



OPERATOR'S MANUAL



HYDRAULIC PLATE ROLLER MODEL: PR-413

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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@baileighindustrial.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.



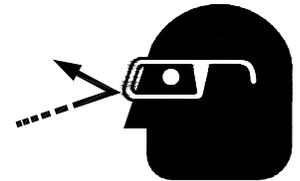


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



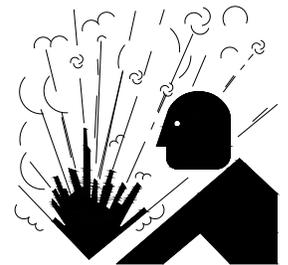
PROTECT EYES

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



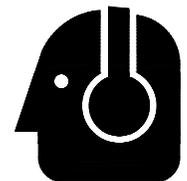
HYDRAULIC HOSE FAILURE

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



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.



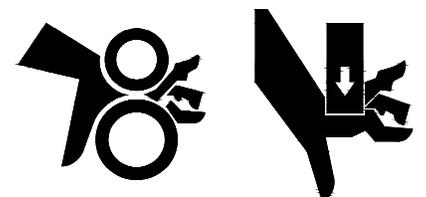
HIGH VOLTAGE

USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT assume the power to be off.
FOLLOW PROPER LOCKOUT PROCEDURES.



BEWARE OF PINCH POINTS

Keep hands and fingers away from the rolls and roll drive components when the machine is in operation or when doing maintenance.





Dual Emergency Stop Cables

The Plate Roller has a safety stop cable located at both the front and the rear of the machine. Pulling on the cable actuates the limit switch which immediately stops the hydraulic pump and all movement of the rolls. Press the flashing orange Reset button to reset the circuit.



machine.

Note: Pressing the **RESET** button will not start the





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.** Before bending sheet metal, 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. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
20. **DO NOT** bypass or defeat any safety interlock systems.
21. Keep visitors a safe distance from the work area.



TECHNICAL SPECIFICATIONS

Roll Speed	6 rpm
Upper Roll Diameter	3.50" (89mm)
Minimum Forming Diameter	5.25" (133mm)
Roll Adjustment Back	Hydraulic
Wire Grooves	Yes
Capacity (Mild Steel)	13ga. (.090") (2.27mm)
Forming Width	48" (1219mm)
Motor	1.5hp (1.1kw) 220V / 1ph / 60hz / 12A
Power	220V / 1ph / 60hz
Shipping Weight	1,254 lbs. (569kg)
Shipping Dimensions	75" x 29" x 46" (1905 x 737 x 1169mm)

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@baileighindustrial.com, Phone: 920.684.4990, or Fax: 920.684.3944.



Note: The photos illustrations using 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

⚠ WARNING: 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.

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.

The plate roller is fully assembled and includes the control pedestal and the tool kit.



Cleaning

Your machine may be shipped with a rustproof waxy oil coating and grease on the exposed unpainted metal surfaces. To remove this protective coating, use a degreaser or solvent cleaner. 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.

⚠ 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.



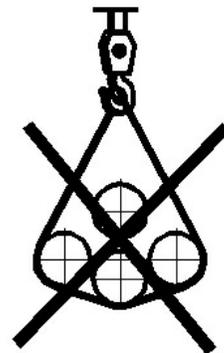
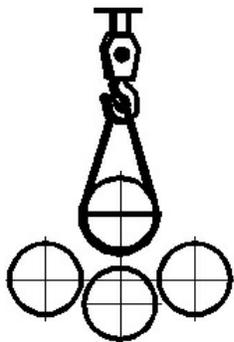
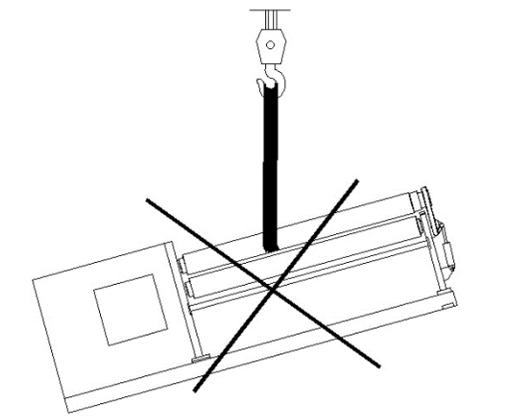
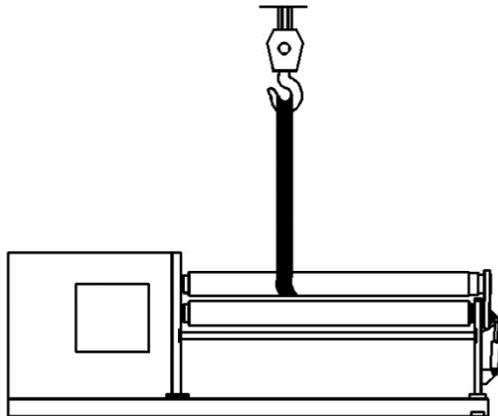


TRANSPORTING AND LIFTING

⚠ CAUTION: 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. Choose a location that will keep the machine free from vibration and dust from other machinery. Keep in mind that having a large clearance area around the machine is important for safe and efficient working conditions.

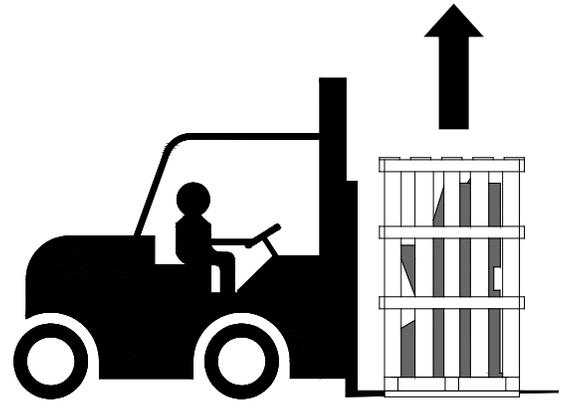
Follow these guidelines when lifting:

- 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.





- 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.



INSTALLATION

IMPORTANT:

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

LEVELING:

- The machine should be sited on a level, concrete floor, suitable to support the entire weight of the machine and work material and in accordance with local building codes. 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.
- Level the machine to within .003"/ft. (.25mm / meter) front to back and left to right.
- The machine installation site should be clean and with little dust, the working temperature range is -5°C~40°C, relative humidity of 55-85%, and altitude lower than 3300 ft. (1000M).
- The work site must be free of flammable or explosive materials to prevent the injury and accident.

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.



- Overall weight of the machine.
- Weight of material being processed.

WORKING CLEARANCES:

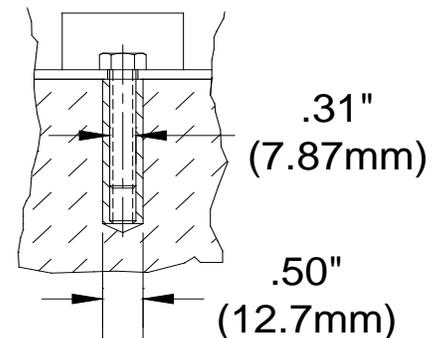
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep 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.
- Is the machine is bolted to the pallet? Before attempting any of the assembly procedures remove all of the loose parts and hardware and unbolt the machine from the pallet.

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.

Anchoring the Machine

- Position the machine on a firm and level concrete floor.
- Maintain a safe operating distance around the machine.
- 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.



Hydraulic Fluid

The hydraulic reservoir was filled to approximately 80% of capacity before leaving Baileigh Industrial. After installation of the machine and before machine startup, bring the oil level up to 90% of capacity. **A shortage of hydraulic oil can cause hydraulic system breakdown and damage to major mechanical parts due to over heating.**



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.

Power cord connection

This machine comes with a power cord available for connection to a power supply. Check that the power cord has not been damaged during transportations and installation of the machine.

Route the power cord to the electrical supply so that the cord does not create a trip hazard. Route the power cord so that it does not get walked or driven over.





CONTROL DESCRIPTIONS AND FUNCTIONS

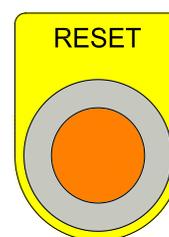
⚠ WARNING: Before opening the door to work on electrical circuits, disconnect and **Lock Out** the electrical supply source to this machine. **FAILURE TO FOLLOW THESE INSTRUCTIONS MAY RESULT IN FATAL OR SERIOUS INJURY.**

Hydraulic Pump Start Button

Turn this switch to start and stop the pump motor. When the pump is “ON” the internal indicator light illuminates the red switch body.

Alarm Reset Button

The machine will stop running after either stop cable is activated, causing the reset light to flash. After clearing the reason for the fault, press the “RESET” button to resume the machine to a working condition.



Back Roll UP / DOWN Buttons

⚠ CAUTION: **DO NOT** bring the back roll tight against the top roll when bending or you could damage the rolls.

With power ON and the hydraulic unit running, the green UP pushbutton will raise the back roll and the yellow DOWN pushbutton will lower the roll.

Footswitch Control

Stepping on the left foot pedal (L) will rotate the rolls and pull the material into the machine. Stepping on the right foot pedal (R) will back the material out of the machine.



time.

Note: **DO NOT** depress both pedals at the same





INSTRUCTIONS FOR POWER ROLL

- **DO NOT** exceed rated capacity on this plate roll. It has been tested at the factory to roll 13ga. (2.27mm) x 48" (1219mm) wide mild steel.
- The Baileigh PR-413 Plate Roll has three 3.5" (89mm) diameter rolls. The two front rolls, one placed vertically above the other are clamping rolls. The bottom roll is manually adjusted for material thicknesses. The rear roll controls the diameter of the finished piece part and is adjusted with a hydraulic torque motor. An encoder and a digital readout are provided to keep the operator informed of its location.

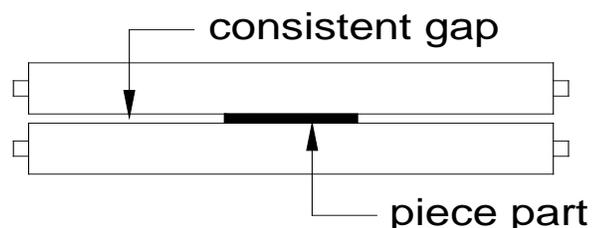
PLATE ROLLING PROCEDURE

Determining Length of Material

LENGTH OF MATERIAL necessary to form the desired size circle is the first consideration in circle forming. To determine the approximate length of material needed use the formula: $C = l \times D$, Where C is the circumference, l is the value of π or 3.1416, and D is the diameter. For example, to find the length of material (C or Circumference) to form a 12" (304.8mm) diameter circle, multiply 3.1416 x 12 (3.1416 x 304.8mm), the result is 37.70" (957.55mm) or the approximate length of material needed. Cut a few pieces of material to this length for test forming. Material may have to be lengthened or shortened depending upon results of the test forming run.

Adjusting the Bottom Front Roll

BOTTOM FRONT ROLL adjustment is necessary to secure the piece part between the top and bottom rolls. To raise or lower the bottom roll, turn the handwheel located on the right side of the machine. Clockwise (cw) for up and counterclockwise (ccw) for down. Insert the material centered between the rolls from the front of the machine and set the rolls so the material fits snugly. Make sure the gap along the full length of the rolls is consistent. Now remove the material from the rolls.





Adjusting the Back Roll

BACK ROLL adjustment is necessary to control the diameter of the circle to be formed. To raise or lower the back roll, use the UP / DOWN pushbuttons located on the pedestal stand. The further you go UP with the back roll, the smaller the radius will be. Lowering the back roll will allow for a larger radius. Because material springback varies with the kind of material being formed, only by test forming several pieces can the correct adjustments be made.

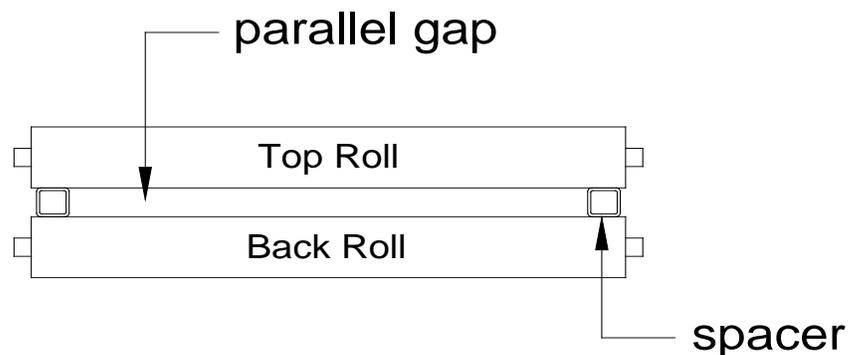


By using the digital readout you can keep track of the gap between the top roll and the back roll when doing multiple piece parts.



Note: *If the rolls are not adjusted exactly parallel, the material will spiral during the rolling process.*

To check if the rolls are parallel, insert a piece of spacer material between the top roll and the back roll. Inch up the back roll slowly until the piece is held. Repeat on the other end of the rolls.





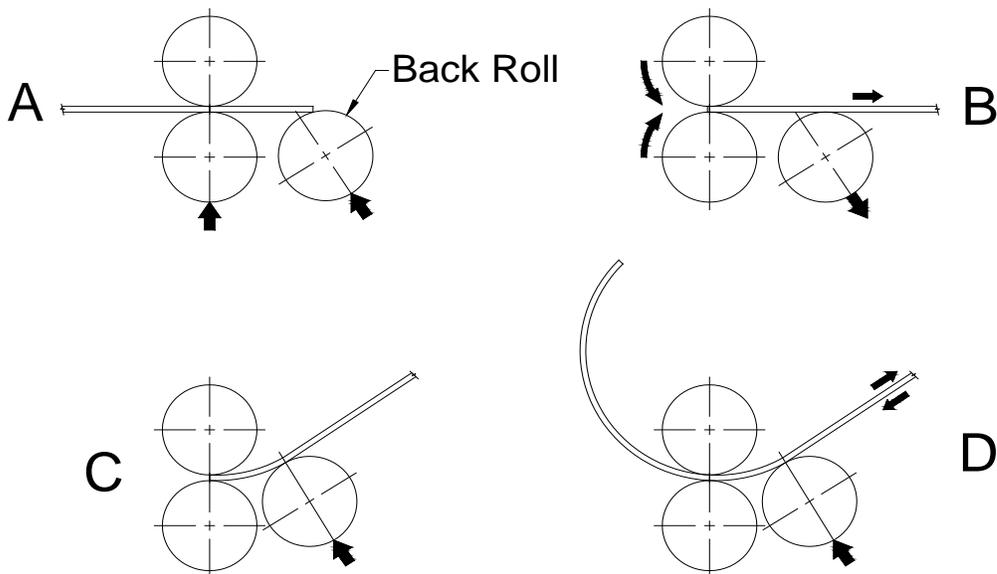
Pre-Bending and Finish Rolling

PRE-BENDING is the operation where the ends of the material are bent to the same radius as that of the finished piece. This principle is used to get the best results in full circle bending.

Before bending, do the following:

- Clean any dust or grease from the material.
- Make sure the edges of the material are free of chips and burrs.
- Check that the material is flat.
- Have a template of the finished diameter to compare with.
- Always work in the center of the rolls.

1. Move the back roll into position as in view "A".
2. Insert the piece part in between the upper roll and the bottom (pinch) roll and lying on the back roll.
3. Adjust the bottom roll up by turning the handwheel clockwise (**cw**) to firmly hold the piece part.
4. Depress the left footswitch so that the piece part travels to the other side as in (fig. B).
5. Move up the back roll a little at a time to start pre-bending the piece part. (fig. C).
6. Alternate pressing the left and right foot pedals to roll the piece part until you reach the required diameter as in (fig. D).





Removing the Rolled Piece Part

⚠ CAUTION: To avoid Operator Injury or Machine Damage NEVER run the machine while the roll is pivoted out.

1. Stop the motor. Either press or pull on the safety stop cable to de-energize the motor, or turn the power switch to the OFF position.
2. Turn the handwheel (A) clockwise (**cw**) to lower the bottom (pinch) roll.
3. Pull out on the lock collar (B) to allow the top roll to pivot outward.
4. When the lock collar is clear of the frame, pivot the top roll out.
5. While the top roll is pivoted out, the limit switch prevents the machine from running.
6. Grasp the formed piece part and slide off of the top roll.
7. Return the roll and lock into position.



Note: Make sure the lock collar is fully seated in the frame.

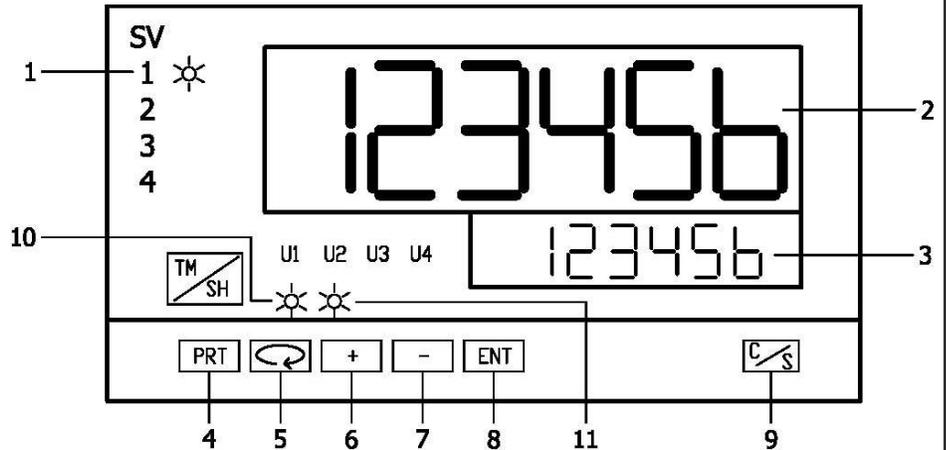




G-B DIGITAL LIMITED MOVING CONTROLLER

Panel Description:

1. Setting lamp.
2. Actual position.
3. Demand position.
4. Setting button.
5. Moving button.
6. Increase value button.
7. Decrease value button.
8. Enter button.
9. Cancels existing value button.
10. Output lamp 1.
11. Output lamp 2.



Setting Way and Description

- Press **PRT** button into actual position setting mode and when setting lamp (SV1) is bright, you could set the actual position.
- Press **↻** button to make the figure flash and change the position of the flash figure from left to right.
- Press **+** button to make the figure flash to increase figure.
- Press **-** button to make the figure flash to decrease figure.
- Press **ENT** button to finish input and out of setting mode.
- Press **ENT** & **PRT** button into parameter setting mode. Please refer to III parameter description and the setting way is referred the above description.
- Press **C/S** button to cancel existing value.
- P.S. If change the setting value and don't Press **ENT** button in 5 seconds, system will input it automatically.



Parameter Description:

PARAMETER	FUNCTION	DESCRIPTION	FACTORY VALUE	X AXIS (Back Gauge)	Y AXIS (Depth & Angle)
1.	Upper limited value	-99999-999999	1000	100.000	001.000
2.	Bottom limited value	-99999-999999	500	000.100	000.100
3.	Decimal	0-5	0	3	3
4.	Ratio value	0.0001-9.9999	1.0000	0.3936	0.3936
5.	Outside message select	0 : RETURN 0. 1 : RETURN VALUE	0	0	0
6.	Outside return time	0 : 0.28 1: 2ms	0	0	0
7.	Panel lock	0 : OPEN 1 : LOCK PRT BUTTON 2 : LOCK C/S BUTTON 3 : ALL LOCK	0	0	0

P.S.1. Press **ENT** & **PRT** button to into parameter setting mode and press to change **PRT** parameter number from 1 to 7.

P.S.2. When setting lock function all parameter is locked.

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.



LUBRICATION AND 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.

Daily Maintenance

- Inspect the power plug and cord.
- Check the foot switch cable for any loosening or damage.
- Check hydraulic hoses and fittings for leakage.
- Keep area around machine clear of debris.
- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.

Weekly Maintenance

- Lubricate threaded components and sliding devices.
- Check fluid level of hydraulic tank.
- Check that all limit switches are secure and adjusted properly.
- Apply rust inhibitive lubricant to all non-painted surfaces.

Hydraulic Oil Specification

- Use hydraulic oil #68 Shell brand or equivalent oil with the same specifications.
- Fill hydraulic oil reservoir to 90% of its capacity.
- DO NOT rely entirely on the oil sight gauge as they can sometimes give an incorrect oil level indication. Remove the oil fill cap and do a visual inspection as well. (BE SURE to wear protective eye gear.)
- A shortage of hydraulic oil will cause hydraulic system / pump breakdown and damage to major mechanical parts due to overheating.
- Change hydraulic oil every 6 months.



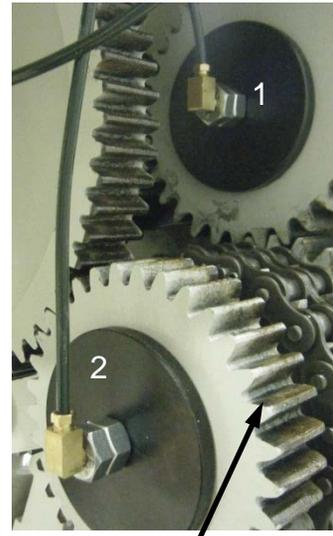
Note: Proper maintenance can increase the life expectancy of your machine.



Locations of Grease Fittings



Add grease to the gear bearings without removing the drive guard.



Keep grease on gear teeth and chain.



Grease the fittings on the bottom and back roller slide blocks. Each roll has two slide blocks and each slide block has an inner and an outer grease fitting.



MACHINE ADJUSTMENTS

Drive Chain



CAUTION: Before removing the guards make sure that the power to the machine has been disconnected.

The drive chain on the Baileigh PR-413 plate roll has been properly adjusted at the factory. Because of the relatively slow rpm of the drive components, there should be minimal wear on the chain.

To tighten the chain:

1. Loosen the (4) carriage bolts holding the motor assembly to the base.
2. Back off the locking nut on the adjusting bolt.
3. Turn the adjusting bolt clockwise (**cw**) to tighten the chain tension. (**DO NOT OVERTIGHTEN**).
4. Re-tighten the lock nut.

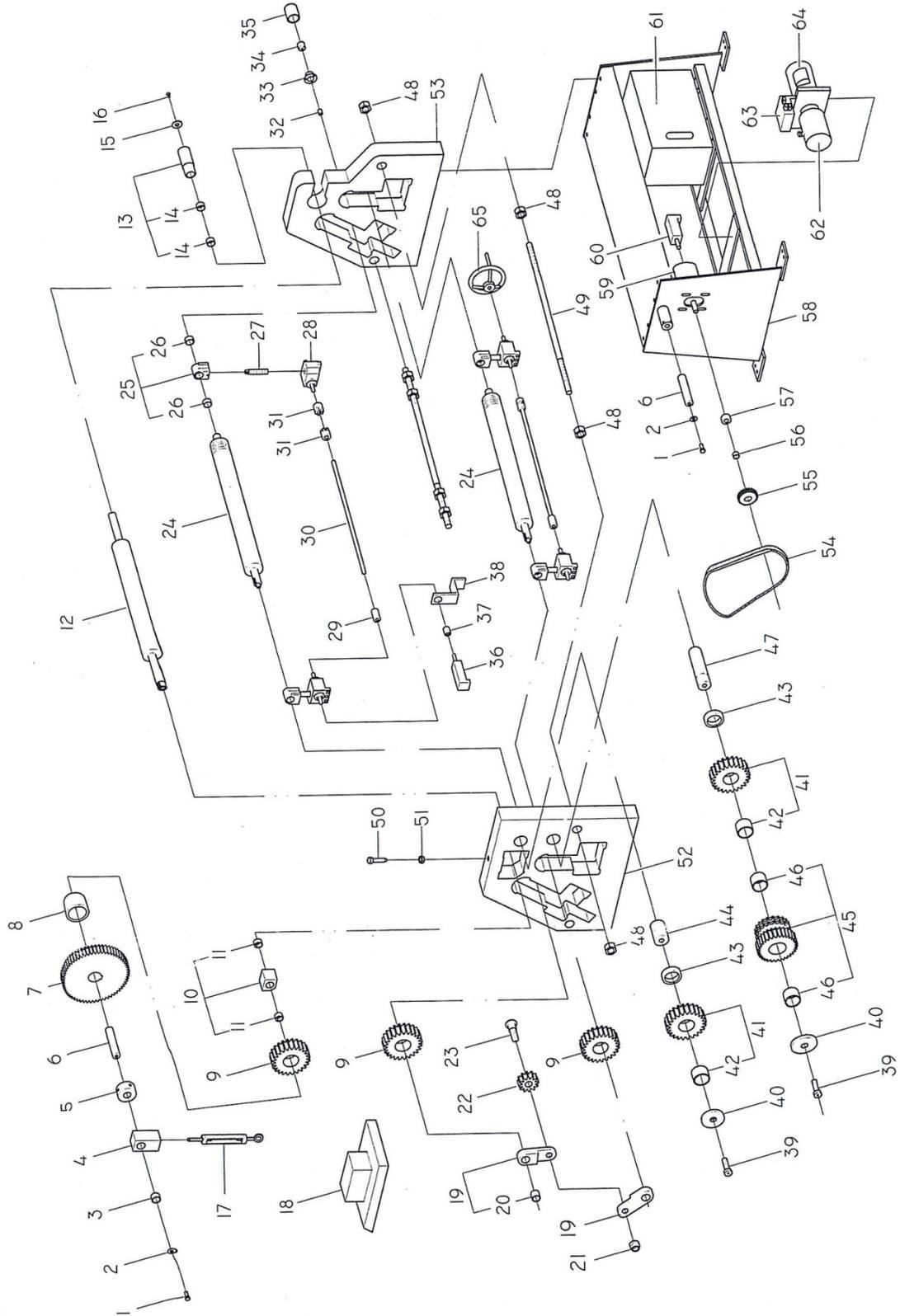
To replace the chain or a sprocket, it may be necessary to block up the motor assembly to release the chain tension.

ALWAYS replace the drive guard before running the machine!!



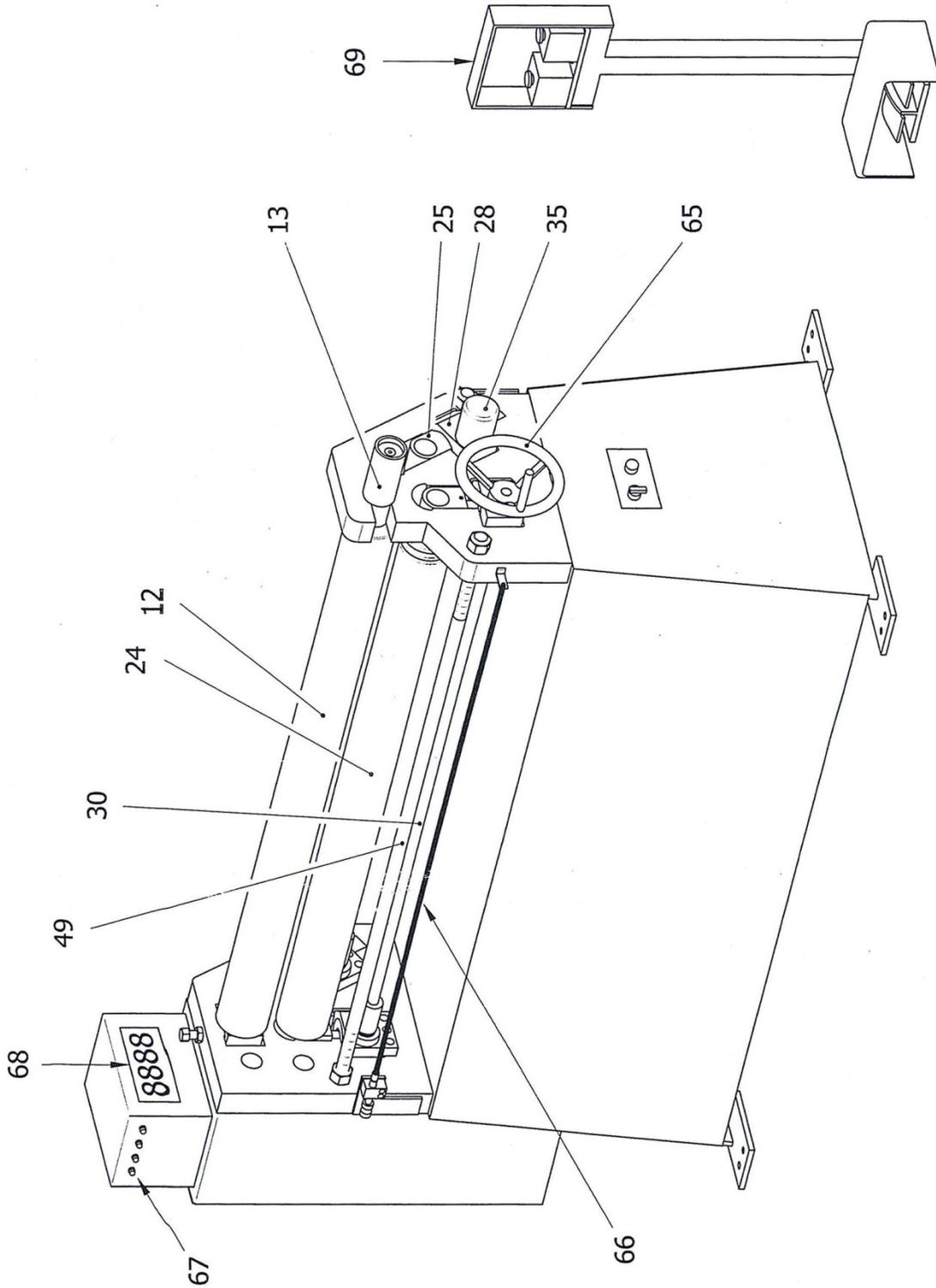


PARTS IDENTIFICATION 1





PARTS IDENTIFICATION 2

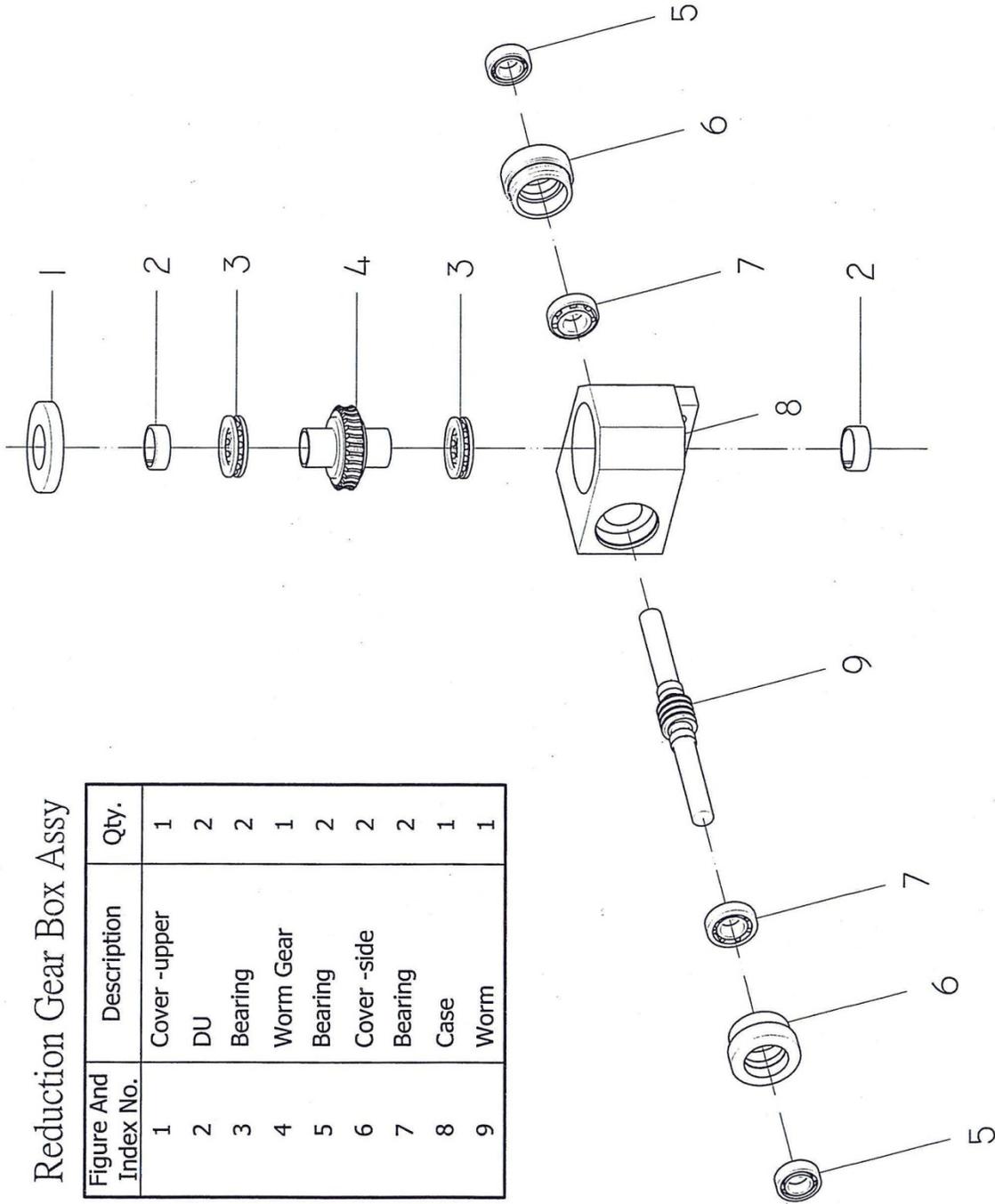




PARTS IDENTIFICATION 3

Reduction Gear Box Assy

Figure And Index No.	Description	Qty.
1	Cover -upper	1
2	DU	2
3	Bearing	2
4	Worm Gear	1
5	Bearing	2
6	Cover -side	2
7	Bearing	2
8	Case	1
9	Worm	1





PARTS LIST

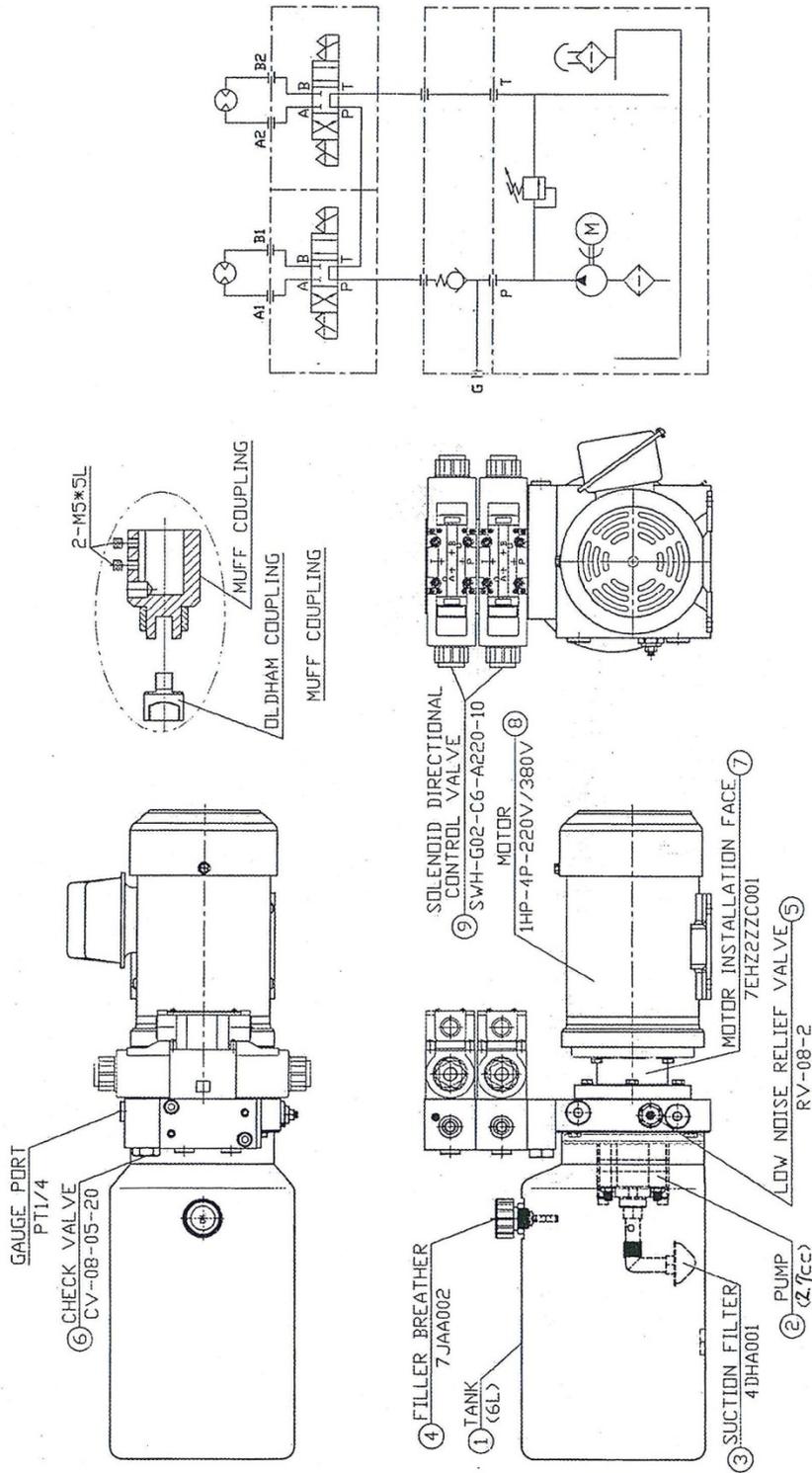
Item	Description	Qty.
1	Screw 5/16" x 3/4"	1
2	Washer	1
3	DU 2030	1
4	Case	1
5	Upper Roller Gear Bushing	1
6	Upper Roller Pull Bar	1
7	Gear	1
8	Upper Roller Gear Bushing	1
9	Gear	1
10	Upper Roller Sliding Block	1
11	DU 3825	2
12	Upper Roller	1
13	Upper Roller Bar	1
14	DU 3825	2
15	Spacer	1
16	Screw 3/8" x 3/4"	1
17	Tighter	1
18	Upper Cover	1
19	Connecting Plate	2
20	DU 2020	2
21	Nut	1
22	Gear	1
23	Connecting Plate Shaft	1
24	Bottom Roller	2
25	Bottom Roller Sliding Block	4
26	DU 3825	8
27	Bolt	4
28	Reduction Gear Box	4
29	Bushing	2
30	Coupler Bar	2
31	Reduction Gear Box Bar	2
32	Encoder Bushing	1
33	Encoder Base	1



34	Encoder	1
35	Encoder Cover	1
36	Hydraulic Motor	1
37	Hydraulic Motor Bushing	1
38	Hydraulic Motor Base	1
39	Screw	2
40	Idle Wheel Spacer	1
41	Idle Wheel	2
42	DU 3830	2
43	Bottom Roller Gear Bushing	1
44	Idle Wheel Short Shaft	1
45	Gear	1
46	DU 3830	2
47	Idle Wheel Long Shaft	1
48	Balance Bar Nut	8
49	Balance Bar	2
50	Upper Roller Sliding Block Fixing Screw	1
51	Nut	1
52	Left Frame	1
53	Right Frame	1
54	Chain	1
55	Sprocket	1
56	DU 2420	1
57	Planetary Reduction Gear Box Bushing	1
58	Machine Base	1
59	Planetary Reduction Gear Box	1
60	Hydraulic Motor	1
61	Electrical Cabinet	1
62	Oil Tank	1
63	Hydraulic Controller	1
64	Motor	1
65	Hand Wheel	1
66	EMS Assembly	2
67	Oil Nipple	4
68	Led Indicator	1
69	Foot Switch	1



HYDRAULICS



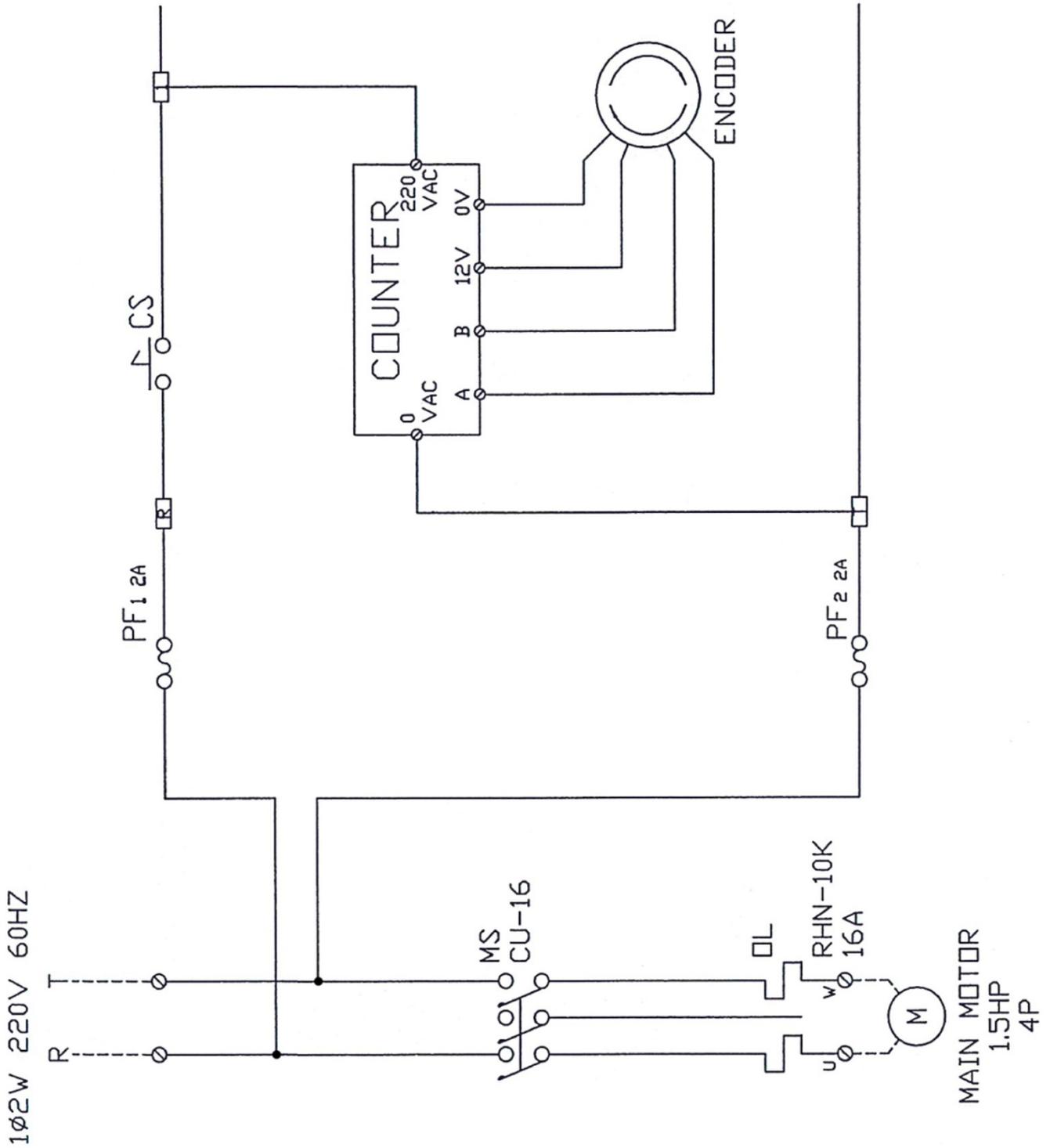
M	S	S1	S2	S3	S4
HYD. MOTOR	▲				
HYD. MOTOR		▲			
ROLL UPPER			▲		
ROLL DOWN				▲	

NO.	PARTS NAME	Q'TY	SPECIFICATION
9	SOLENOID DIRECTIONAL CONTROL VALVE	2	SWH-G02-C6-A220-10
8	MOTOR	1	1HP-4P-220V/380V
7	MOTOR INSTALLATION FACE	1	7EHZ2ZC001
6	CHECK VALVE	1	CV-08-05-20
5	LOW NOISE RELIEF VALVE	1	RV-08-2
4	FILLER BREATHER	1	7JAA002
3	SUCTION FILTER	1	4DHA001
2	PUMP	1	2.7cc/rev
1	TANK	1	6L



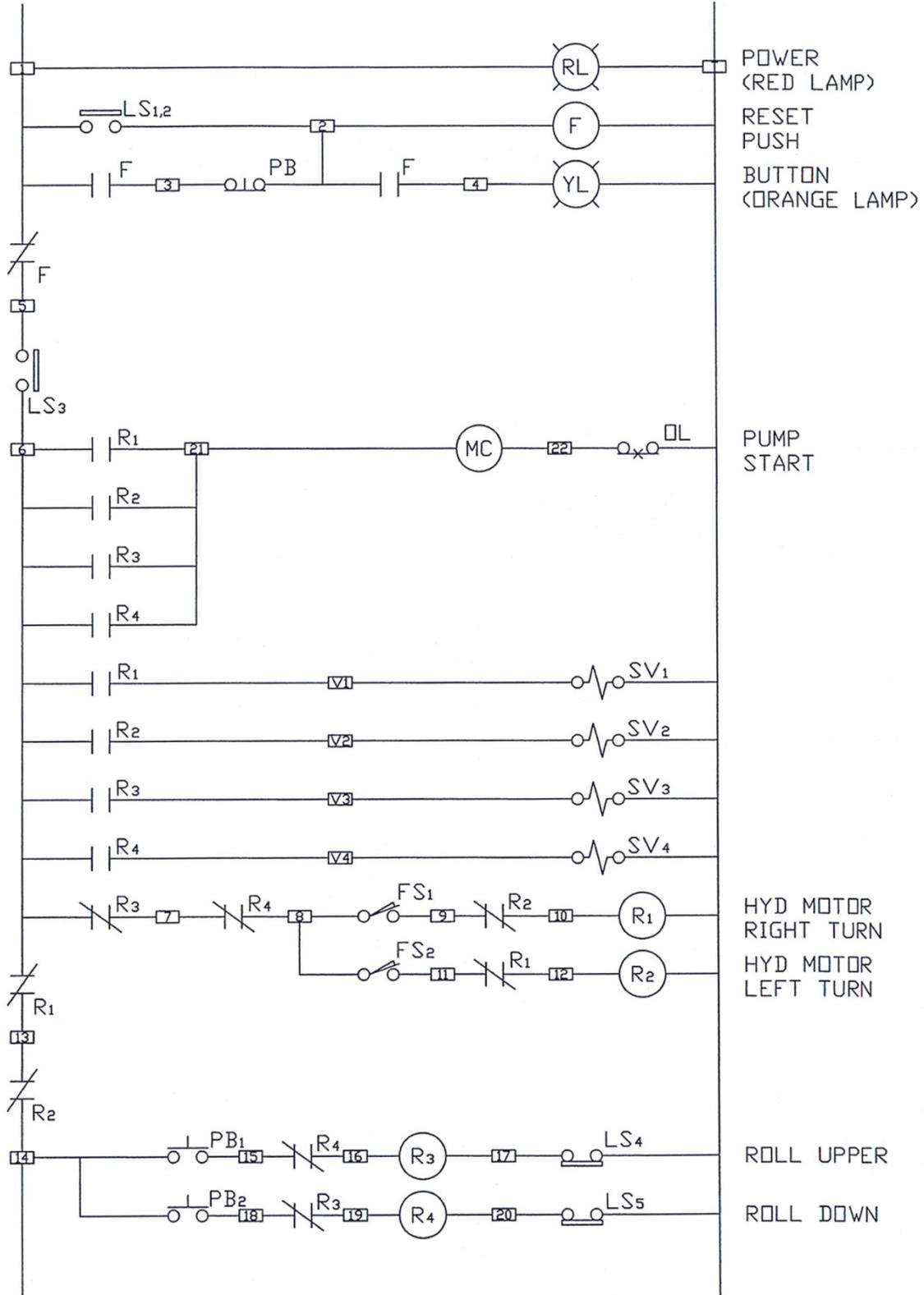


ELECTRICAL SCHEMATIC 1



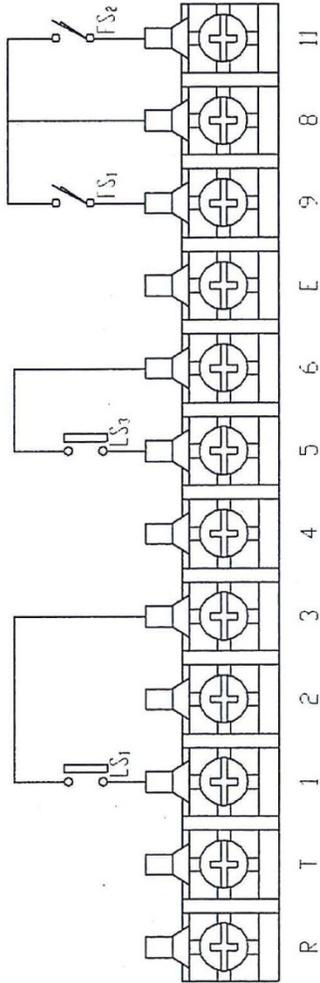


ELECTRICAL SCHEMATIC 2

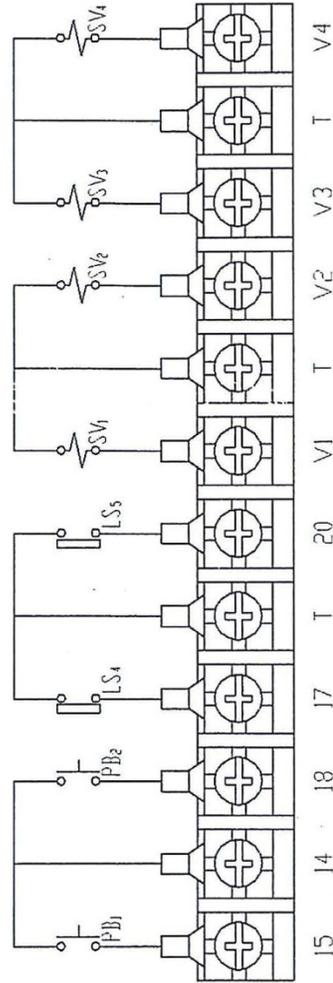




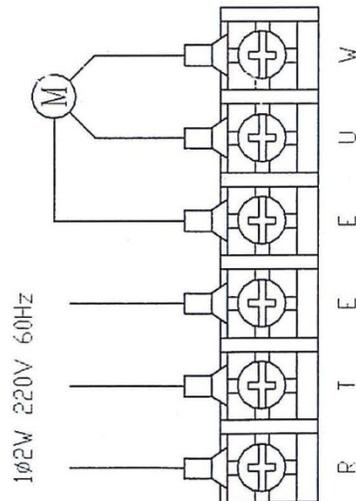
TERMINAL BLOCKS



TB2



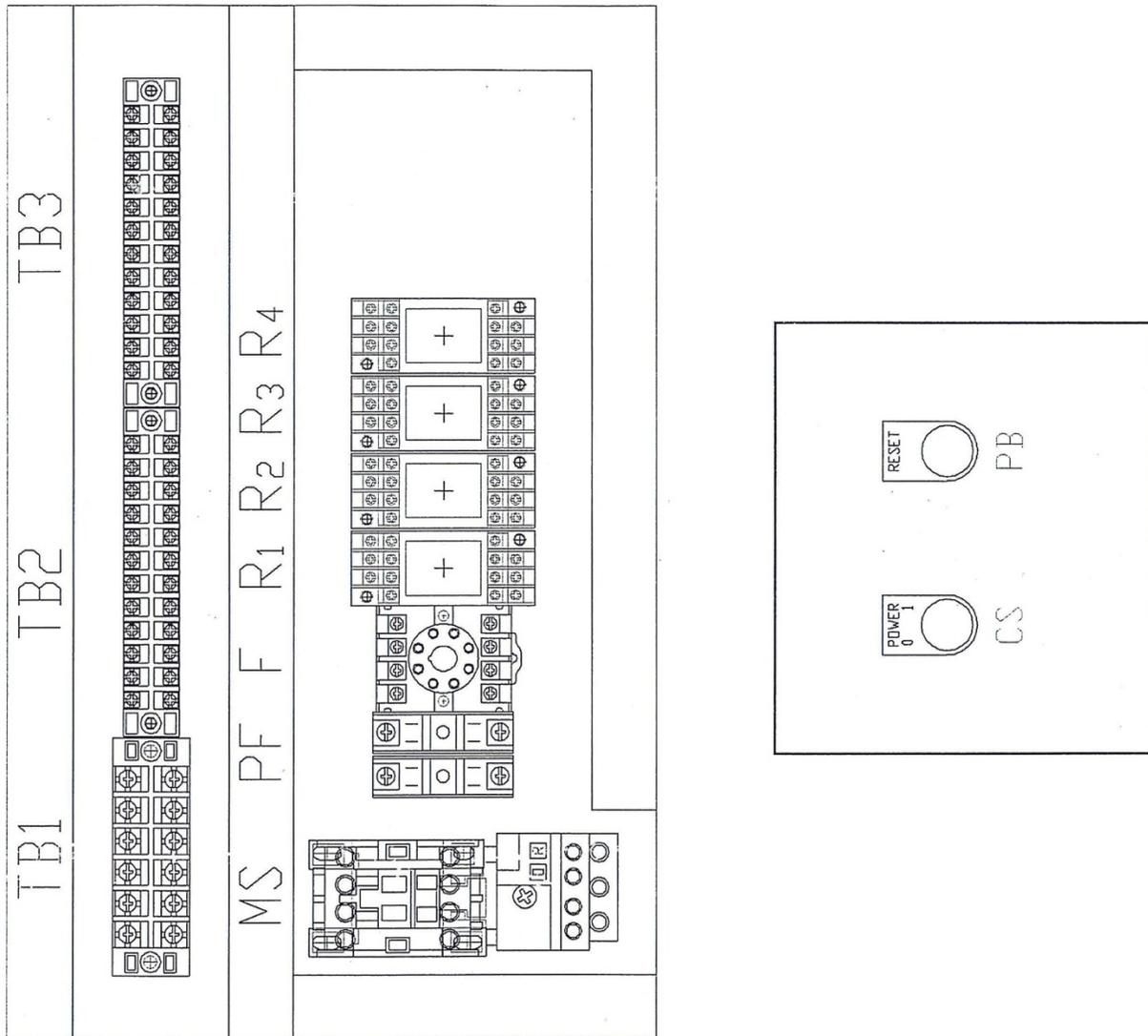
TB3



TB1



ELECTRICAL ENCLOSURE



No.	Model	Name	Specification	Note
1	MS	Magnetic Switch	HUO-16 220VAC 16A	MC, OL
2	PF	Fuses	10 x 38mm 2A	PF1, PF2
3	F	Flicker	H3-FK-M3 220V	
4	R1 – R4	Power Relay	MY-4 AC 220V	
5	TB1	Trans Bus	6P 30A	
6	TB2, TB3	Trans Bus	12P 15A	
7	CS, RL	Select Switch	30Ø 1A Red 220V	
8	PB3, YL	Push Button	30Ø 1B Yellow 220V	



NOTES



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