



OPERATOR'S MANUAL



SHEET METAL NOTCHER MODEL: SN-V04-MS

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THANK YOU & WARRANTY

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 a 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 a 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 a 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 a 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 30 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, (e) 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, lightening, 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's 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 attorneys' 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 issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh 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 sales@baileigh.com



INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Set-up and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



Note: This symbol refers to useful information throughout the manual.



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** is used with the safety alert symbol. **DANGER** identifies a hazard or unsafe practice that will result in severe **Injury or Death.**



Safety signs with signal word **DANGER** or **WARNING** are typically near specific hazards.



General precautions are listed on **CAUTION** safety signs. **CAUTION** also calls attention to safety messages in this manual.



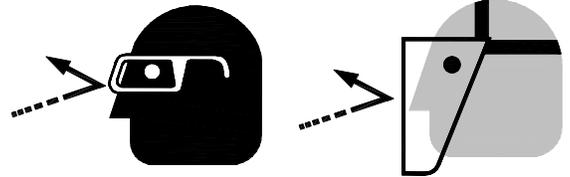


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



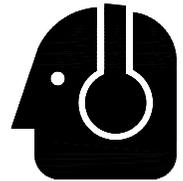
PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



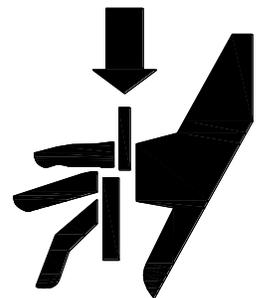
HYDRAULIC HOSE FAILURE

Exercise **CAUTION** around hydraulic hoses in case of a hose or fitting failure.



BEWARE OF SHEAR HAZARD

Keep hands and fingers clear from under the blade.
NEVER place your hand or any part of your body in this machine.



EMERGENCY STOP BUTTON

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button. Twist the emergency stop button clockwise (cw) to reset.
Note: Resetting the E-Stop will not start the machine.





SAFETY PRECAUTIONS



Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

1. **Only trained and qualified personnel can operate this machine.**
2. **Make sure guards are in place and in proper working order before operating machinery.**
3. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
4. **Keep work area clean.** Cluttered areas invite injuries.
5. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
6. **Dressing material edges.** Always chamfer and deburr all sharp edges.
7. **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 machines rated capacity.
8. **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.
9. **Dress appropriate. 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.
10. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.



11. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
12. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
13. **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.
14. **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.
15. **Blade adjustments and maintenance.** Always keep blades sharp and properly adjusted for optimum performance.
16. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
17. **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.
18. **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.
19. **DO NOT** touch live electrical components or parts.
20. **Turn off** power before checking, cleaning, or replacing any parts.
21. Be sure **all** equipment is properly installed and grounded according to national, state, and local codes.
22. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
23. **DO NOT** bypass or defeat any safety interlock systems.
24. Keep visitors a safe distance from the work area.

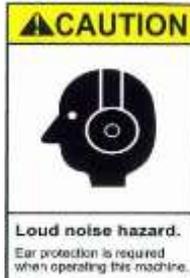


SAFETY LABELS

ATTENZIONE!
-NON ESEGUIRE TAGLI CON UNA SOLA LAMA
SENZA UTILIZZO DEI PREMILAMIERA ALLO SQUADRO.

WARNING!
-ALWAYS USE THE SQUARE HOLDDOWN WHEN
CUTTING SHEET METAL FROM A SINGLE SIDE
OF BLADE SYSTEM.

1.
Always use hold down.



2.
Hearing protection required when operating this machine.



3.
Move the lever to the left to lock the cylinder.
Move the lever to the right to unlock the cylinder.



4.
Using hander wheel to adjust the angle of blade set when cylinder is unlocked.

**ONLY PROPERLY TRAINED AND
AUTHORIZE PERSONEL
SHOULD OPERATE
THIS MACHINE**

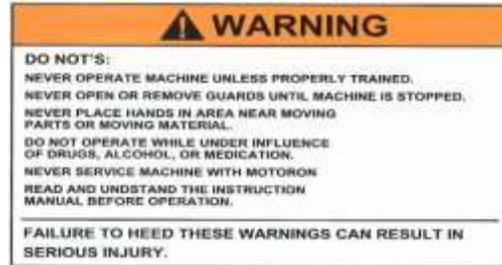
5.
Only qualified & authorized persons allowed to operate this machine.



6.
Bodily Injury Warning.



7. General Safety Notice. The user is responsible to read the manual and wear safety protection when operating this machine.



8. General operational safety rules to operate this machine.



9. Oil Fill reminder. Fill hydraulic reservoir before first use.



10. Disconnect power supply (air or electricity) before performing any service or maintenance.



11. This machine has two Emergency Stop Buttons (E-Stop). Pressing either E-Stop must immediately stop the machine, preventing any electrical and mechanical parts to further move or cause any damage. To reset the E-Stop, twist the emergency stop button 1/4 turn clockwise.

While this will stop the machine and disable operation, it WILL NOT remove power to internal electrical components and should not be relied upon for servicing the machine. Main power should be shut off for service work.



12. The label indicates the position of electrical box and the potential electrical hazard inside.



13. DO NOT remove any covers or guards during operation.



14. DO NOT remove any covers or guards during operation. Keep fingers away.



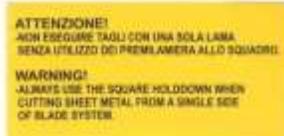
15. Lifting hook installation point.



16. Machine specifications tag. Actual appearance may vary.



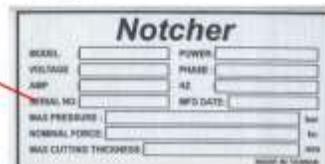
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TECHNICAL SPECIFICATIONS

Table Dimensions	37.4" x 31" (950 x 788mm)
Maximum Notch Dimensions	8-1/2" x 8-1/2" (216 x 216mm)
Notch Angle	30° – 140° Variable
Strokes Per Minute	15
Table Size	27" x 23.5" (686 x 597mm)
Blade Gap Adjustment	Manual
Maximum Capacity – Mild Steel	0.237" (6mm)
Maximum Capacity – Stainless Steel	9 ga. (13 ga.)
Maximum Cutting Thickness: with 15 degree blade with 30 degree blade	3 mm (R=60 kg/mm ²) 6 mm (R=42 kg/mm ²)
Noise: A weighted sound pressure level measuring: Associated uncertainty K = 4 dB acc. to ISO 4871 Measured made in accordance with EN ISO 3746:1995	70.2dB (@ 1 Meter)
Motor	4 hp (3kw)
Power Requirements	220V / 3-phase
Shipping Dimensions	60" x 44" x 68" (1524 x 1118 x 1728mm)
Shipping Weight	1,100 lbs. (499kg)
Based on a material tensile strength of *60000 PSI – mild steel **100000 PSI – stainless steel	

TECHNICAL SUPPORT

Our technical support department can be reached at 920.684.4990, and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: sales@baileigh.com, Phone: 920.684.4990, or Fax: 920.684.3944.



Note: *The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.*



Note: *The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.*



UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete in one crate. 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.
If any parts are missing, do not plug in the power cable, or turn the power switch on until the missing parts are obtained and installed correctly.

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.





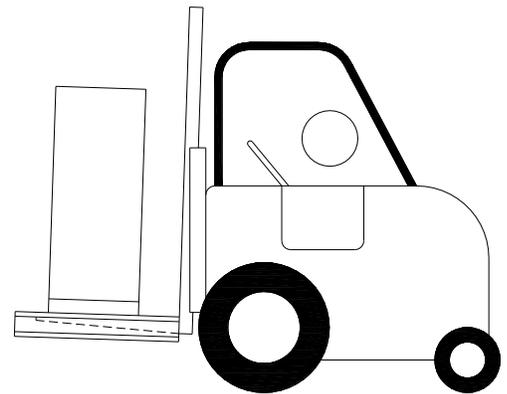
TRANSPORTING AND LIFTING



IMPORTANT: *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.*

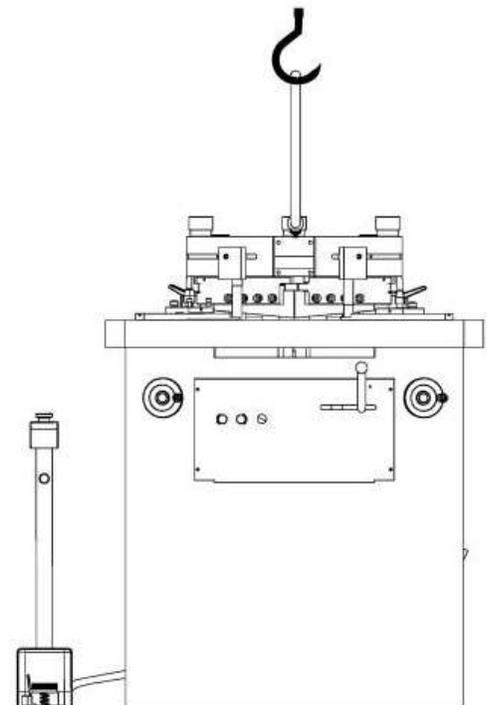
Follow these guidelines when lifting with truck or trolley:

- 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.



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.





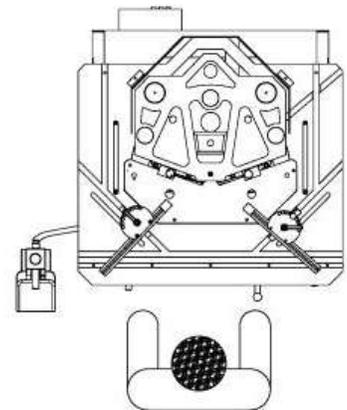
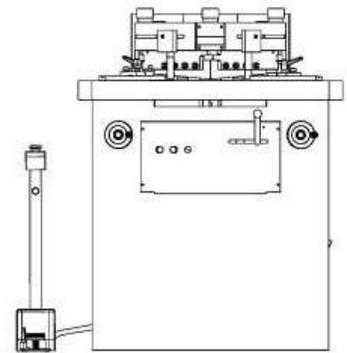
INSTALLATION AND ASSEMBLY

⚠ WARNING: FOR YOUR OWN SAFETY, DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL THE MACHINE IS COMPLETELY INSTALLED AND YOU READ AND UNDERSTAND THE ENTIRE INSTRUCTION MANUAL.

IMPORTANT:

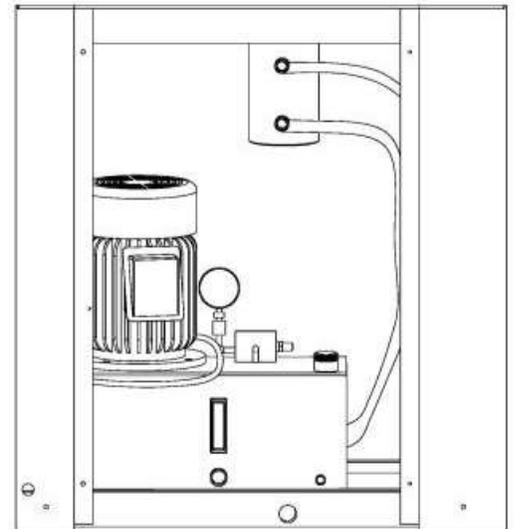
Consider the following when looking for a suitable location to place the machine:

- 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. Keep at least 4ft. (1m) of open space around the machine for safe operation.
- 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.



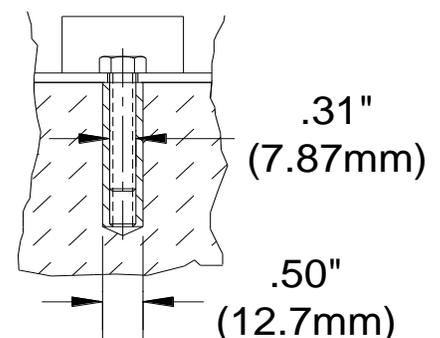


- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.
1. Remove the hex head tapping screws from the top plate then insert the hook onto the top of the head set.
 2. Lift the machine off of the pallet to set up at the working position.
 3. Check that all guards and panels are in place and secure and read the operation manual.
 4. Place the foot pedal control at the best position for operation.
 5. Unscrewing and remove the left side cover to check and fill the hydraulic reservoir. Leave the cover off until the electrical circuit has been connected to check for correct motor rotation.
 6. Fill in the hydraulic reservoir to about 4/5 position of the oil indicator.
 7. Use MOBILE-25, AGIP-46, SHELL-46, ESSO-46, TOTAL-46 or equivalent hydraulic oil.



Anchoring the Machine

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





ELECTRICAL

⚠ WARNING: Baileigh Industrial is not responsible for any damage caused by wiring up to an alternative 3-phase power source other than direct 3-phase. If you are using an alternate power source, consult a certified electrician or contact Baileigh Industrial prior to energizing the machine.

⚠ 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.

Motor Specifications

Your tool is wired for 220 volt, 60Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.

Considerations

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

Extension Cord Safety

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

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	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.



Connecting Power Supply

This machine is pre-wired for 230 volt. You may either install a plug or “hard-wire” the machine directly to a control panel.

- If you are connecting a plug, use a proper UL/CSA listed 3-pole, 4-wire grounding plug suitable for 230 volt operation.
 - If the machine is to be hard-wired to a panel, make sure a disconnect switch is readily available for the operator.
 - During hard-wiring of the machine, make sure the fuses have been removed or the breakers have been tripped in the circuit to which the machine will be connected. Place a warning placard on the fuse holder or circuit breaker to prevent it being turned on while the machine is being wired. **Always** follow proper lockout /tagout procedures.
1. Three Phase. Connect the three power wires to terminals **R, S, & T**.
 2. Connect the ground wire (typically green) to the “**E**” (Safety Ground) terminal.
 3. Check for correct rotation of motor and pump.
 4. Reset both “**E**”-STOP buttons.
 5. Press the start button and quickly check motor rotation.
 6. The motor must rotate as indicated by the arrow on the motor end cover.
 7. If not, disconnect power to the machine, and switch the **R & T** wires.
 8. **DO NOT** move the ground wire **E**.

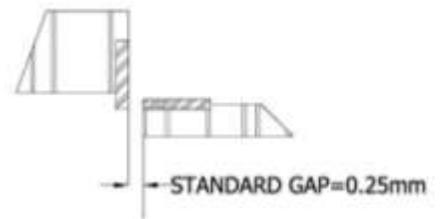
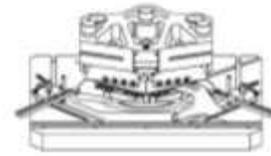
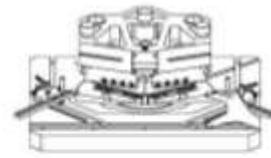
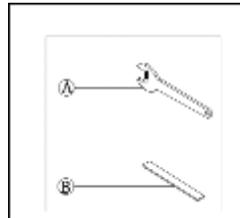


Important: Improper rotation can severely damage the hydraulic pump.



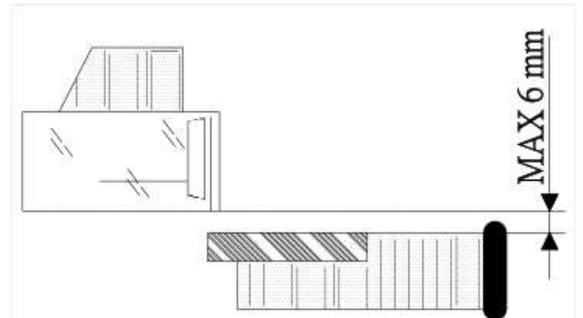
ADJUSTMENT OF BLADE GAP TOLERANCE

1. Disconnect the power supply!
 2. Unscrew the screws then remove the safety cover.
 3. Loosen the bias screws and blade screws to measure the tolerance by 0.25 mm (for 6mm) thickness gauge.
 4. Adjust the upper and lower blades against to the thickness gauge. Also make the thickness gauge can be removed smoothly.
 5. Tight all the screws.
- A Open wrench for blade screw
B 0.25 mm thickness gauge (for 6mm)
C 0.15 mm thickness gauge (for 4mm)



MAXIMUM CUTTING THICKNESS AND ANGLES

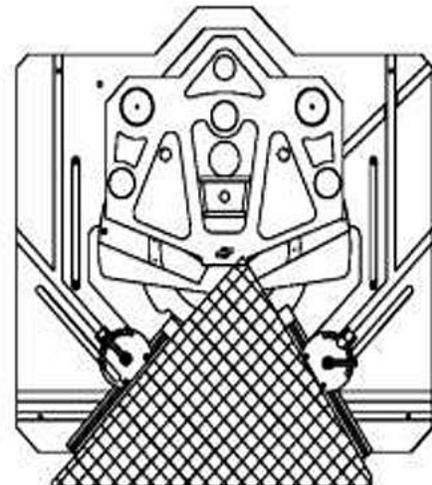
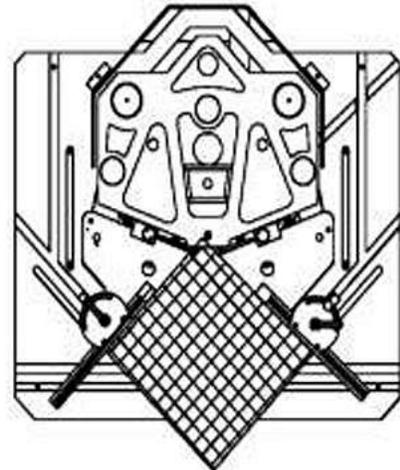
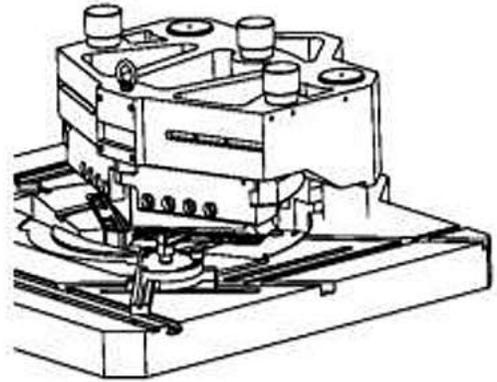
- 6 mm, 30~140 degree
- With 15 degree blades (cut 30° to 60°)
- With 30 degree blades (cut 60° to 140°)





ADJUSTMENT OF MOBILE REFERENCE SQUARE

1. Loosen the handle to the length for the work piece.
2. Take out the pin and adjust the degrees you need.
3. Adjust the left and right block to match work piece.





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:

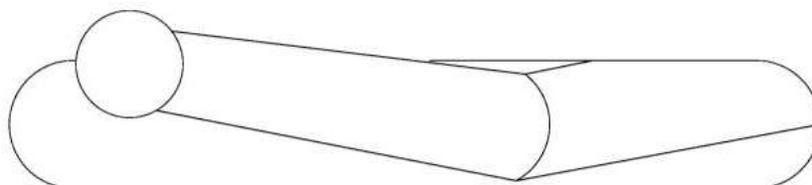
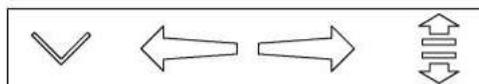
- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Dimensional properties of material must be consistent and not exceed the machine capacity values.
- Chemical structure of material must be consistent.
- Buy certificated steel from the same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

OPERATION

⚠ CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges. When handling large heavy material make sure they are properly supported.

Locking and Unlocking Blade Adjusting Handle

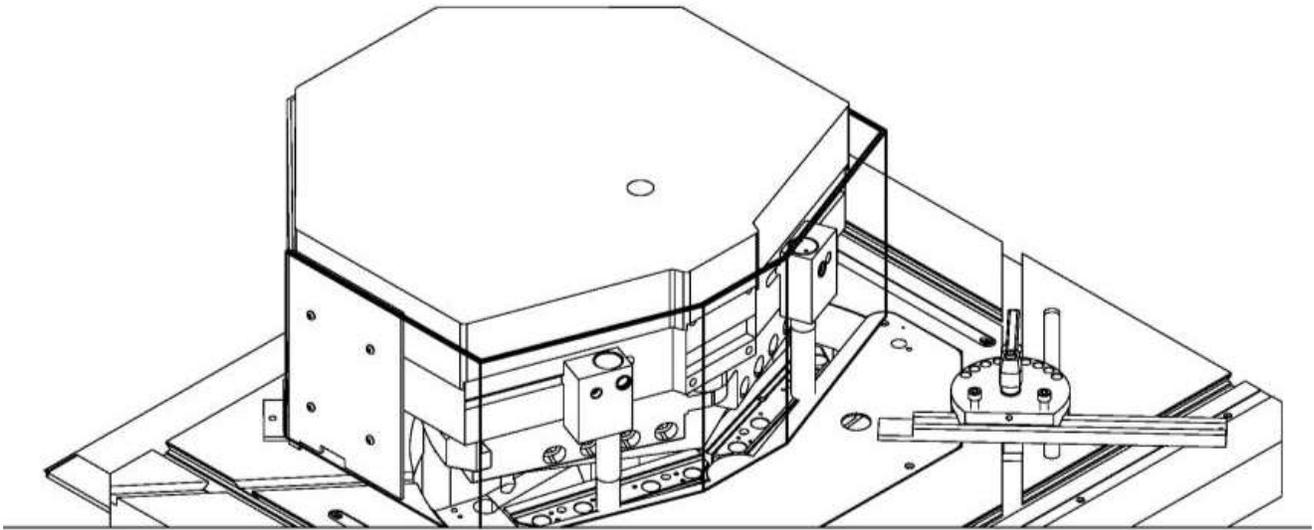
When operator moves the handle to right side (lock position) will **NOT** allow adjusting the blade angle. When operator moves the handle to left side (unlock position) will allow adjusting the blade angle.





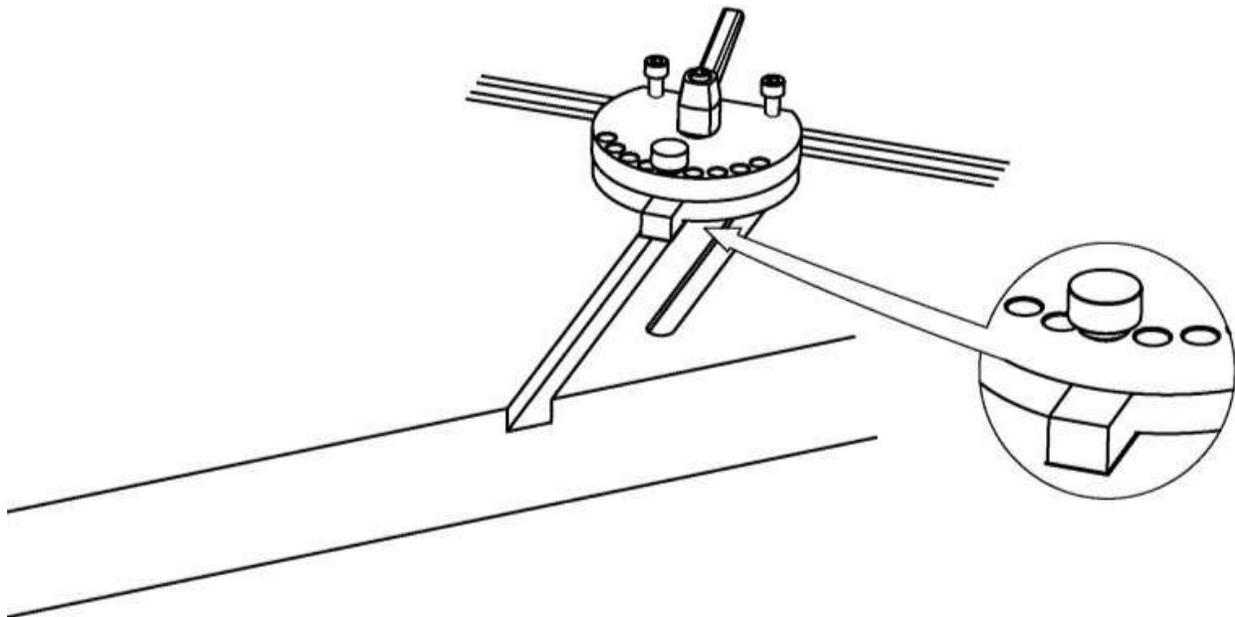
Safety Protection

Never take off the safety cover when operation and **DO NOT** remove the two hold down to avoid the board kick back from when cutting.



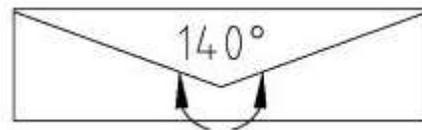
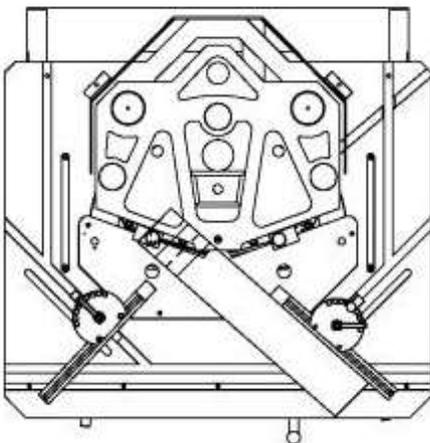
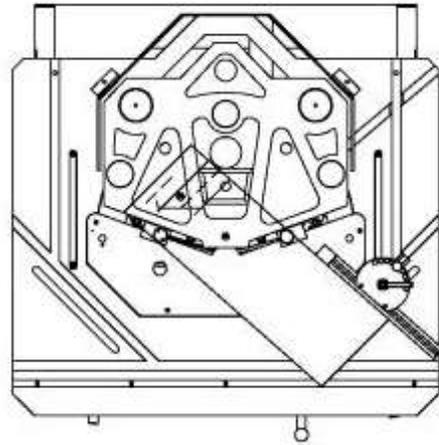
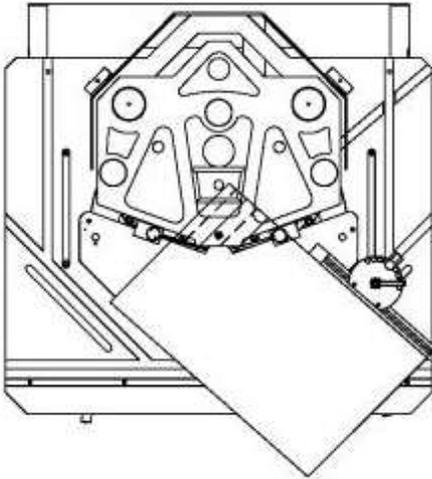
Positioning Squares

The positioning squares are inserted into the T-slots on the table. There are few different direction T-slots for you to choose when operation. They are all equipped with shoulder strut which can be used as fence to again the sheet metal. The referral holes on the square are equal to 15 degree, for locking fixed the angels, just insert the knob pin.





OPERATION REFERENCE





BLADES ADJUSTING

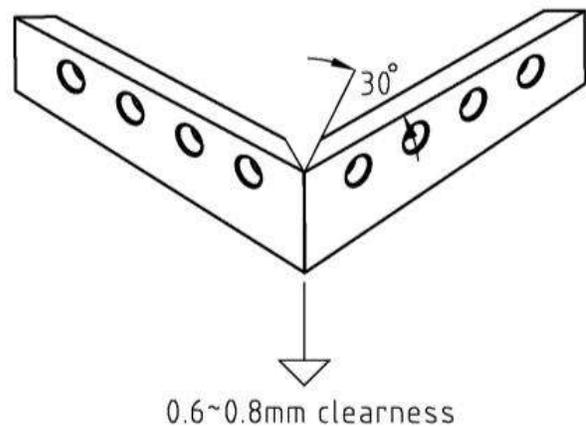
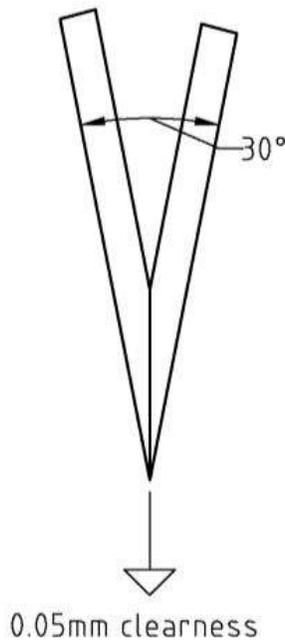


WARNING: Adjustments should be performed by qualified personnel. Always follow proper safety precautions when working on or around any machinery. Disconnect the power supply before making any adjustments.

Upper Blades

When adjust the upper blades with 15 degree blades (cut 30° to 60°), please keep at least 0.05mm clearance at the two blades edge.

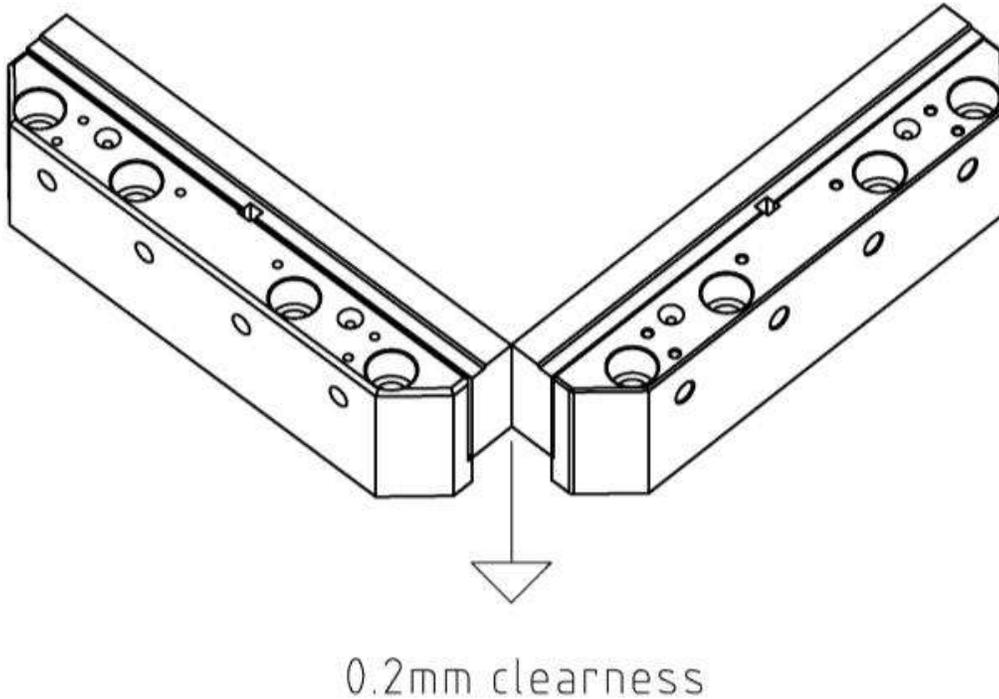
When adjust the upper blades with 30 degree blades (cut 60° to 140°), please keep at least 0.6~0.8mm clearance at the two blades edge.





Lower Blades

When adjust the lower blades, please keep at least 0.2mm clearance at the two blades edge.



Cutting Thickness

When cutting 3 or 4mm board, please keep 0.15mm clearance between the upper and lower blades.

When cutting 6mm board, please keep 0.25mm clearance between the upper and lower blades.

When cutting the stainless board (2mm), please change the special made blades.



MAINTENANCE



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

Maintenance should be performed on a regular basis by qualified personnel.

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

Maintenance on your machine should be done at periodic intervals to ensure that the machine is in good working order. Inspection and maintenance should be performed at least twice a year but more often if the machine receives constant use.

- 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.



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

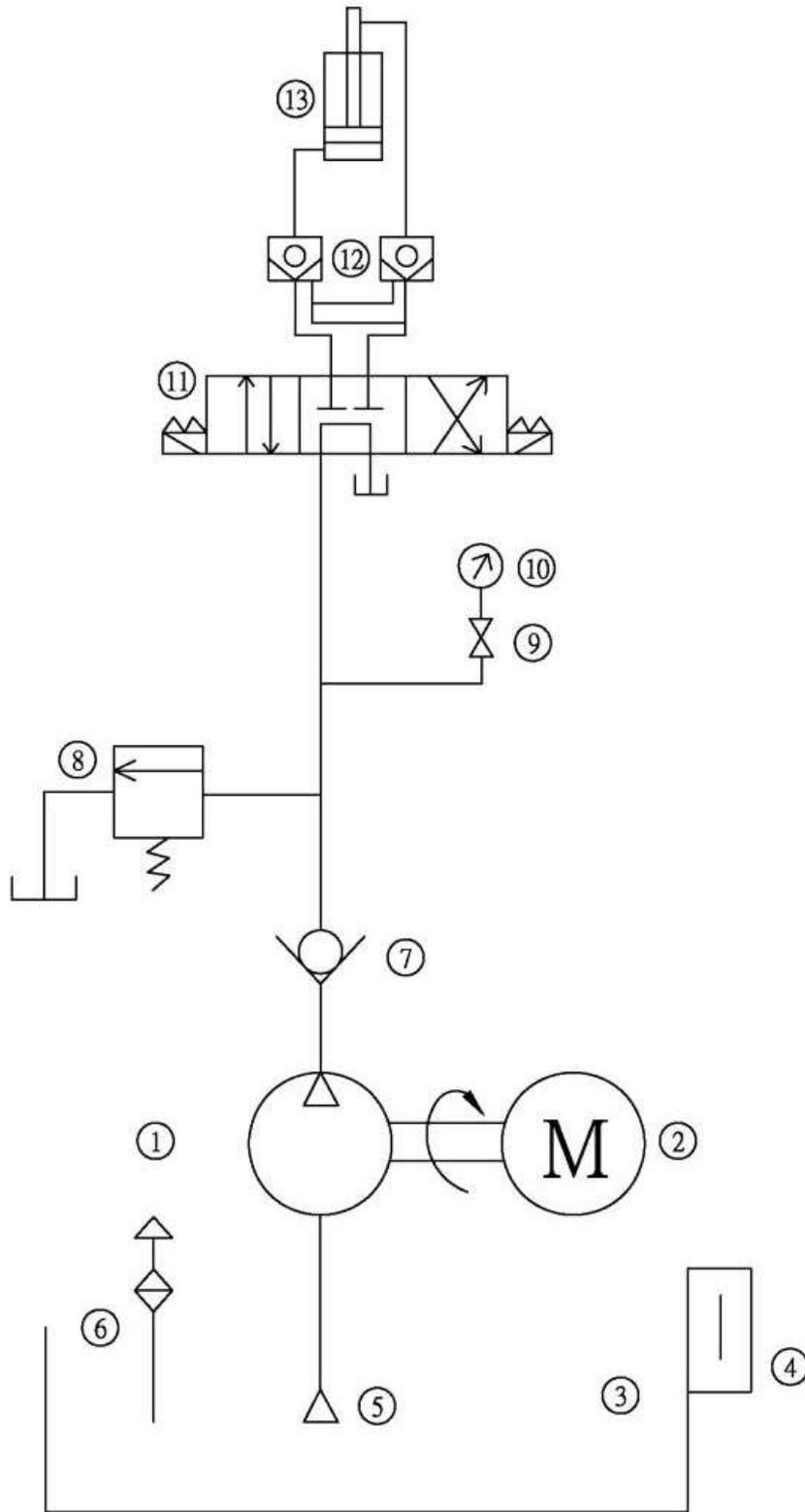
- Check all fasteners to make sure they are tight and check all adjustments that they are in order.
- Clean and oil the tables so that the material will slide easily. Clean any rust spots that may develop on the bed with a commercial rust remover.
- Use a mill file to remove any nicks or dings from the table.

Hydraulic System

The hydraulic circuit oil and filter needs to be replaced after first 3000 hours and then after every 5000 hours operation, change the oil and filter again.



HYDRAULIC DIAGRAM



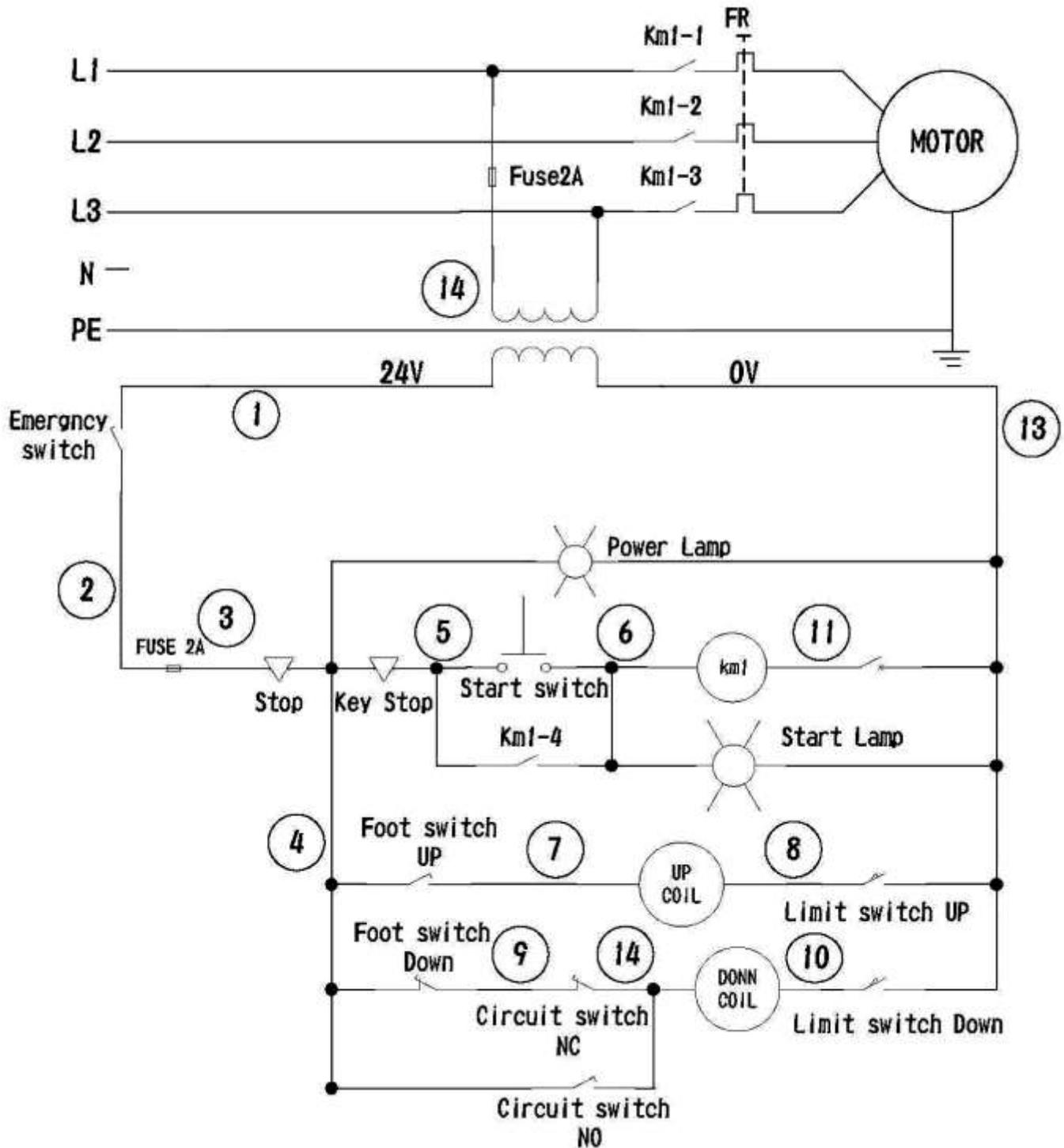


Hydraulic Component List

Item	Description
1	4hp (3kw) Motor
2	Hydraulic Pump
3	Oil Tank
4	3" Oil Gauge
5	Oil Filling Point
6	1/2" Filter
7	3/8" Solenoid Valve
8	1/4" Pressure Gauge Cut Off
9	250 Kgs Oil Gauge
10	082 Pressure Regulator
11	Terminal Block DSG-02-3060-AC24
12	Stop Valve
13	Oil Cylinder

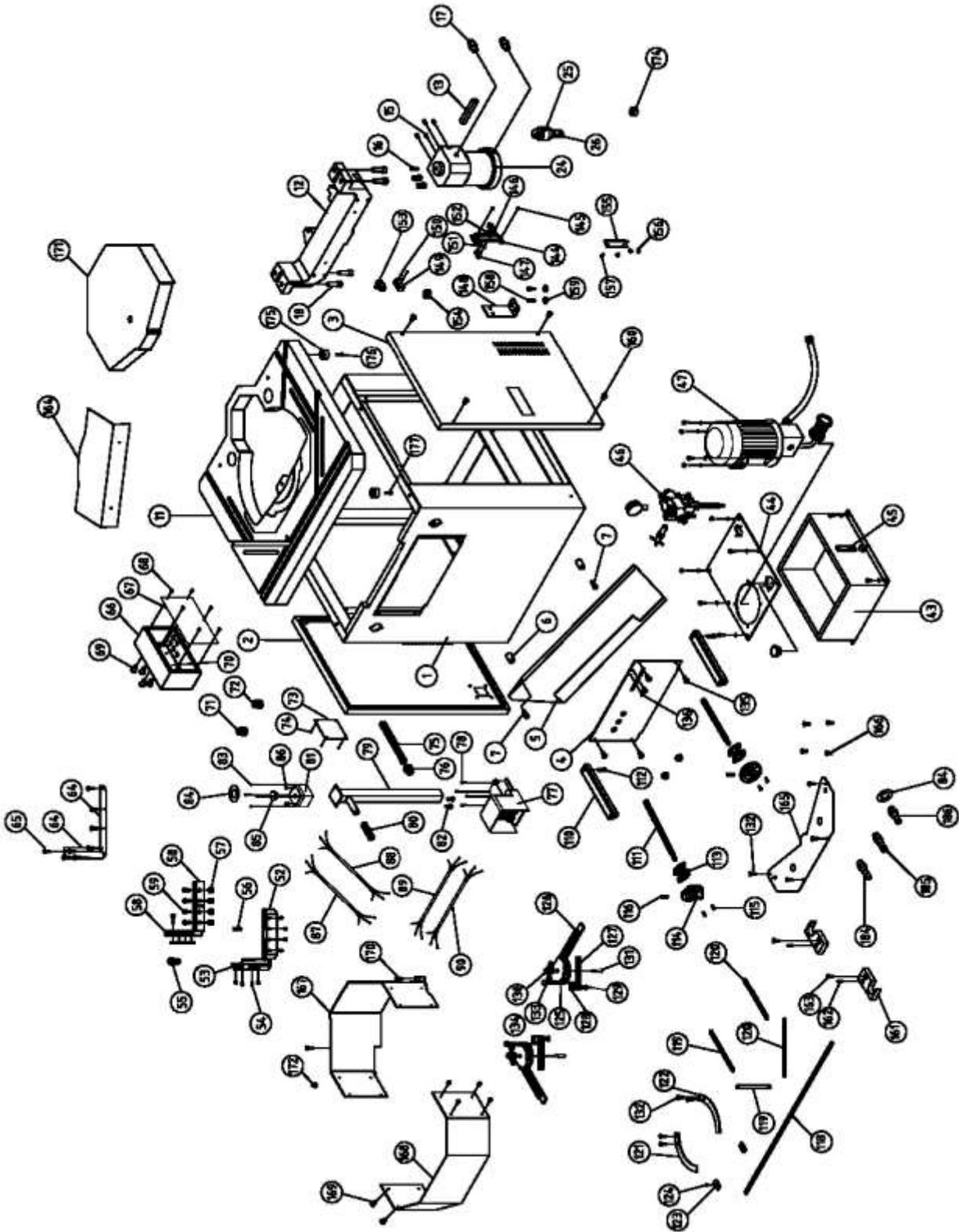


ELECTRICAL DIAGRAM



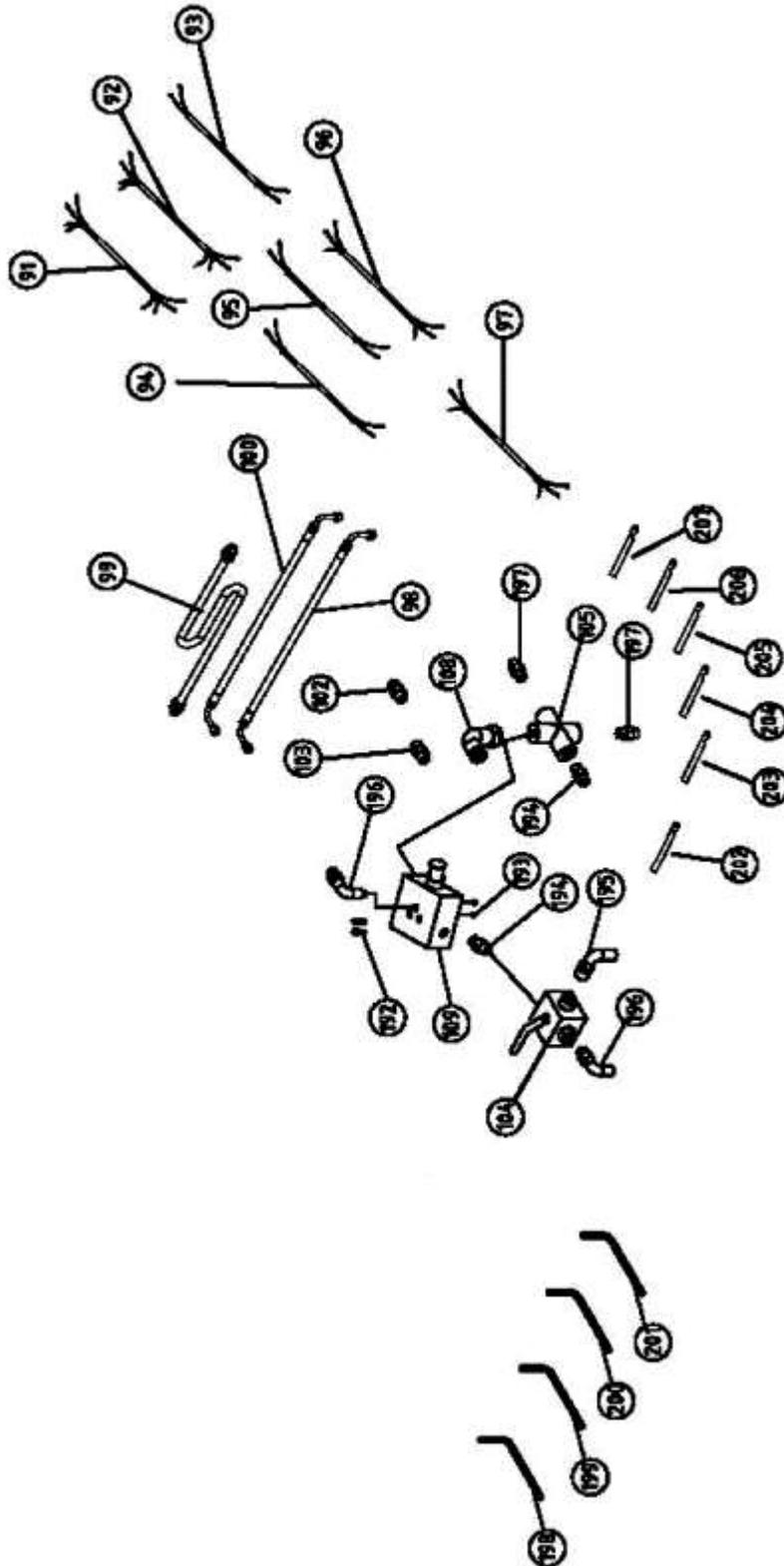


EXPLODED DIAGRAM - 2





EXPLODED DIAGRAM - 3





Part List

NO.	Description	Specification	Q'TY
1	Base		1
2	Right Cover		1
3	Left Cover		1
4	Control Box Cover		1
5	Scrap Discharge Chute		1
6	Plastic Pad		2
7	Cap Screw	M6x50	2
8	Head Set		1
9	Copper Rod	φ70xφx60	4
10	Packing		2
11	Table		1
12	Lower Set		1
13	Cylinder Key	20x20x150	1
14	Cap Screw	M16x35	4
15	Cap Screw	M16x50	4
16	Cap Screw	M16x100	1
17	Oil Bushing	PT3/8"xPT3/8"x90°	2
18	Cap Screw	M16x60	4
19	Single Direction Cylinder	φ40	3
20	Oil Pressure Rod		3
21	Oil Tube Connector	PT1/8"xH1/4"	2
22	Lock Nut	M14	3
23	Turning Track		1
24	Cylinder		1
25	Single Direction Cylinder		2
26	Cylinder Fixing Plate		2
27	Pin		2
28	Key	14x9x60	2
29	Main Spindle		2
30	Hook	M24	1
31	Blade Setting Rod		1
32	Upper Right Blade Kit		1



NO.	Description	Specification	Q'TY
33	Upper Left Blade Kit		1
34	Lock Nut	M16	1
35	Left Upper Cutter		1
36	Right Upper Cutter		1
37	Cap Screw	M10x30	8
38	Sets Screw	M8x10	3
39	Bulb Fixing Board		1
40	Button Head Screw	M6x10	2
41	Bulb Cap		1
42	Bulb	60W	1
43	Oil Tank		1
44	Oil Tank Cover		1
45	Oil Indicator		1
46	Electric Distributor		1
47	Motor		1
48	Right Blade Adjust Set		1
49	Left Blade Adjust Set		1
50	Blade Setting Rod		1
51	Rod		2
52	Right Cutter Set		1
53	Left Cutter Set		1
54	Set Screw	M10x12	8
55	Cap Screw	M10x65	8
56	Key	φ6x20	6
57	PU Rod		8
58	Cutter		2
59	Cap Screw	M10x65	8
60	Right Moving Block		1
61	Left Moving Block		1
62	Pin (Small)		2
63	Pin (Big)		2
64	Stainless Cover		2
65	Countersunk Phillips Head Screw	M5x8	4
66	Control Box		1



NO.	Description	Specification	Q'TY
67	Control Box Cover		1
68	Phillips Head Screw	M4x8	6
69	Button Head Screw	M6x15	4
70	Bottom Board Of Control Box		1
71	Connector Of Power Cord	MG-20	4
72	Connector Of Power Cord	3.0	2
73	Acrylic Board		1
74	Rivet	4-2	4
75	Wire Tube	1/2"x1050	1
76	Bushing	1/2"	2
77	Footpad Control Switch		1
78	Phillips Head Screw	M5x15	4
79	Emergency Stop Switch Rod		1
80	Handle Cap		1
81	Emergency Stop Switch Box		1
82	Phillips Head Screw	M6x12	2
83	Tapping Screw	M4x42	4
84	Emergency Switch Sticker		2
85	Emergency Stop Switch		1
86	Phillips Head Screw	M4x8	2
87	Power Cord		1
88	Motor Cord		1
89	Emergency Switch Cord		1
90	Cord Of Footpad Switch		1
91	Limit Switch		1
92	Limit Switch		1
93	Light Cord		1
94	Stopping Cord		1
95	Solenoid Valve Cord-In		1
96	Solenoid Valve Cord-Off		1
97	Stopping Cord Of Manual Switch		1
98	High Pressure Oil Tube (In)	H3/8"x600	1
99	High Pressure Oil Tube (Out)	H3/8"x1000	1
100	High Pressure Oil Tube	H3/8"x600	1



NO.	Description	Specification	Q'TY
101	Oil Pipe	H1/8"x1800	1
102	Oil Pipe	H1/8"x700	3
103	Oil Pipe	H1/8"x230	2
104	High Pressure Reduce Bore	1/4"	1
105	Cross Joint-(Inner Thread)	PT1/4"	2
106	Bushing	PT1/4"xT1/4"	1
107	Bushing	PT1/4"xH1/4"x45	2
108	Bushing	PT1/4"xH1/4"x90	2
109	Insert Type-Pressure Reduction Valve		1
110	Angle Adjustment Set		2
111	Stopping Nut	7/8"	2
112	Cap Screw	M12x30	2
113	Bearing Set		2
114	Hander Wheel	4"	2
115	Button Head Screw	M6x15	4
116	Spring Pin	φ4x30	2
117	Rod Spring		2
118	Scale		1
119	Left Long Scale		2
120	Right Long Scale		2
121	Left Round Scale		1
122	Right Round Scale		1
123	Short Scale		2
124	Phillips Head Screw	M4x8	13
125	Positioning Square		2
126	Shoulder Strut		2
127	Adjust Moving Plate		2
128	Adjust Plate		2
129	Cap Screw	M5	4
130	Handle		2
131	Rotator of Protractor		2
132	Flat Head Screw	M4x8	8
133	Pin		2
134	Knob	M6x10	2



NO.	Description	Specification	Q'TY
135	Button Head Screw	M6x30	4
136	Flat Head Screw	M4x10	2
137	Left Pressing Plate		1
138	Rod		2
139	Round Pad		2
140	Spring		2
141	Cap	M6x45	2
142	Cap Screw		2
143	Right Pressing Plate		1
144	Limit Switch Plate		1
145	Button Head Screw	M6x10	2
146	Set Block		2
147	Flange Bolt	M5x12	4
148	Limit Switch Board		1
149	Switch Cover		4
150	Phillips Head Screw	M4x30	8
151	Washer	1.5x1/4"x16	2
152	Spring Washer	M5	4
153	Limit Switch		4
154	Nut	M4	8
155	Fixing Plate		1
156	Button Head Screw	M8x10	2
157	Button Head Screw	M6x10	2
158	Cap Screw	M6x15	2
159	Washer		2
160	Button Head Screw	M6x50	8
161	Fixing Block		2
162	Fixing Pin	φ6x20	2
163	Countersunk Phillips Head Screw	M4x16	2
164	Chip Leading Board		1
165	Angel Plate		1
166	Flat Head Screw	M4x8	4
167	Safety Cover		1
168	Head Set Acrylic Cover Board		1



NO.	Description	Specification	Q'TY
169	Button Head Screw	M6x10	12
170	Cap Screw	M6x15	2
171	Head Set Cover		1
172	Bushing	PG-16	1
173	Setscrew	M6x20	3
174	Nut	M10	2
175	PU Pad		4
176	Flat Head Screw	M10x30	2
177	Cap Screw	M10x30	2
178	Right Anti-Chip Plate		1
179	Left Anti-chip Plate		1
180	Flat Head Screw	M4x8	2
181	Cap Screw	M6x40	2
182	Nut	M6	2
183	Setscrew	M6x20	2
184	Power Light		1
185	Start Switch		1
186	Key Lock Switch		1
187	Main Spindle Packing		2
188	Spring Washer	M16	2
189	Cap Screw	M16x40	2
190	Steel Ball	φ6	2
191	Bearing		2
192	Cap Screw	M6x50	2
193	Nut	M6	2
194	Vertical Bushing	PT3/8"xPT1/4"	2
195	Bushing	PT1/4"xH3/8"x90°	2
196	Bushing	PT3/8"xH1/4"x90°	2
197	Vertical Bushing	PT1/4"xH1/4"	2
198	Allen Wrench	2.5mm	1
199	Allen Wrench	4mm	1
200	Allen Wrench	5mm	1
201	Allen Wrench	8mm	1
202	0.05mm Thickness	0.05mm	1



NO.	Description	Specification	Q'TY
203	0.15mm Thickness	0.15mm	1
204	0.2 mm Thickness	0.2mm	1
205	0.25mm Thickness	0.25mm	1
206	0.6mm Thickness	0.6mm	1
207	0.8mm Thickness	0.8mm	1



NOTES



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