



OPERATOR'S MANUAL

Metal Working



STRAIGHT HAND BRAKE MODEL: HB-12016

Baileigh Industrial, Inc.
P.O. Box 531
Manitowoc, WI 54221-0531
Phone: 920.684.4990
Fax: 920.684.3944
sales@baileigh.com

REPRODUCTION OF THIS MANUAL IN ANY FORM WITHOUT WRITTEN APPROVAL OF BAILEIGH INDUSTRIAL, INC. IS PROHIBITED. Baileigh Industrial, Inc. does not assume and hereby disclaims any liability for any damage or loss caused by an omission or error in this Operator's Manual, resulting from accident, negligence, or other occurrence.

Rev. 12/2016

© 2016 Baileigh Industrial, Inc.



Table of Contents

THANK YOU & WARRANTY	1
INTRODUCTION.....	3
GENERAL NOTES.....	3
SAFETY INSTRUCTIONS	4
SAFETY PRECAUTIONS	6
Dear Valued Customer:.....	6
TECHNICAL SPECIFICATIONS	8
DESCRIPTION.....	8
TECHNICAL SUPPORT	8
UNPACKING AND CHECKING CONTENTS.....	9
Cleaning	10
TRANSPORTING AND LIFTING	11
INSTALLATION.....	12
Anchoring the Machine	12
Mounting Supports to the Main Body of the Brake	13
Attaching the Handles	13
Installing the Counterweights.....	14
Mounting the Stop Rod	14
GETTING TO KNOW YOUR MACHINE	15
SETUP AND ADJUSTMENTS	16
Adjusting the Setback.....	16
Positioning the Stop Collar	17
Counterweight Adjustments.....	17
Adjusting the Clamping Pressure	18
Top Leaf Adjustment	19
Bending Leaf Edge Alignment	20
OPERATION	21
Bending Allowance	21
Bending Sheet Metal	21
UNDERSTANDING SPRINGBACK	22
MATERIAL SELECTION.....	22
MATERIAL EQUIVALENCY CHART	22
LUBRICATION AND MAINTENANCE	23
PARTS IDENTIFICATION DRAWING	24
PARTS LIST.....	25
TROUBLESHOOTING	26



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, (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, 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 modifications.



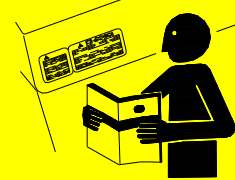
Note: This symbol refers to useful information throughout the manual.



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.**



DANGER

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



WARNING

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



CAUTION

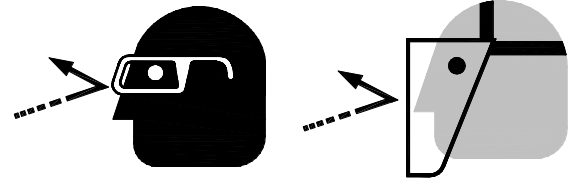


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



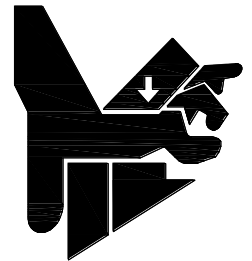
PROTECT EYES

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



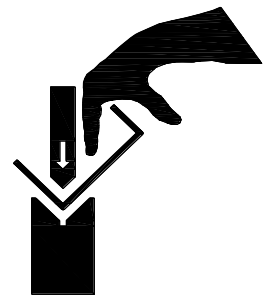
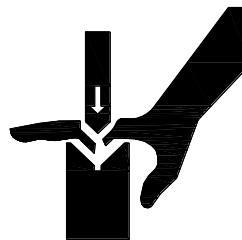
BEWARE OF CRUSH HAZARD

Closing upper beam and brake bed will result in loss of fingers or limbs if placed in machine. **NEVER** place your hand or any part of your body in this machine.



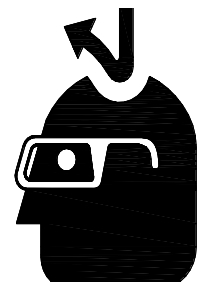
BEWARE OF CRUSH HAZARD

NEVER place your hands, fingers, or any part of your body in the die area of this machine.



KEEP CLEAR OF MOVING OBJECTS

Always be aware of the position of the clamp handle and the counterweight. They are heavy and can swing back suddenly causing serious body or head injuries.





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**

Dear Valued Customer:

- All Baileigh machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

PLEASE ENJOY YOUR BAILEIGH MACHINE! ...PLEASE ENJOY IT SAFELY!

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 machines 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 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.
11. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
12. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
13. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
14. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. **Observe work area conditions.** **DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted.
16. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
17. **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. Keep visitors a safe distance from the work area.



TECHNICAL SPECIFICATIONS

Bend Length	120" (3048mm)
Bend Material Thickness	16ga. (1.52mm) mild steel* 20ga. (0.912mm) stainless steel**
Bend Angle	0 – 135 degrees
Floor Stand	2 pcs. Welded Steel
Shipping Dimensions (L x W x H)	148" x 34" x 40" (3759 x 864 x 1016mm)
Shipping Weight	3300 lbs. (1500 kg)
Based on a material tensile strength of *64000 PSI – mild steel **100000 PSI – stainless steel	

DESCRIPTION

The Baileigh Model HB-12016 Straight Hand Brake is hand operated and capable of bending up to 16ga. (1.52mm) mild steel and 20ga. (.912mm) stainless x 120" (3048mm) long. The machine has a 6" (152mm) box depth allowing it to fabricate pans, boxes, channels, angles, and other shapes. Adjustable counterweights allow the operator to balance the bending leaf to correspond to material thickness. An adjustable stop gauge is included to allow the operator to perform repeat bends.

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.

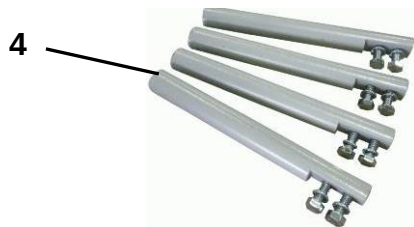
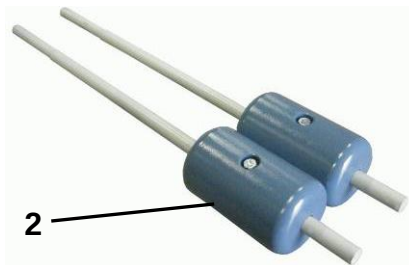


Note: The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.



UNPACKING AND CHECKING CONTENTS

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



6

Item	Description	Qty.
	Brake Main Body	1
1	Supports	2
2	Counterweight Assemblies	2
3	Open End Wrench	1
4	Handles w/Bolts & Lockwasher	4
5	Stop Rod w/Cotter Pin	1
6	Hex Bolt ½-13x1.75"	6
	Lockwasher ½"	6
	Flatwasher	6
	Hex Nut ½-13	6
	Touch-up Paint	



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** place the machine into service 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.





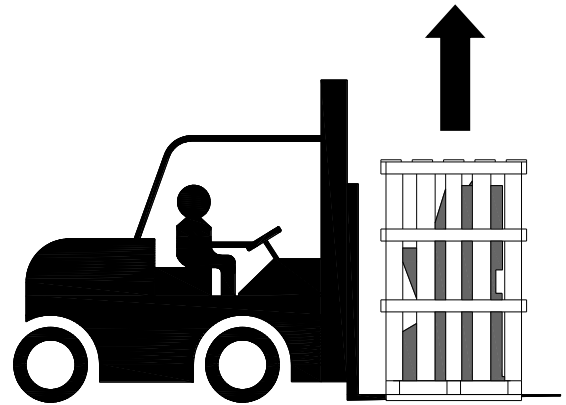
TRANSPORTING AND LIFTING



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

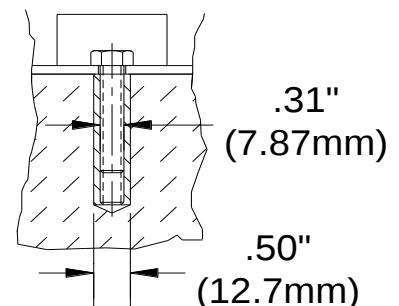
IMPORTANT:

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

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.

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.





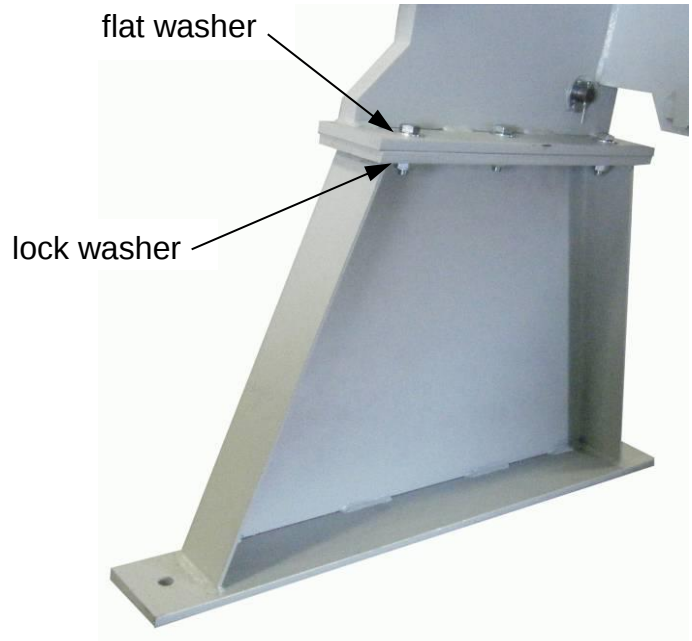
Mounting Supports to the Main Body of the Brake

1. Pull back on the clamp handles to raise the clamping leaf.
2. When using a fork lift to raise the main body from the pallet, first spread the forks as wide as possible.
3. Place wood or similar material between the forks and the finger blade to protect the finger blade from damage.



WARNING: DO NOT position yourself under the main body at any time while attaching the supports.

4. Raise the main body from the pallet, avoiding sudden accelerations or quick changes of direction and carefully pull the pallet out of the way.
5. While the main body is being held securely by the fork lift, attach the supports with (6) 1/2-13 x 1-3/4" hex bolts, flat washers, lock washers, and hex nuts. Tighten securely.
6. Carefully lower the brake, and set into position on the floor.



Attaching the Handles

Locate and secure the handles to the backside of the bending plate with M10 x 40mm capscrews, flat washers, and lock washers included.





Installing the Counterweights

1. Loosen the jam-nuts and back out the hex bolts of each counterweight pocket for clearance.
2. Carefully lift the counterweight assembly and place into the pocket.
3. Tighten the hex bolts against the shaft and finally secure the jam-nuts.
4. Repeat the above procedure for the other counterweight.



Note: DO NOT use the counterweight arms to raise the bending leaf or you may damage the hinges.



Mounting the Stop Rod

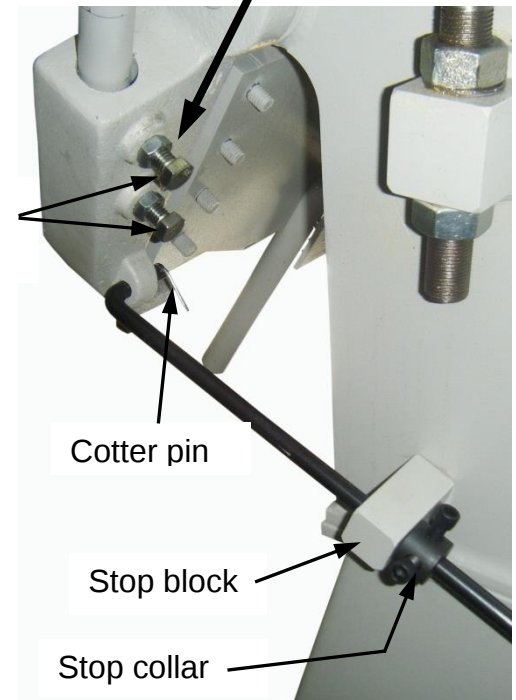
1. Loosen the socket head bolts on the stop collar and remove from the stop rod.
2. Insert the stop rod into the rotating stop block.
3. Push the short end of the stop rod into the tab on the bending leaf and secure with the cotter pin (supplied).
4. Slide the stop block back onto the stop rod as shown.
5. Install the stop collar and snug socket head bolts.

Tighten
Securely

Cotter pin

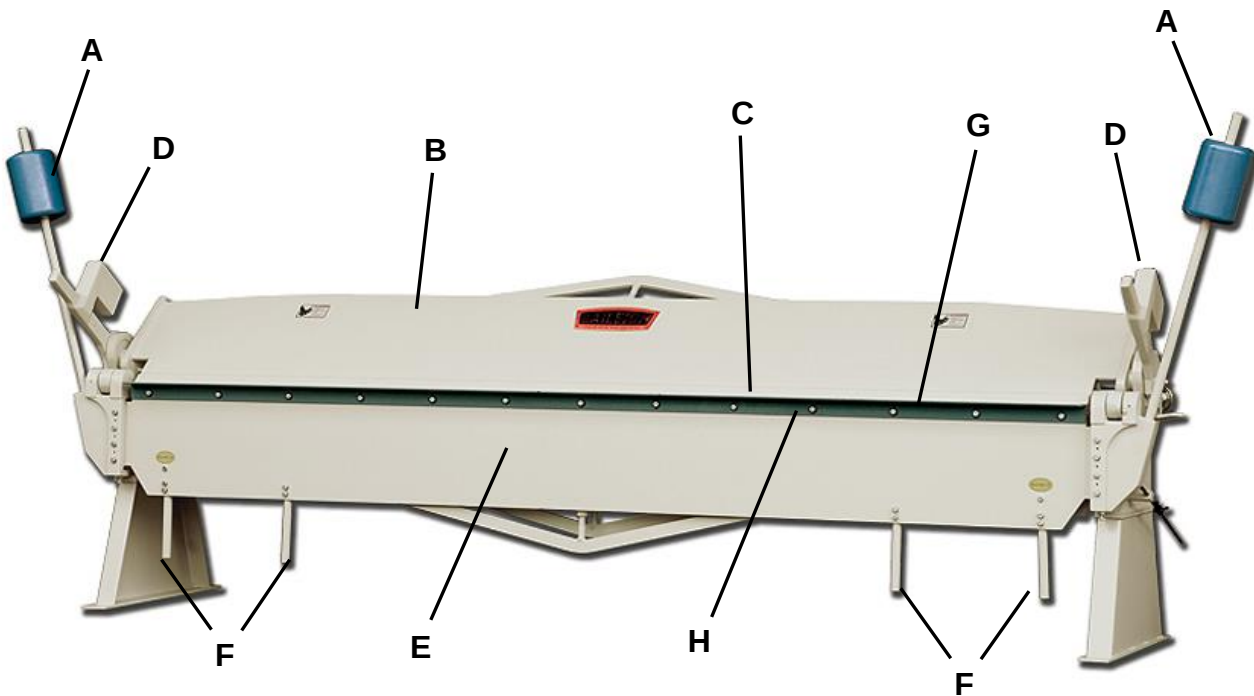
Stop block

Stop collar





GETTING TO KNOW YOUR MACHINE



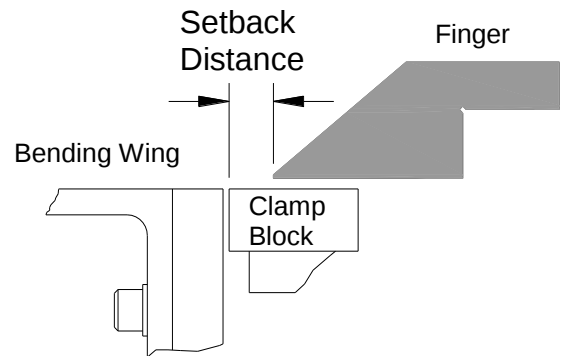
Item	Name	Description
A	Counterweight	Adjustable weights to assist in raising the bending leaf.
B	Clamping Leaf	Secures the piece part against the clamping block.
C	Finger Blade	The die that the piece part is bent against.
D	Clamping Handles	Used to raise, lower, and lock the clamping leaf.
E	Bending Leaf	Raised by the operator to make the bend.
F	Operating handles	Used by the operator to raise the bending leaf.
G	Clamp Block	Lower jaw for clamping and holding the piece part.
H	Bending wing	Angle on bending leaf that presses piece part against finger.



SETUP AND ADJUSTMENTS

Adjusting the Setback

Setback is the distance from the front edge of the finger to the front edge of the clamp block. This distance is determined by the gauge (thickness) of the piece part and inside radius of the bend. The setback is typically 1.5 – 2 times the material thickness.



1. To adjust, make sure the clamp leaf is not clamped in the down position
2. Loosen the setback knob set screw. (Allen head style shown.).
3. Rotate the setback knobs counter-clock wise (**ccw**) to move the finger toward the edge of the clamp block or clockwise (**cw**) to the finger back.
4. Re-tighten the setback knob setscrews to hold the shaft in place. (**DO NOT** overtighten).



Note 1: Always make sure the finger is parallel with the edge of the clamp block to avoid any distortion of the bend.



Note 2: To avoid damaging the brake, include the thickness of folded edges when determining the setback distance.

5. To check clamp alignment from end to end, make a 90° test bend in each of two small sample pieces, placing them 4" (102mm) in from each end of the brake. Stack the bent strips on top of each other and check that they are bent to the same degree. If a strip is over bent, increase the setback on that side accordingly. Vice versa if it is under bent. Move the fingers past the desired set back point, and then forward towards the clamp block edge to remove any slack.



Positioning the Stop Collar

The stop collar is used for repeat bending when you want the bending leaf to stop at the same position each time.

1. Loosen the stop collar and make your bend, stopping at the top of the bend.
2. Slide the collar up to the stop hub and tighten.
3. The bending angle can now be repeated until reset by the operator.



Counterweight Adjustments



CAUTION: DO NOT allow the weight to free fall down the shaft or fall off the shaft where it might cause personal injury.
DO NOT lower the weights to a point where they restrict the motion of the locking clamp arms.

The counterweights provide added leverage when bending thicker piece parts. Position the weight **LOW** when bending light gauge material and **HIGH** when bending heavier gauge material. Never use material heavier than the machine is rated for.

Adjust the counterweights by loosening the hex bolt and raising or lowering the position of the weight on the shaft. (One operator can tend to the bolt while the other operator positions the weight.)





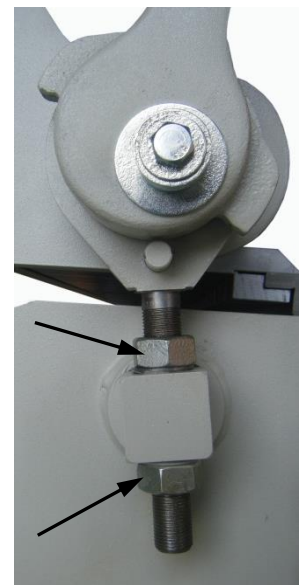
Adjusting the Clamping Pressure



CAUTION:

- Excessive clamping pressure can “pre load” and permanently distort the brake.
- DO NOT bend material heavier than the rated capacity, even in shorter lengths.
- Use material with square-sheared edges. (a rolled edge will cause bowing).
- Bending a round object will warp or nick the clamp edge.
- Adjust the clamp pressure accordingly for different metal gauges.
- Do not use a pipe extension on the clamp bars to get more leverage.

The clamping pressure may have to be adjusted as the thickness of the piece part changes. A suitable pressure should have a medium resistance when pulling back on the hold down handle(s). At the end of the stroke there should be a definite locking of the piece part under the clamping leaf. To adjust the pressure, move the nuts on the threaded link shaft either up or down.



1. To adjust the clamping pressure, tighten both sides of the clamping leaf with a piece part in the brake.
 - a. If the clamping pressure seems light and the piece part is loose in the clamp, move the adjusting nuts **UP**.
 - b. If the clamping pressure seems hard and you can't lock the handles, move the adjusting nuts **DOWN**.
 - c. Once the pressure feels right, no further adjustments are necessary for this thickness piece part. (When changing thickness it may become necessary to adjust again.)
2. Remove the piece part from under the clamping leaf, lock down the leaf with the handles, and loosen pressure on the top nut.
3. Unlock the clamping leaf and turn the bottom nut ½ turn in the desired direction.
4. Lock the clamping leaf, re-tighten the top nut, and repeat Step 1 above until the desired pressure is reached.

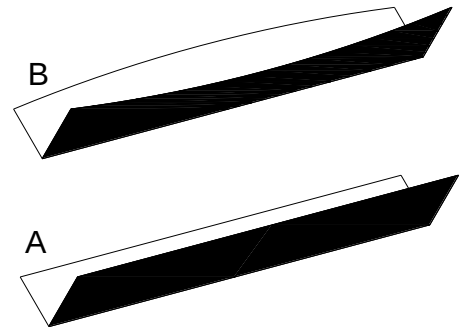


Top Leaf Adjustment



IMPORTANT: The top leaf and bending leaf adjustments were made at the factory based upon full capacity (length and thickness) mild steel. Additional adjustments are generally not needed. Different materials and material strength and hardness variation may require adjusting the leaf to obtain a satisfactory bend.

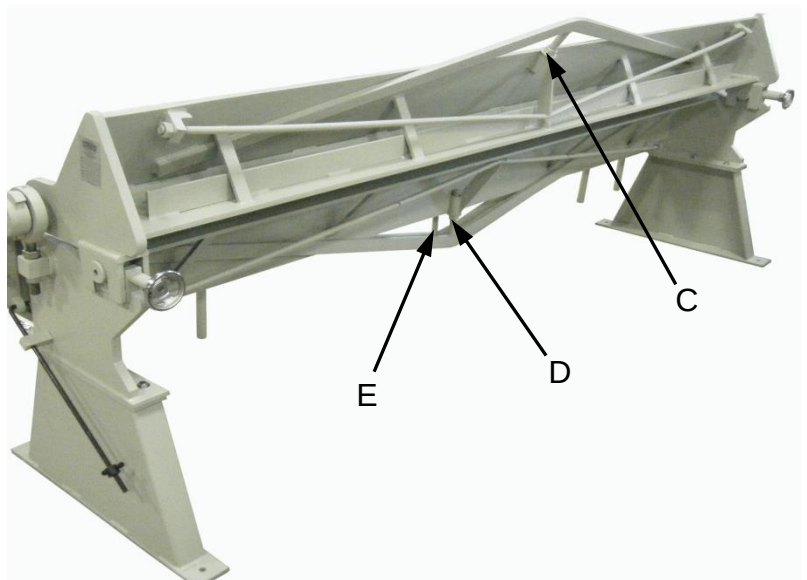
Normal bending should provide a consistent bend angle (A) over the entire length of the material. If the angle remains open (B) in the middle of the material, the leaf may need to be adjusted to reduce bend angle variation.



Note: The brake needs to be leveled and secured to the floor to provide consistent accurate results.

Crowning adjustment is made by tightening or loosening the center leaf nuts (C and D).

1. Move the clamp handles to the forward position.
2. If the bend is open on the middle as in example (B), evenly tighten the top leaf center truss nut (C) and the lower leaf center truss nut (D) 1/2 turn each and test the bend angle.
3. Repeat the test bend and continue to adjust until the bend is even over the entire length of the material.

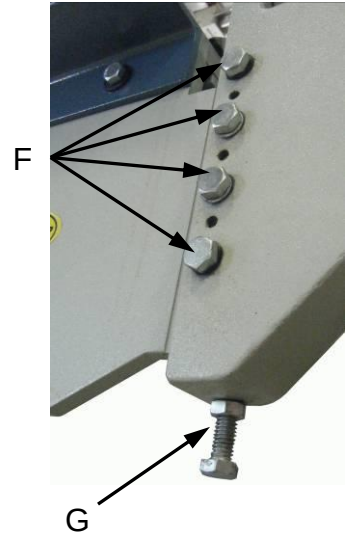




Bending Leaf Edge Alignment

Bending accuracy is dependent on the top surface of the bending leaf and the attached bending wing being flush with the top face of the clamping block when the bending leaf is in the lowered position.

1. Adjust bending leaf center truss nut (E) up or down as needed until the center of the bending leaf is perfectly aligned (on the same plane) with the clamping leaf edge.
2. Loosen the hinge to leaf bolts (F) only slightly to allow for the leaf to move with the adjusting bolt (G).
3. Adjust bending leaf ends with hinge adjustment bolts (G) up or down as needed until the ends of the bending leaf are perfectly aligned (on the same plane) with the clamping leaf edge.
4. Repeat these steps as needed until the entire length of the bending leaf is perfectly aligned (on the same plane) with the clamping leaf edge.
5. Tighten the hinge bolts (F) after adjustment.





OPERATION



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



CAUTION: Keep hands and fingers clear of the clamping beam. Stand off to the side of the machine to avoid getting hit with the bending apron as it comes up to bend.

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

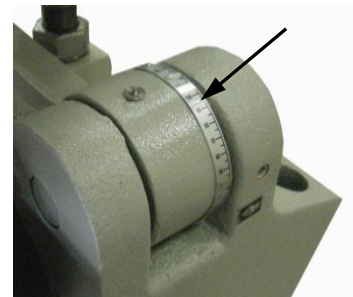
When performing basic bending operations, it is important that the fingers of the brake are parallel with the edge of the clamping block. Also, make sure you have the proper setback and clamping pressure set for the thickness material being bent.

Bending Allowance

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

Bending Sheet Metal

1. Lift the clamping handle(s) to open up the clamping leaf.
2. Insert the piece part between the clamping leaf and the brake finger.
3. Align the finger of the clamping leaf to the scribed bend line of the piece part and clamp in place by pulling the clamp handle(s) down.
Note: DO NOT force the clamping handle(s). The holding pressure only needs to be tight enough to hold the sheet metal from moving when bending.
4. Pull up on the bending leaf handles until the piece part has reached the desired bend angle.
5. Lower the bending leaf, raise the clamping leaf, and remove the bent piece part.





UNDERSTANDING SPRINGBACK

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

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.

MATERIAL EQUIVALENCY CHART

Mild Steel	14ga. (.075") (2mm)
Stainless Steel	18ga. (.048") (1.2mm)
Aluminum	.200" (5mm)
Soft Brass	.135" (3.4mm)
Annealed Phosphor Bronze	.120" (3mm)
Soft Copper	.135" (3.4mm)
Hard Copper	.120" (3mm)
ABS Plastic	.250" (6.3mm)



LUBRICATION AND MAINTENANCE



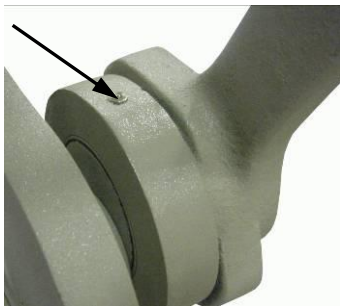
WARNING: Maintenance should be performed on a regular basis by qualified personnel.
Always follow proper safety precautions when working on or around any machinery.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.

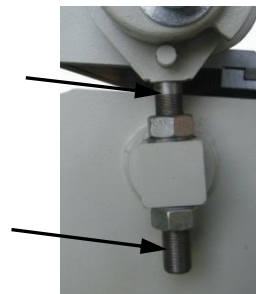
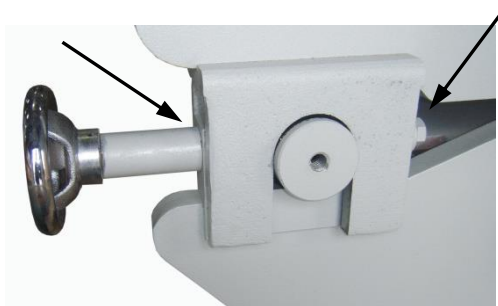


Note: Proper maintenance can increase the life expectancy of your machine.

Using an oil can with a good quality #30W oil, apply 5-6 drops into each of the four ports. Repeat weekly; more often depending on usage. Wipe off any excess oil.

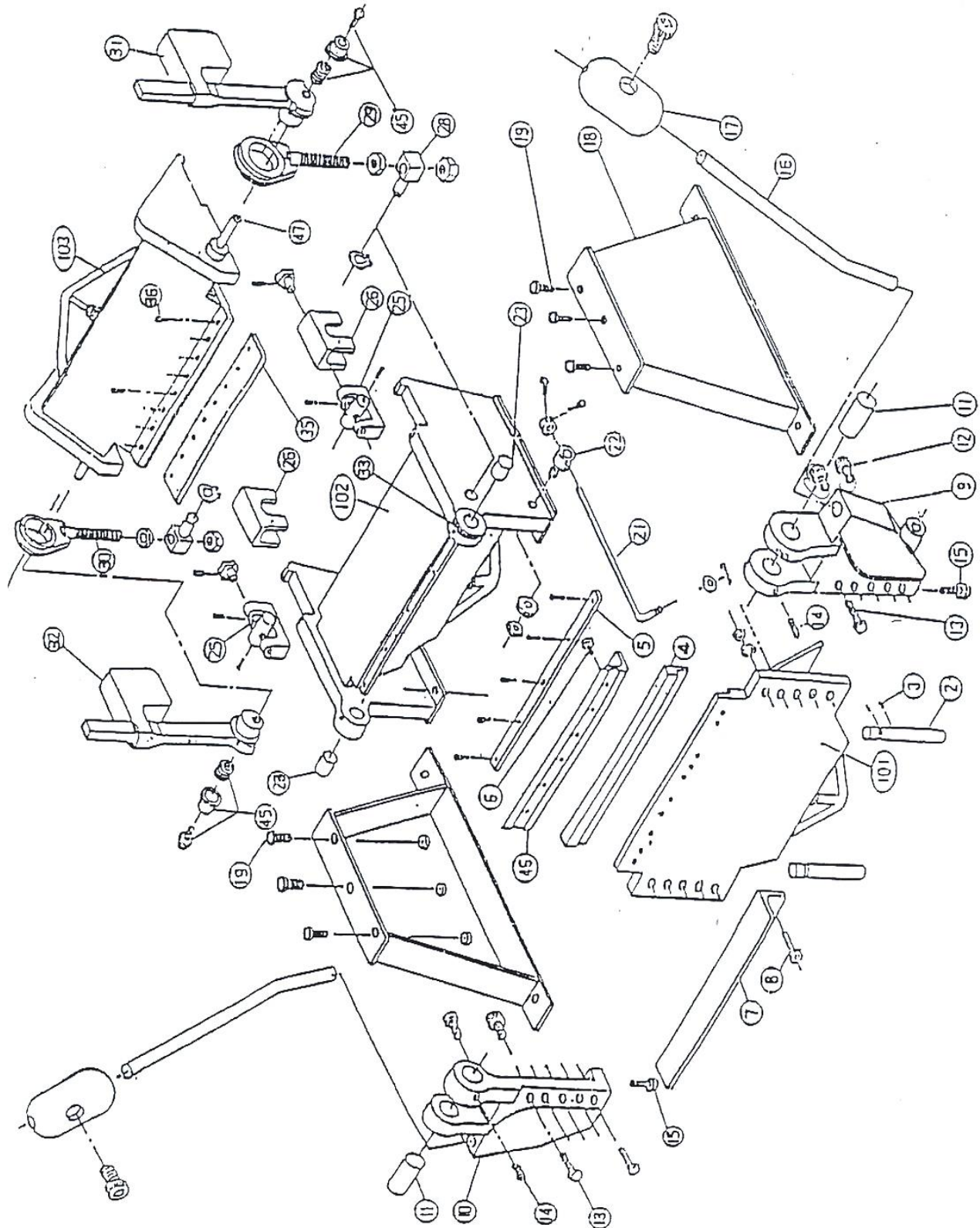


The threads on the setback knobs and the threads on the clamping pressure adjustment will need an occasional wiping down with white lithium grease. This will help to maintain smooth operation of each.





PARTS IDENTIFICATION DRAWING





PARTS LIST

Item	Description	Qty.
101	Bending leaf Assembly	1
2	Handle bar	2
3	Screw	4
4	Insert bar	1
5	Bottom bar	1
6	Round head screw	25
7	Angle bar	1
8	Round head screw	10
9	Hinge (R. H.)	1
10	Hinge (L. H.)	1
11	Hinge rod	2
12	Round – head screw	4
13	Hexagon screw	10
14	Headless screw	4
15	Round – head screw	2
16	Rod	2
17	Counter weight Assembly	2
18	Stand Assembly	2
19	Hexagon screw	6
21	Bending adjustable rod Assembly	1
22	Box adjustable Assembly	1
23	Bushing	2
102	Base Assembly	1
25	Bolt adjustable Assembly	2
26	Holder	2
28	Swivel pin Assembly	2
29	Toggle Assembly (R. H.)	1
30	Toggle Assembly (L. H.)	1
31	Clamping handle (R. H.)	1
32	Clamping handle (L. H.)	1
33	Scale	1
34	Hold down Assembly	1
35	Top blade	1



Item	Description	Qty.
36	Screw	25
45	Spring cover Assembly	2
46	Insert clamp bar	1
47	Shaft clamp handle	2

TROUBLESHOOTING

FAULT	PROBABLE CAUSE	REMEDY
INACCURATE BENDS	Fingers are not aligned	Follow proper finger alignment procedure.
	Setback distance is not equal from one side to the other	Accurately measure distance and set accordingly.
	Clamping leaf is not holding piece part securely.	Re-adjust the clamping pressure.
	Bending wing out of alignment with the top surface of the clamping block.	Please consult the Baileigh Service Department
BENDING LEAF HARD TO LIFT AND BEND.	Exceeding the bending limits of the brake.	Do not bend material thicker than the machine was designed for.
	Counter weights are not adjusted properly.	Locate the weight lower for thin material and high for thicker material.



NOTES



NOTES



NOTES



BAILEIGH INDUSTRIAL, INC. 1625 DUFEEK DRIVE MANITOWOC, WI 54220

PHONE: 920. 684. 4990 FAX: 920. 684. 3944

www.baileigh.com

BAILEIGH INDUSTRIAL, INC. 1455 S. CAMPUS AVENUE ONTARIO, CA 91761

PHONE: 920. 684. 4990 FAX: 920. 684. 3944

BAILEIGH INDUSTRIAL LTD. UNIT D SWIFT POINT

SWIFT VALLEY INDUSTRIAL ESTATE, RUGBY

WEST MIDLANDS, CV21 1QH UNITED KINGDOM

PHONE: +44 (0)24 7661 9267 FAX: +44 (0)24 7661 9276

WWW.BAILEIGH.CO.UK

BAILEIGH INDUSTRIAL GMBH HOFENER STRAßE 64

70736 FELLBACH

DEUTCHSLAND

WWW.BAILEIGHINDUSTRIAL.DE

BAILEIGH INDUSTRIAL PTY. LTD.

P.O BOX 1573, 126 MELROSE DRIVE TULLAMARINE,

VIC 3043 AUSTRALIA

PHONE: 011 61 383 743 888

WWW.BAILEIGH.COM.AU