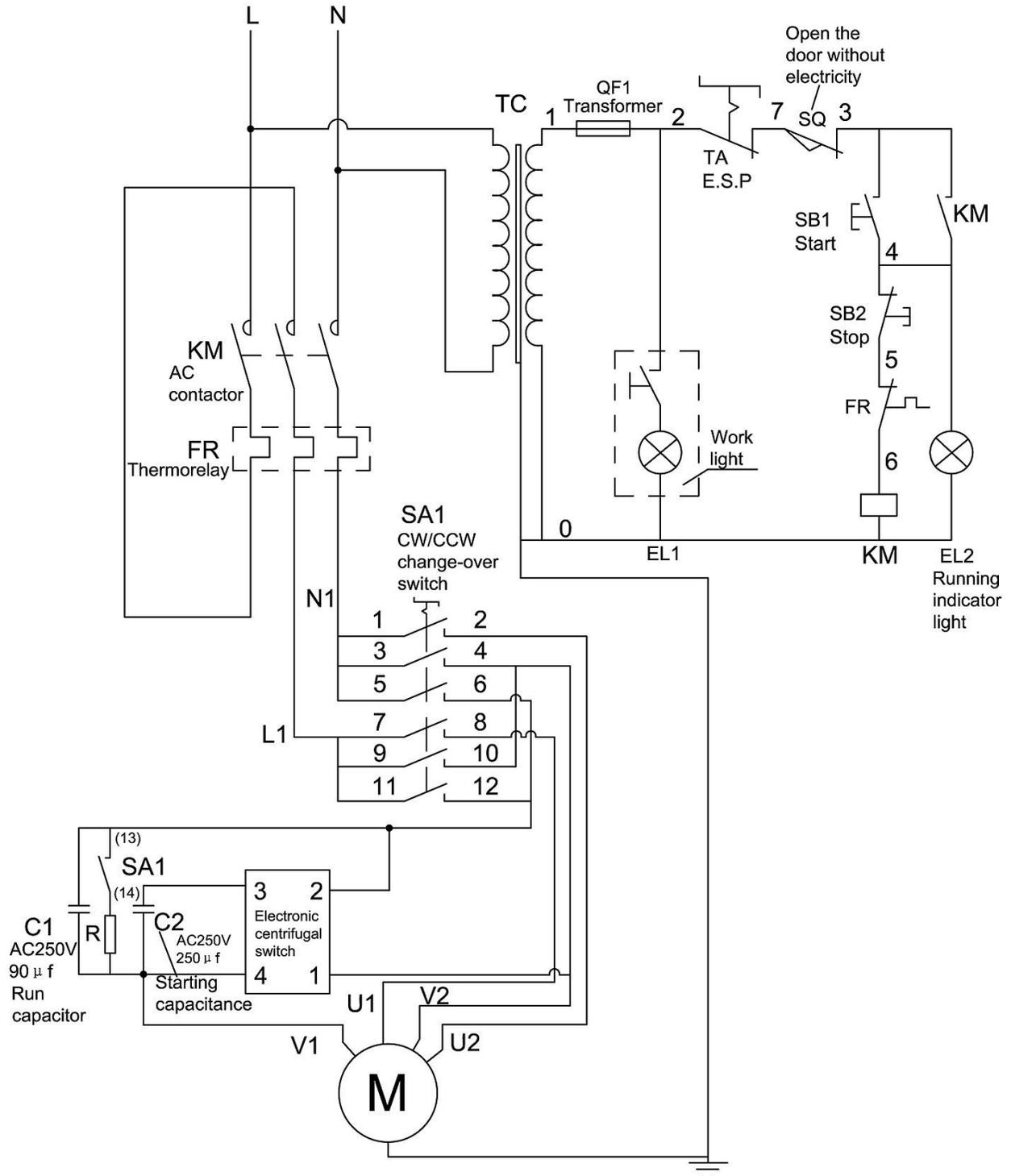


11.1.20 Electric Box – Parts List J

Index No	Part No	Description	Size	Qty
1	BA1-10768	Electric box cover		1
2	**	Rail anchor		1
3	**	Motor Protector 380/50		1
4	**	Electric box distance tube		2
5	**	Anchor plate		1
6	**	Electric box plate		1
7	**	Emergency stop		1
8	**	Rubber molding 15x8		1
9	BA9-1018976	Pole reverser		1
10	BA1-10769	Nut 1816	M18x1.5	1
11	**	Angular nipple		1
12	**	Protection conduit		1
13	**	Under volt release		1
14	**	Electric box plate		1

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

12.0 Wiring Diagram



12.1 Wiring Diagram – Parts List

Index No	Part No	Description	Size	Qty
KM	BA9-1013224	Motor Contactor		1
FR	**	Thermal Overload		1
TC	BA9-1017781	Transformer 60VA		1
TA	**	Emergency Stop Button		1
SB1	**	Push Button (Start)		1
SB2	**	Push Button (Stop)		1
EL	**	Work Lamp Assembly (no bulb)		1
	BA9-1013791	LED Bulb		1
C1	BA9-1002852	Capacitor 90UF 250V. AC (49*102)		1
C2	BA9-1010293	Capacitor 250UF 250V. AC (50*105)		1
	BA9-1002846	Centrifugal Switch (Electric Style)		1
	**	Rotation Selector Switch		1

13.0 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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