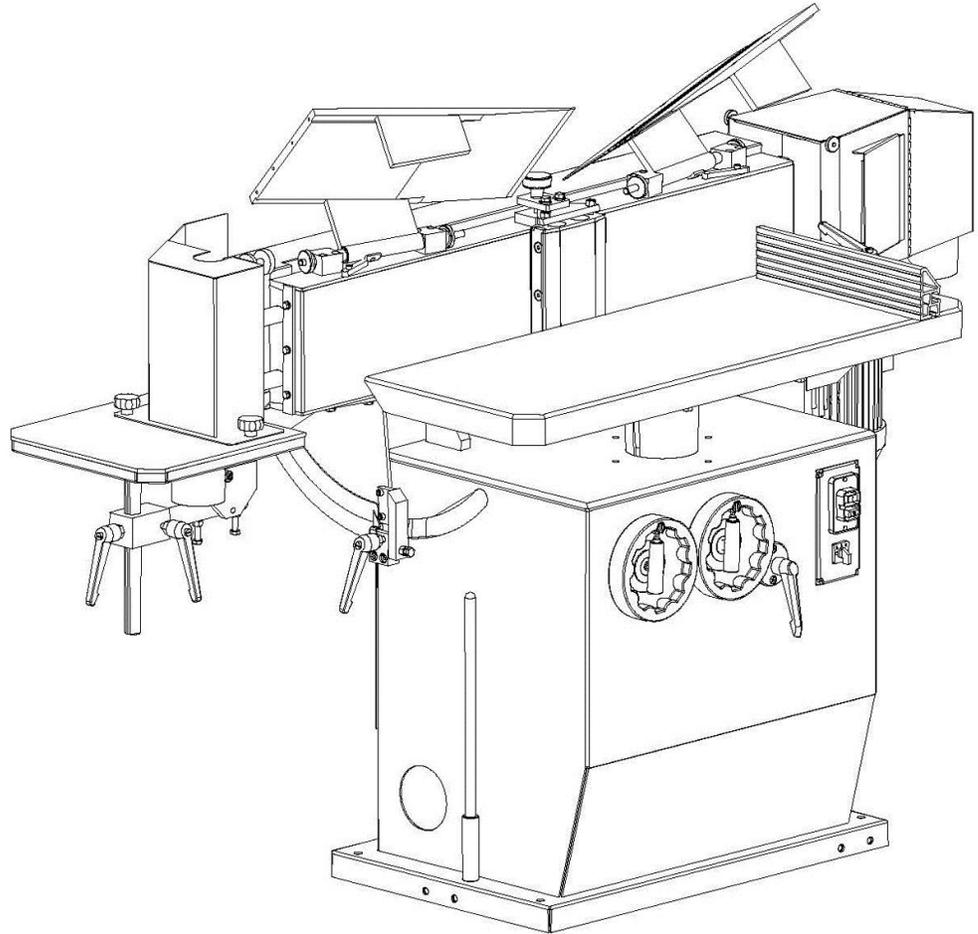




OPERATOR'S MANUAL



OSCILLATING EDGE BELT SANDER MODEL: ES-8120

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

Table of Contents

THANK YOU & WARRANTY	1
INTRODUCTION	3
GENERAL NOTES.....	3
SAFETY INSTRUCTIONS	4
SAFETY PRECAUTIONS	6
SPECIFICATIONS	9
TECHNICAL SUPPORT	9
UNPACKING AND CLEANING	10
Cleaning	10
GETTING TO KNOW YOUR MACHINE	11
INSTALLATION	11
Securing the Base	11
ELECTRICAL.....	12
Extension Cord Safety.....	13
WIRING DIAGRAM.....	13
OPERATION.....	14
INSTALL SANDING BELT.....	15
HEIGHT ADJUSTMENT OF TABLE	15
SIDE ADJUSTMENT OF TABLE.....	15
TILTING SANDING UNIT.....	15
EDGE SANDING (COATED EDGES).....	16
PERIODIC MAINTENANCE.....	16
EXPLODED PARTS DIAGRAM - 1.....	17
Exploded Parts List - 1	18
EXPLODED PARTS DIAGRAM - 2.....	19
Exploded Parts List - 2	20
EXPLODED PARTS DIAGRAM - 3.....	21
Exploded Parts List - 3	22
EXPLODED PARTS DIAGRAM - 4.....	23
Exploded Parts List - 4	24
EXPLODED PARTS DIAGRAM - 5.....	25
Exploded Parts List - 5	25
EXPLODED PARTS DIAGRAM - 6.....	26
Exploded Parts List - 6	27
EXPLODED PARTS DIAGRAM - 7.....	28
Exploded Parts List - 7	28
EXPLODED PARTS DIAGRAM - 8.....	29
Exploded Parts List - 8	30
EXPLODED PARTS DIAGRAM - 9.....	31
Exploded Parts List - 9	31
EXPLODED PARTS DIAGRAM - 10.....	32
Exploded Parts List - 10	32



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.



DANGER



WARNING



CAUTION

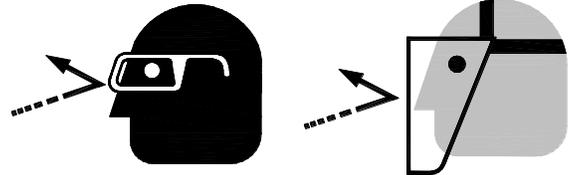


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



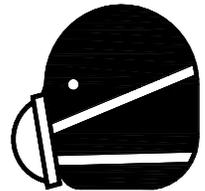
PROTECT EYES

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



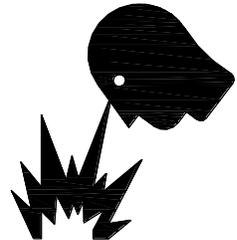
DUST HAZARD

Wear appropriate dust mask. Dust created while using machinery can cause cancer, birth defects, and long term respiratory damage. Be aware of the dust hazards associated with all types of materials.



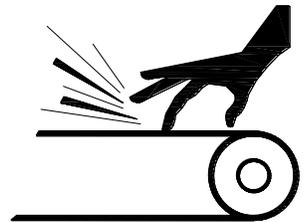
DUST PARTICLES AND IGNITION SOURCES

DO NOT operate the edge sander in areas where explosion risks are high. Such areas include locations near pilot lights, open flames, or other ignition sources.



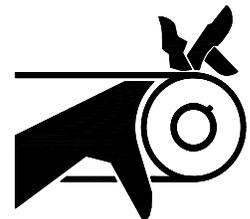
MOVING BELT ABRASIONS

DO NOT place hands or fingers near, or in contact with sanding belt during operation.



MOVING BELTS CAN CRUSH AND DISMEMBER

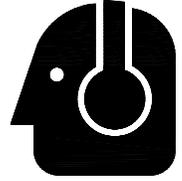
DO NOT allow fingers to get pinched between belt and belt rollers. This may pull the operator's hand into the machine causing serious personal injury. **DO NOT operate without guards in place.**





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)



SAFETY PRECAUTIONS



Wood 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, push sticks, hold-downs, feather boards, goggles, 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. **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 should 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.



SAFETY PRECAUTIONS (cont.)



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. **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.
8. **Use eye and ear protection.** Always wear ISO approved impact safety goggles
9. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
10. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
11. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for binding of moving parts that may affect proper machine operation.
12. **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.
13. **DO NOT** bypass or defeat any safety interlock systems.
14. Know the location of the **ON - OFF** switch and the "**E**"- **STOP** button.
15. Keep visitors a safe distance from the work area.
16. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
17. **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.
18. **DO NOT** touch live electrical components or parts.
19. **Be Sure** all equipment is properly installed and grounded according to national, state, and local codes. If machine is equipped with a three-prong plug, it should be plugged into a three-hole electrical receptacle. If an adapter is used to accommodate a two-prong receptacle, the adapter plug must be attached to a known ground. Never remove the third prong.
20. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**



SAFETY PRECAUTIONS (cont.)



21. **Maintain machine in top condition.** Keep clean for best and safest performance. Follow instructions for lubricating and changing accessories.
22. **Reduce the risk of unintentional starting.** Make sure switch is in “OFF” position before plugging in power cord.
23. **Never leave machine running unattended. TURN POWER OFF.** Don't leave machine until it comes to a complete stop.
24. **Make sure machine is disconnected from power supply** while motor is being mounted, connected or reconnected.
25. **Minimum Stock Dimensions. DO NOT** sand material thinner than 1/16” (1.5mm), narrower than 1/8” (3mm), or shorter than 8” (203mm).
26. **Changing Sanding Belt. DO NOT** operate the sander if the belt is damaged or badly worn. Replace at once.
27. **Inspect Piece Part.** Always inspect piece part for staples, nails, knots, or other imperfections that could become projectiles causing personal injury.
28. **Sand Appropriate Material.** Only use this sander for natural wood stock. It is **NOT** recommended to sand particle board, plastics, laminates, medium-density fibre board (MDF), metal, glass, ceramics, or products containing asbestos or lead paint. Some of these materials contain hazardous dust and will shorten the life span of the belt.
29. **Correctly Feeding The Stock.** Grasp the piece part firmly with both hands and ease into the belt with light pressure. **NEVER** force the piece part into the belt. **DO NOT** sand tapered or pointed stock with the point facing into the feed direction of the belt. **NEVER** sand more than one piece of stock at a time.
30. **Warning:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use a wood dust collection system whenever possible.



In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button.



SPECIFICATIONS

Work Table	37.75" x 13.75" (960 x 350mm)
Work Table Height Adjustment	8.25" (210mm)
Length Of Sanding belt	118.11" (3000mm)
Width Of Sanding belt	5.9" (150mm)
Rear Wall Of Sanding belt	41.3" x 7.8" (1050 x 200mm)
Sanding Unit Tilttable	90° - 45°
Belt Speed	65.5 ft/sec. (20m/sec)
Oscillation Motor	0.34hp (0.25kw)
Oscillation Way	0.78" (20mm)
Motor	4hp (3kw) 220V / 60hz
Speed	3400 rpm
Dust Collector Attachment Diameter	4.75" / 3.14" (120 / 80mm)
Deminsions	76" x 31.5" x 41.14" (1930 x 800 x 1045mm)
Weight	640 lbs. (290kgs)

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: All illustrations are representative 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 CLEANING

Carefully unpack the machine and all loose items from the shipping carton(s). Remove the protective coating from all unpainted surfaces. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline or lacquer thinner for this purpose). After cleaning, cover the unpainted surfaces with a good quality household floor paste wax.

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.





GETTING TO KNOW YOUR MACHINE

The edge sander is constructed to sand wood, wood similar, or wood coated materials. On the machine stand a 45° tiltable sanding unit is mounted. The sanding rest mounted on the machine stand can be adjusted to height and to both sides. The sanding unit is equipped with a self-tightening sanding belt tensioner, 2 adjustable flap-stops and a height adjustable rest on the left side at the driven roller.

INSTALLATION

IMPORTANT:

- Overall weight of the machine.
- Weight of material being processed.
- 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 are safely supported and will not extend into any aisles.

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

- 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.

Securing the Base

⚠ WARNING: Before operating; make sure it is firm level footing to the floor. If it tips over on you, it could cause severe injury or death.

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.

1. Four rubber pads are furnished with the machine, which are to be placed under the machine at the Four Corners.
2. Adjust the leveling pads as required for leveling.



ELECTRICAL

⚠ 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.

Connections

- A separate electrical circuit should be used for your tools. If an extension cord is used, use only 3-wire extension cords, which have grounding type plugs and receptacles, which accept the tool's plug. 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.
- Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

⚠ 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.



- Use only 3-wire extension cords that have grounding type plugs and receptacles that accept the tool's plug.
- Repair or replace damaged or worn cord immediately.

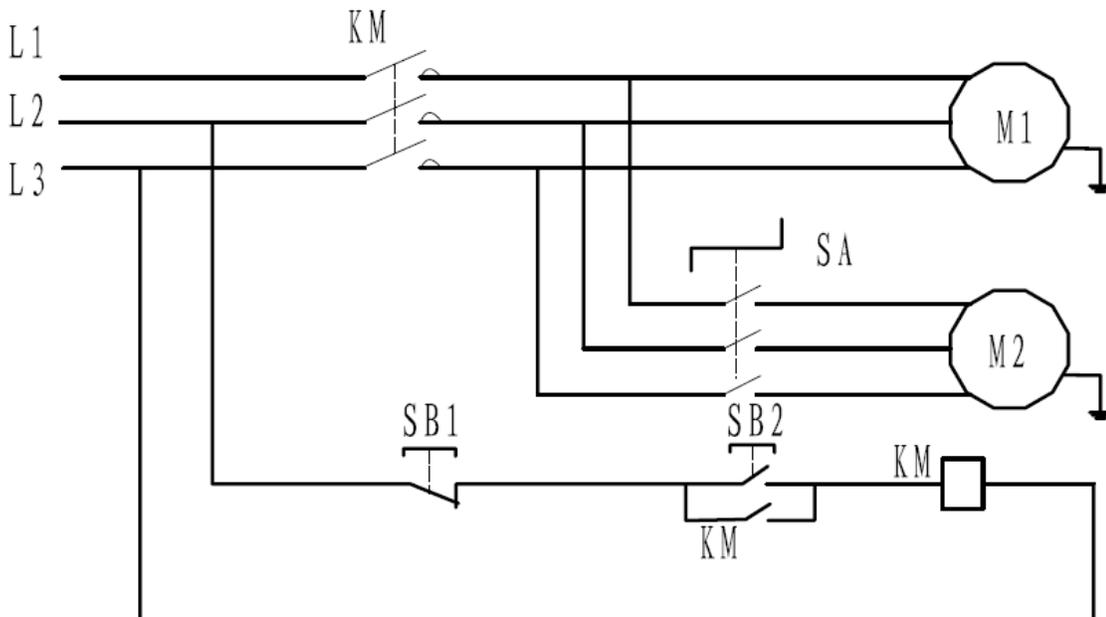
Extension Cord Safety

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.

WIRING DIAGRAM

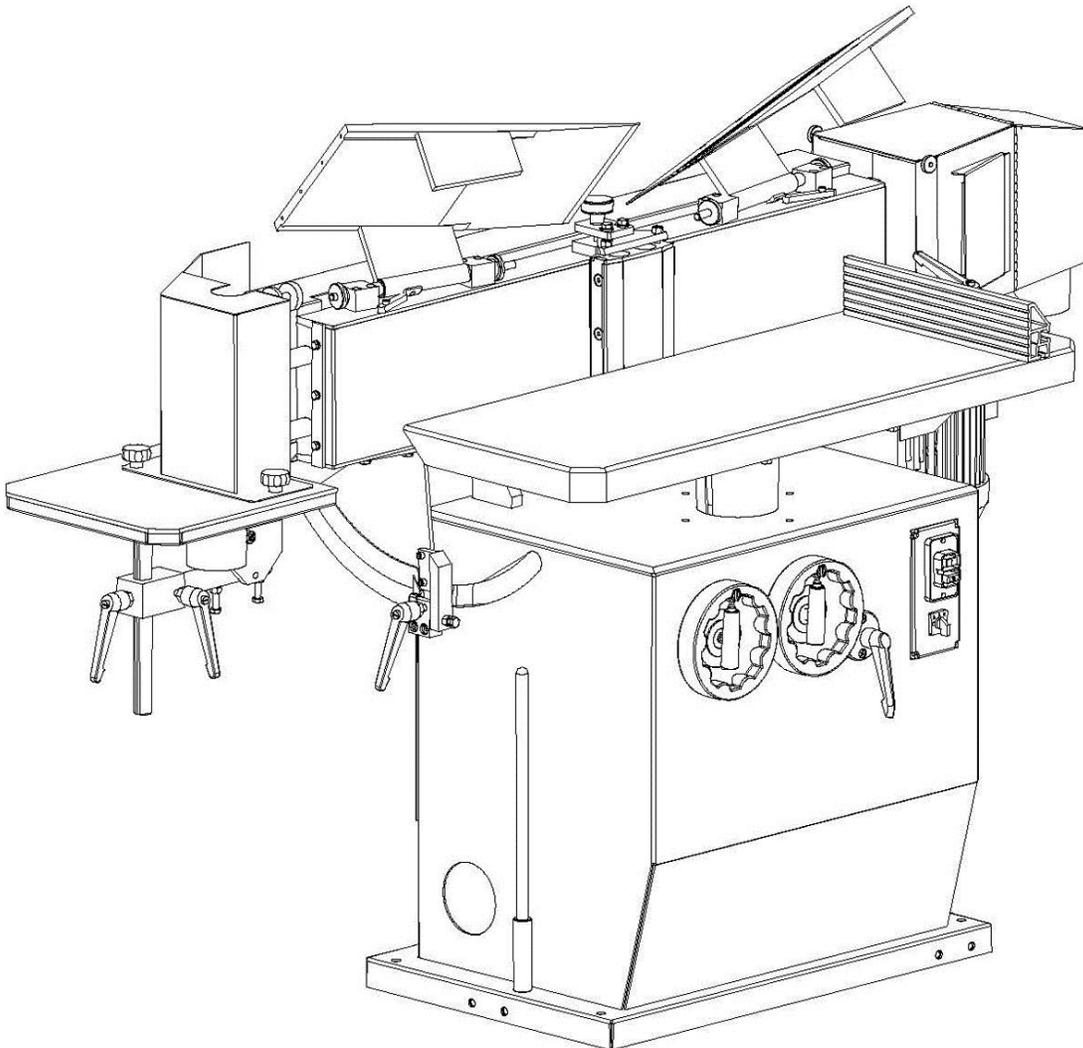




OPERATION

⚠ CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from , chips, dust, burrs, and slivers.

1. Connect machine to power supply.
2. Verify area around machine and belt are clear and not in contact with any material.
3. Push green button to start the machine.
4. Place the material on the table and using a firm grip, bring the material into contact with the belt in a smooth steady fashion. Use the miter gauge as needed to assist in securing the material while sanding.
5. To switch off the machine push red knob.





INSTALL SANDING BELT

1. Disconnect the machine from power source.
2. Open or take off sanding belt covers.
3. Loosen sanding belt tensioner.
4. Put on new sanding belt (check direction as marked by arrows on the paperback), tighten slowly.

⚠ WARNING: Never operate the belt sander with any covers removed missing or damaged. It could cause severe injury or death.

5. Connect power and turn the machine ON to check run and position of sanding belt.
6. Sand belt should run in the middle of left roller, adjust by set-screw on top of left roller if necessary.
7. Close sanding belt covers.

HEIGHT ADJUSTMENT OF TABLE

1. Loosen clamp screw left beside belt wheel.
2. Adjust table height as needed by turning the right hand wheel.
3. Tighten clamp screw.

SIDE ADJUSTMENT OF TABLE

1. Loosen clamp screw on the left side underneath of table.
2. Adjust table to position needed and clamp with screw

TILTING SANDING UNIT

1. Loosen clamp screw on the left side of machine stand.
2. Adjust angle needed (from 90° - 45°) by turning the left hand wheel.
3. Tighten clamp screw.



EDGE SANDING (COATED EDGES)

1. Fix rest in very outside position.
2. Loosen sanding belt tightening.
3. Mount sanding device with rollers between sanding belt and rest and fix with screw.
4. Tighten sanding belt slowly.
5. Turn on the machine and check run of sanding belt, adjust if necessary as described before.
6. Adjust rest to height needed and as near as possible to sanding belt.
7. Fix with clamp screw.
8. Adjust both sanding stops to the sanding depth needed by turning the screw on top of stop.

PERIODIC MAINTENANCE

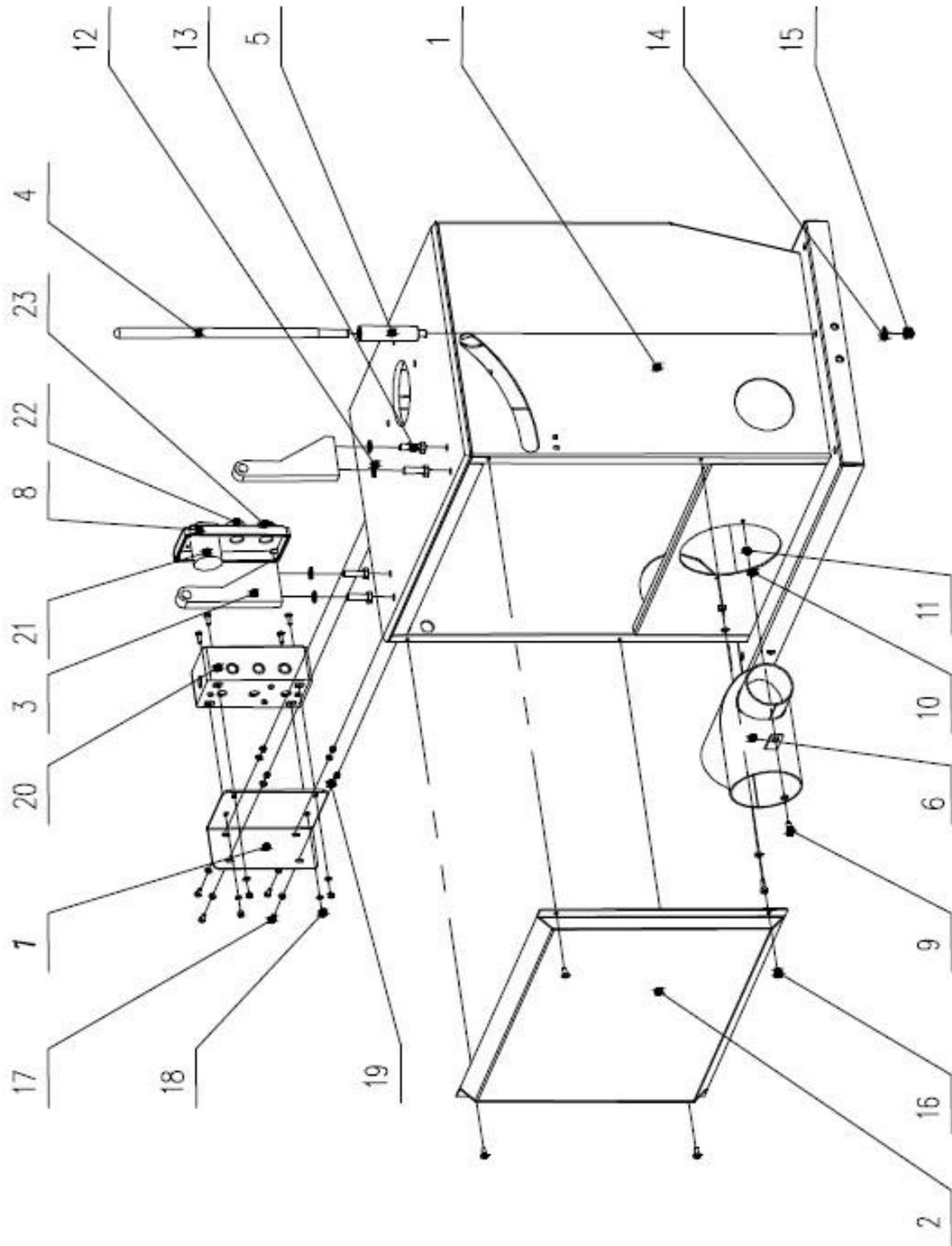
This machine is designed and manufactured for easy operation and maintenance. The proper amount of good quality grease is packed in all ball bearings, so not necessary lubrication.

The auxiliary wheel and the drive wheel are made by rubber material, after the machine has been operated for long period of time the auxiliary wheel and drive wheel may be wear. If this happens the auxiliary wheel and drive wheel needs to be replaced. When the auxiliary wheel is wear, we recommend replace all auxiliary wheel units.

- The machine requires thorough cleaning once a day.
- Check of the auxiliary wheel and drive wheel.
- Check of screws and bolts.



EXPLODED PARTS DIAGRAM - 1





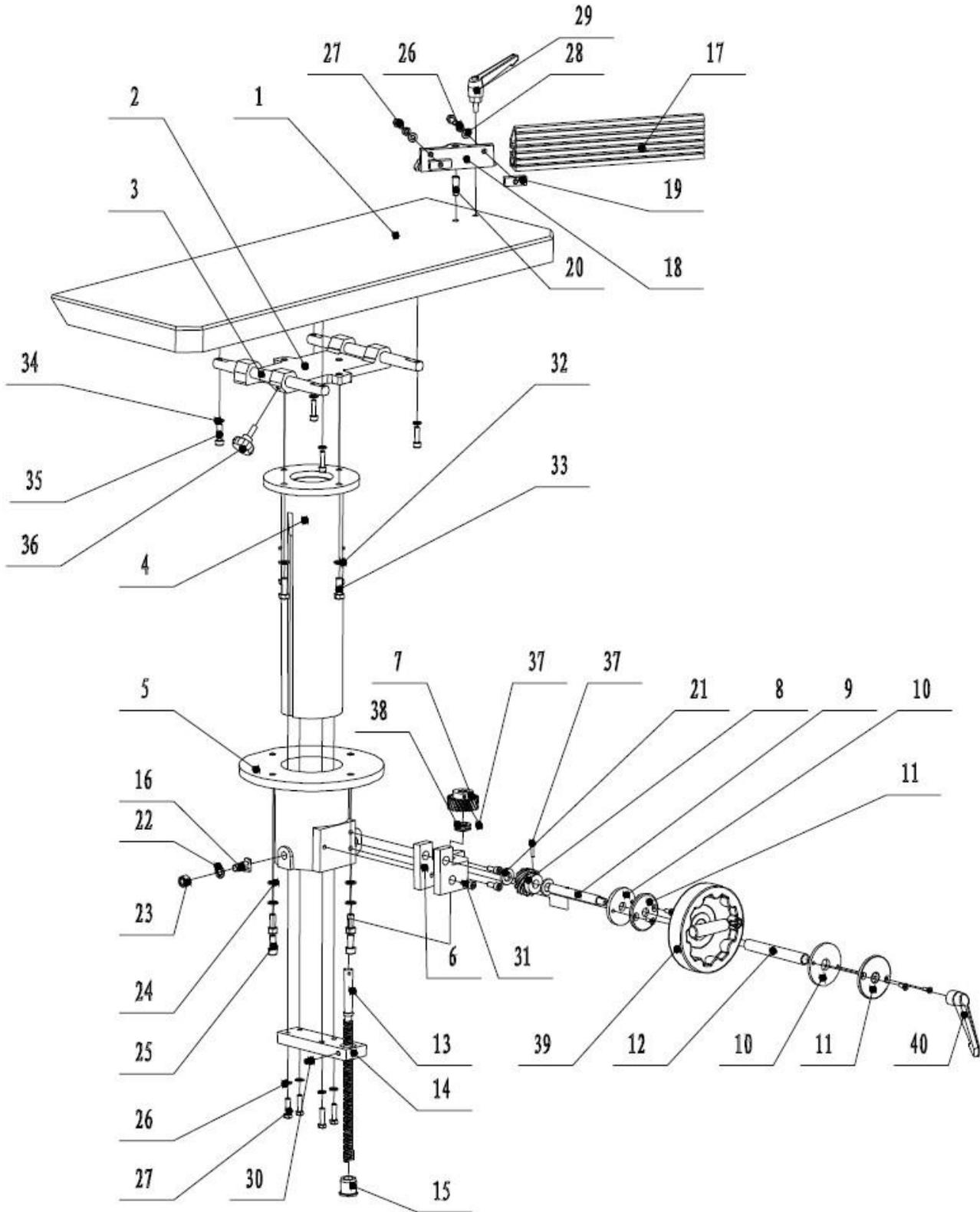
Exploded Parts List - 1

Item	Description	Qty.
1	Base	1
2	Base Cover	1
3	Supporting Base	2
4	Extension Handle	1
5	Extension Handle Sleeve	1
6	Connector	1
7	Switch Plate	1
8	Switch Cover	1
9	Socket Hex Cap Screw M6 x 16	2
10	Washer 6	4
11	Hex Nut M6	2
12	Spring Washer M10	4

Item	Description	Qty.
13	Hex Cap Screw M10 x 35	4
14	Spring Washer M10	1
15	Hex Nut M10	1
16	Hp Screw M6 x 12	4
17	Hp Screw M5 x 16	8
18	Hex Nut M5	8
19	Washer 5	12
20	Switch Box	1
21	Turning Switch	1
22	Button HY57C	1
23	Button HY57B	1



EXPLODED PARTS DIAGRAM - 2





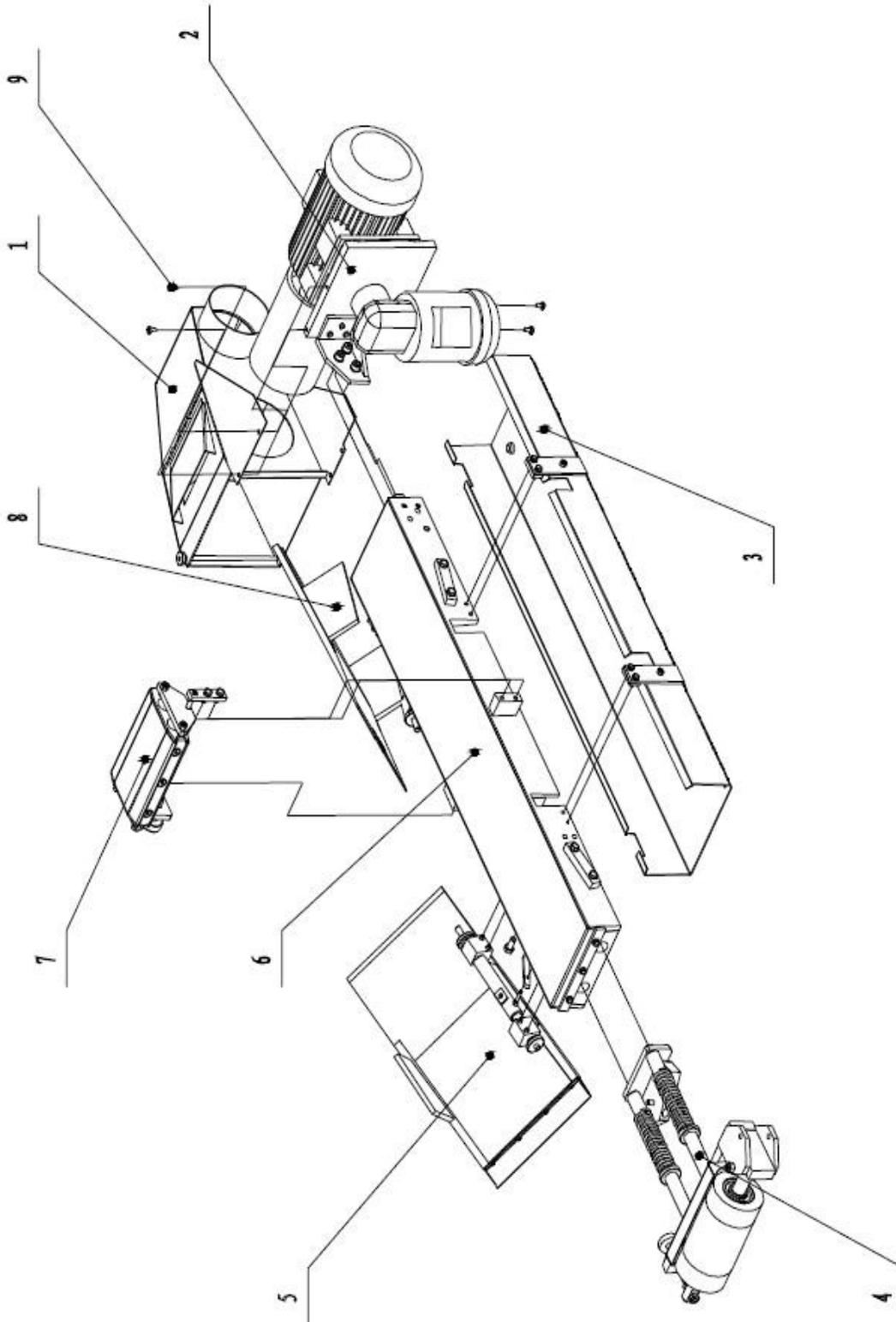
Exploded Parts List - 2

Item	Description	Qty.
1	Table	1
2	Sliding Base	1
3	Sliding Axle	2
4	Lifting Sleeve	1
5	Fixing Base	1
6	Gear Base	1
7	Big Bevel Wheel	1
8	Small Bevel Wheel	1
9	Gear Axle	1
10	Inner Plate	2
11	Outer Plate	2
12	Locking Pole	1
13	Lifting Gear Bar	1
14	Gear Bar Base	1
15	Gear Nut	1
16	Guiding Screw	1
17	Guiding Ruler	1
18	Angle Ruler	1
19	Square Nut	2
20	Pin	1

Item	Description	Qty.
21	Washer	2
22	Spring Washer M12	1
23	Nut M12	1
24	Spring Washer M10	4
25	Socket Hex Cap Screw M10 x 25	4
26	Spring Washer M8	4
27	Hex Cap Screw M8 x 25	4
28	Washer M8	2
29	Handle B-M8 x 30	1
30	Socket Hex Cap Screw M8 x 20	1
31	Socket Hex Cap Screw M8 x 20	3
32	Spring Washer M10	4
33	Hex Cap Screw M10 x 30	4
34	Spring Washer M8	4
35	Socket Hex Cap Screw M8 x 30	4
36	Locking Handle(Big) M8 x 25	1
37	Elasticity Pin 5 x 30	2
38	Ball Bearing 51102	1
39	Handle 12 x 160	1



EXPLODED PARTS DIAGRAM - 3





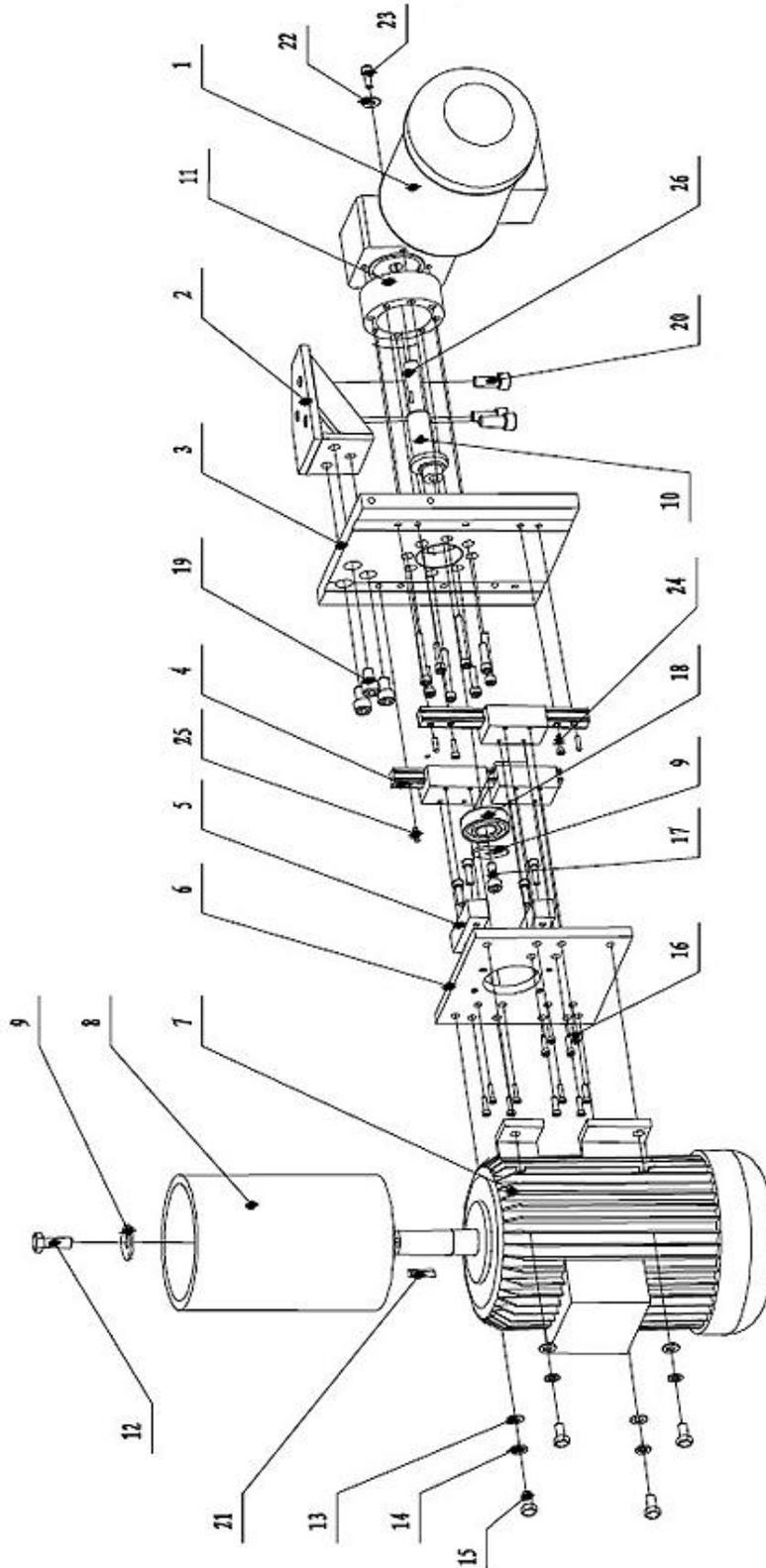
Exploded Parts List - 3

NO	Description	Q'TY
1	Dust Collecting System	1
2	Motor Pulley System	1
3	Protecting Cover System	1
4	Driver Pulley System	1
5	Left Table System	1

NO	Description	Q'TY
6	Graphite Table System	1
7	Extension Graphite Table System	1
8	Right Table System	1
9	HP Screw M6 x 10	4



EXPLODED PARTS DIAGRAM - 4





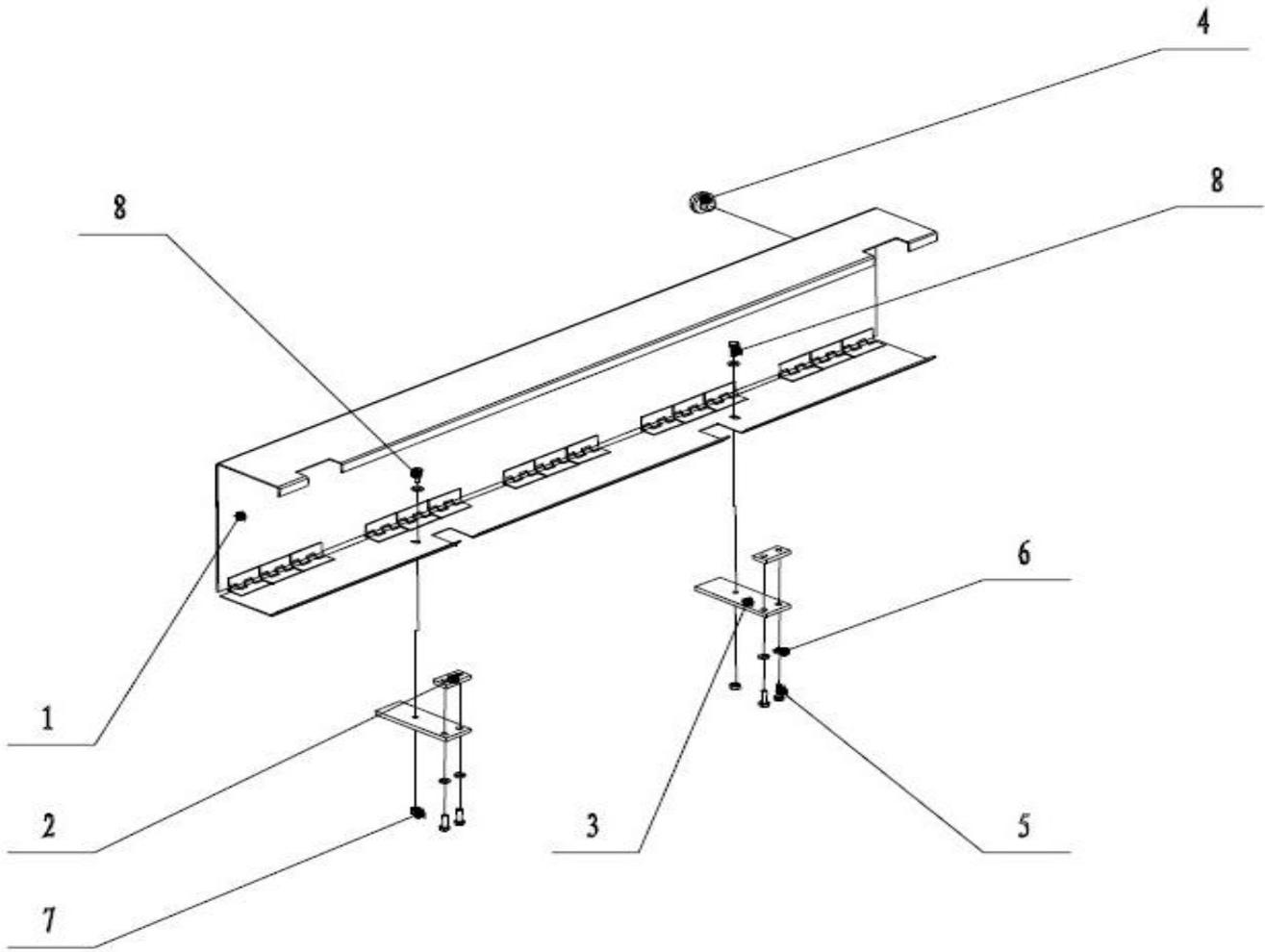
Exploded Parts List - 4

Item	Description	Qty.
1	Minitype Reducer	1
2	Side Fixing Frame	1
3	Guiding Fixing Frame	1
4	Guiding Block	2
5	Block	2
6	Motor Fixing Plate	1
7	Motor	1
8	Motor Pulley	1
9	Washer	2
10	Eccentric Axle	1
11	Flange Plate	1
12	Hex Cap Screw M8 x 30	1
13	Washer M8	4

Item	Description	Qty.
14	Spring Washer M8	4
15	Hex Cap Screw M8 x 20	4
16	Socket Hex Cap Screw M4 x 16	12
17	Socket Hex Cap Screw M8 x 20	1
18	Bearing 6204-2RZZ/Z1	1
19	Socket Hex Cap Screw M10 x 20	3
20	Socket Hex Cap Screw M10 x 25	3
21	Key 6 x 30	1
22	Washer M6	1
23	Socket Hex Cap Screw M6 x 16	1
24	Socket Hex Cap Screw M4 x 20	6
25	Elasticity Pin 5 x 20	4
26	A Pin 5 x 15	2



EXPLODED PARTS DIAGRAM - 5



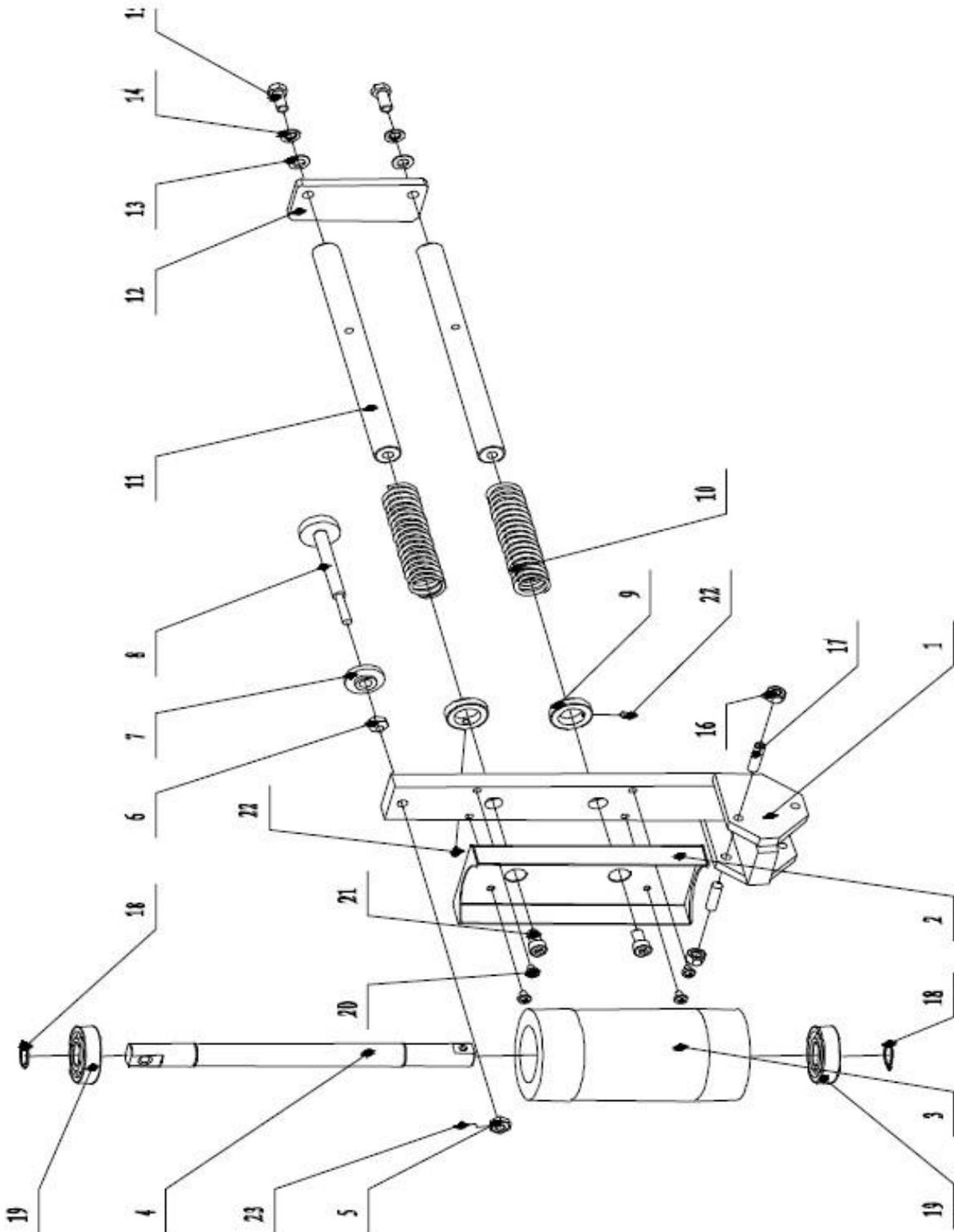
Exploded Parts List - 5

Item	Description	Qty.
1	Protecting Cover	1
2	Plate	2
3	Connecting Plate	2
4	Rubber Pad	1

Item	Description	Qty.
4	Hex Cap Screw M6 x 20	4
5	Washer M6	6
6	Hex Nut M6	4
7	Hex Cap Screw M6 x 16	2



EXPLODED PARTS DIAGRAM - 6





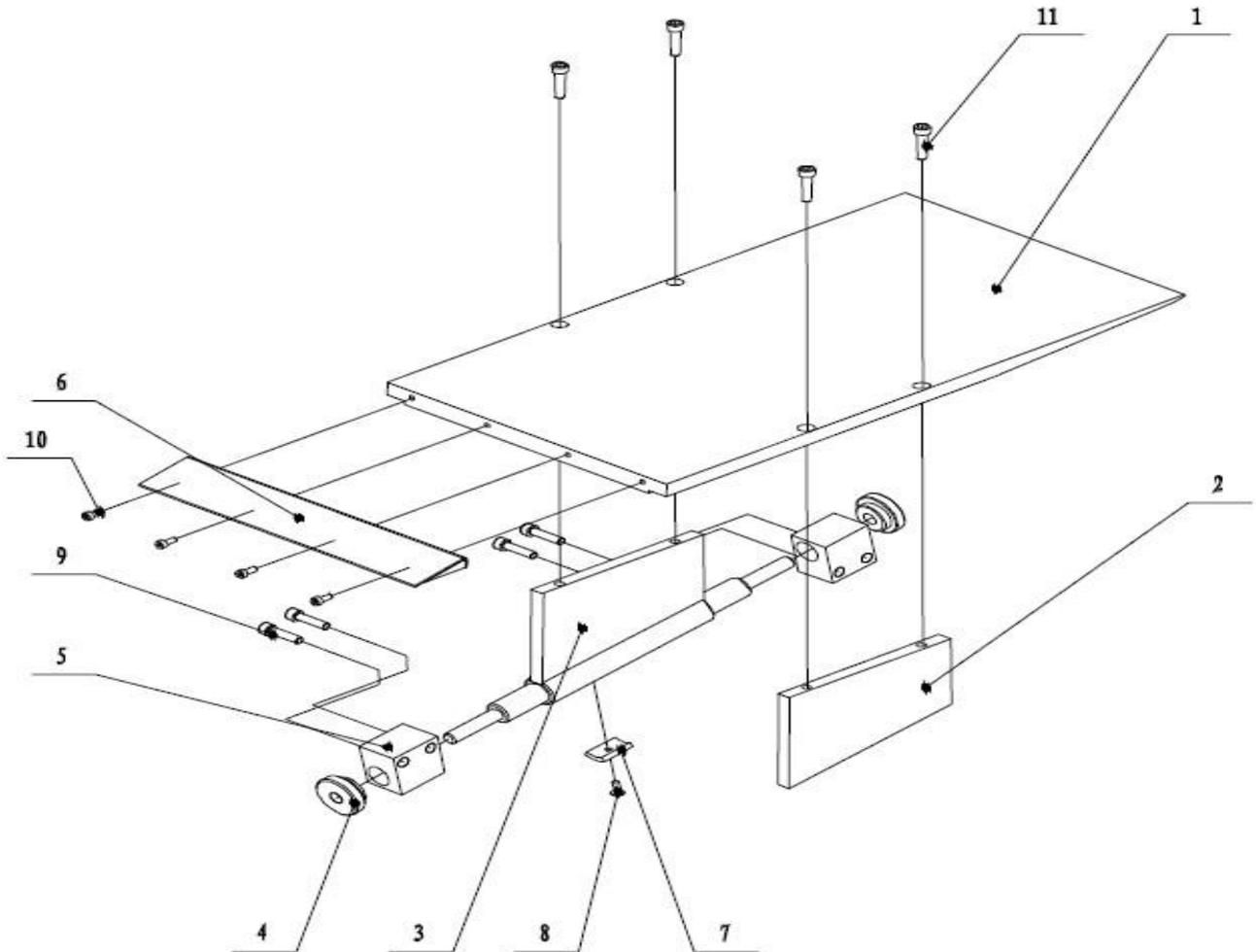
Exploded Parts List - 6

Item	Description	Qty.
1	Driver Pully Frame	1
2	Driver Pully Cover	1
3	Driver Pully	1
4	Driver Pully Axle	1
5	Roundness Locking Nut	1
6	Roundness Nut	1
7	Locking Nut	1
8	Adjusting Bar	1
9	Locating Sleeve	2
10	Compress Spring	2
11	Guiding Axle	2
12	Locating Plate	1

Item	Description	Qty.
13	Washer M10	2
14	Spring Washer M10	2
15	Hex Cap Screw M10 x 35	2
16	Hex Nut M10	2
17	Socket Hex Cap Screw M10 x 40	2
18	Elasticity Ring 25	2
19	Bearing 6305	2
20	Ph Screw M6 x 10	4
21	Socket Hex Cap Screw M10 x 25	2
22	Socket Hex Cap Screw M6 x 10	2
23	Socket Hex Cap Screw M4 x 6	1



EXPLODED PARTS DIAGRAM - 7



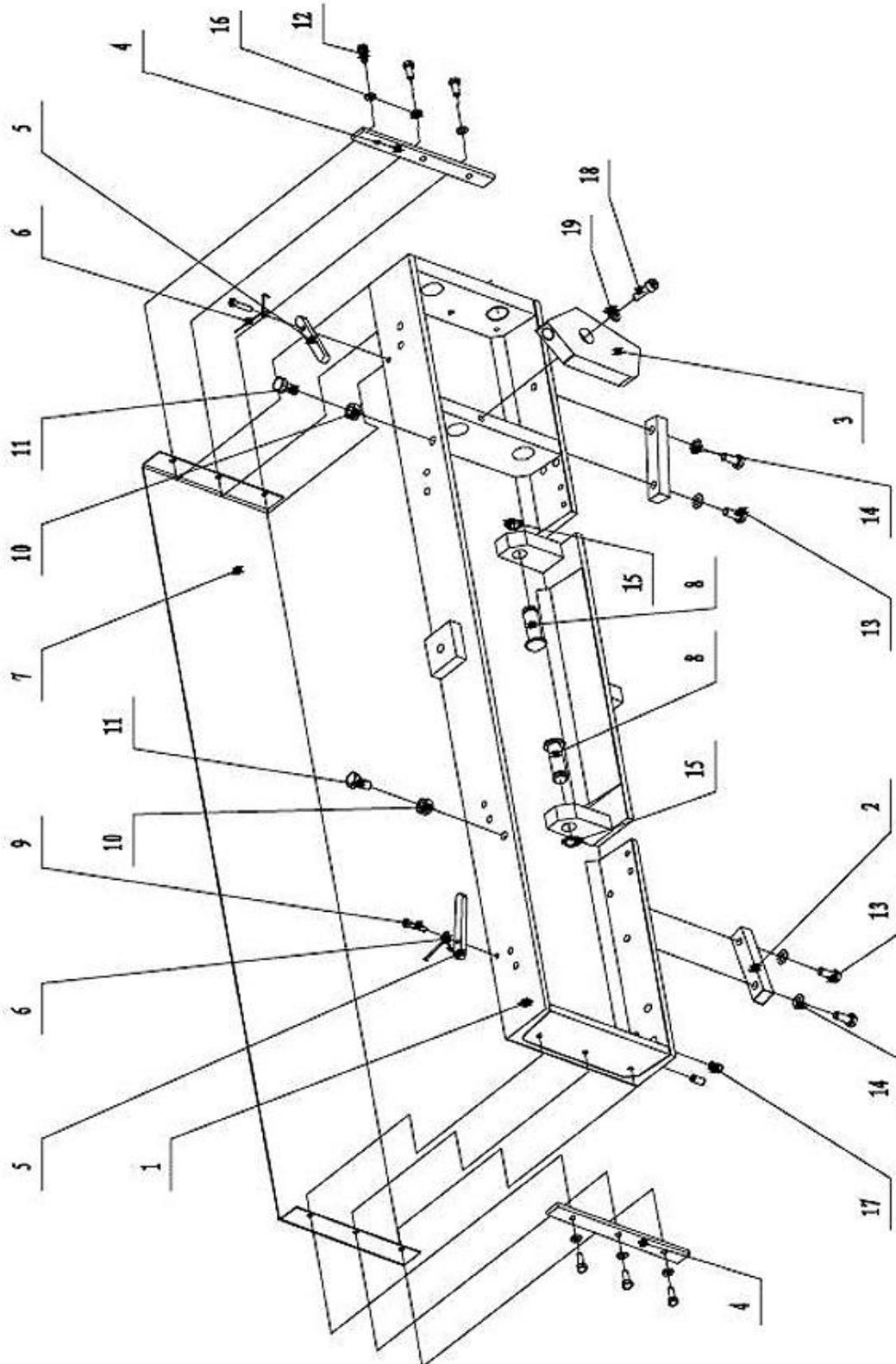
Exploded Parts List - 7

Item	Description	Qty.
1	Left Table	1
2	Supporting Plate	1
3	Turning Support Plate	1
4	Adjusting Nut	2
5	Block	2
6	Small Extention Table	1

Item	Description	Qty.
7	Locking Block	1
8	Screw M4 x 12	1
9	Socket Hex Cap Screw M8 x 25	4
10	Socket Hex Cap Screw M5 x 10	4
11	Socket Hex Cap Screw M6 x 30	4



EXPLODED PARTS DIAGRAM - 8





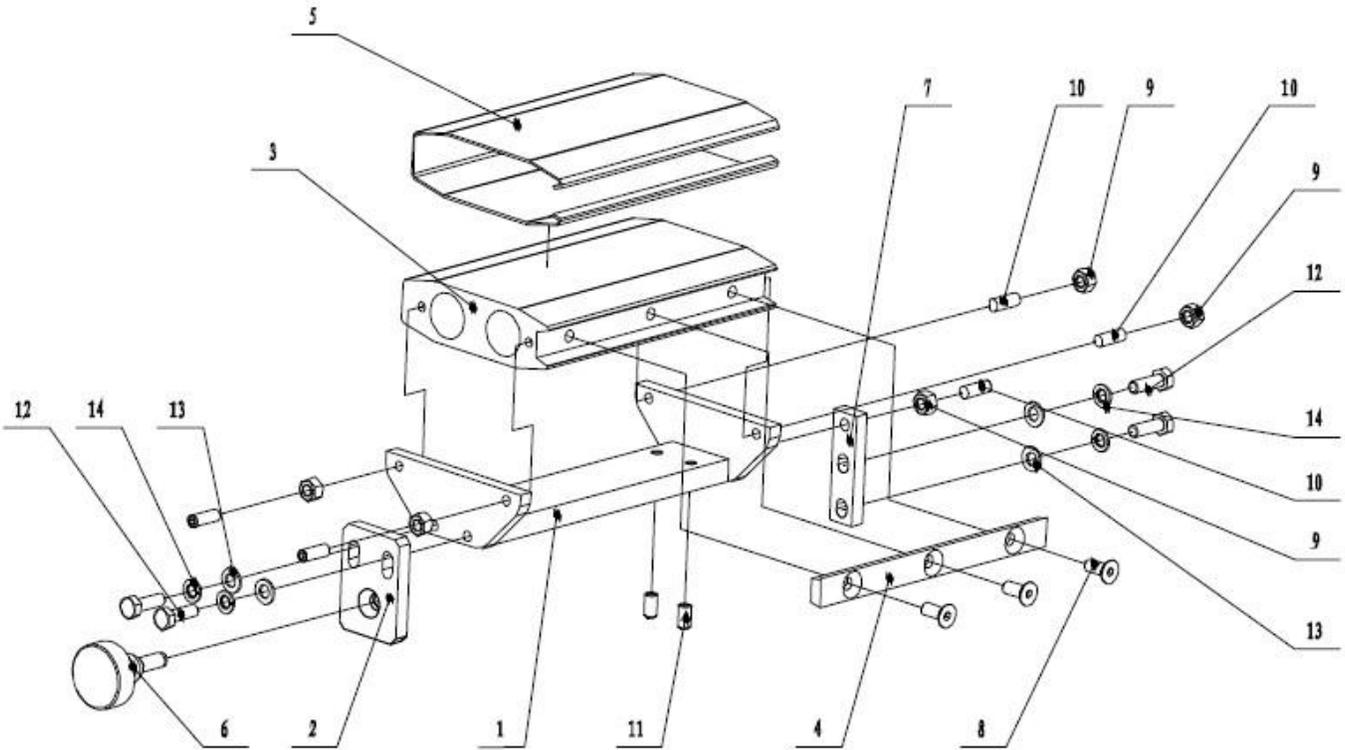
Exploded Parts List - 8

Item	Description	Qty.
1	Graphite Table	1
2	Block	2
3	Cam Block	1
4	Plate	2
5	Locating Pin	2
6	Spring	2
7	Graphite Plate	1
8	Axle	2
9	Socket Hex Cap Screw M5 x 25	2
10	Hex Nut M10	2

Item	Description	Qty.
11	Hex Cap Bolt M10 x 30	2
12	Hex Cap Bolt M6 x 16	6
13	Hex Cap Bolt M8 x 30	4
14	Spring Washer M8	4
15	Elasticity Ring M16	2
16	Washer M6	6
17	Screw M8 x 16	2
18	Socket Hex Cap Screw M8 x 30	1
19	Washer M8	1



EXPLODED PARTS DIAGRAM - 9



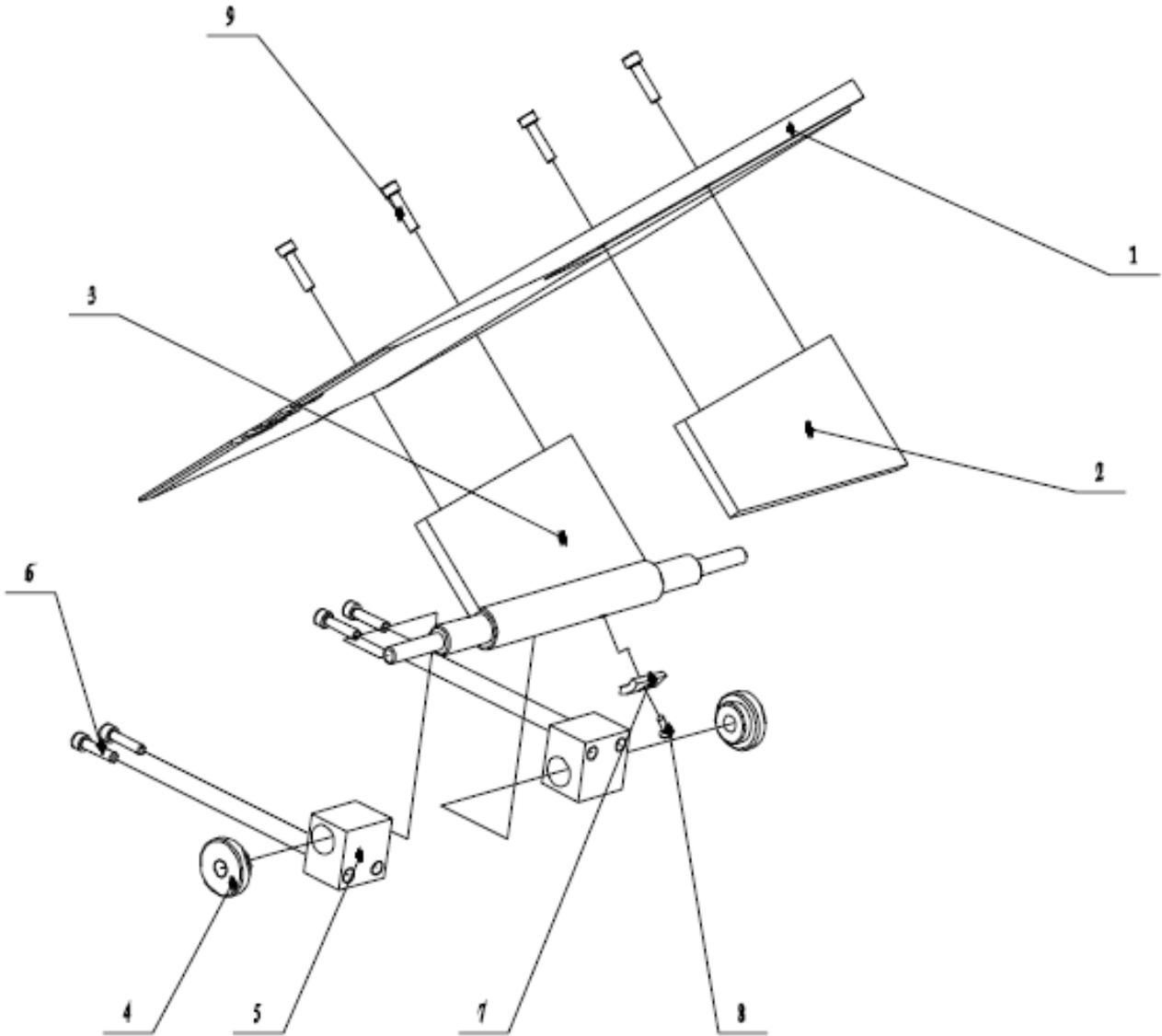
Exploded Parts List - 9

Item	Description	Qty.
1	Extention Graphite Table Support	1
2	Connecting Plate I	1
3	Extention Graphite Table	1
4	Press Plate	1
5	Graphite Plate	1
6	Locking Handle	1
7	Connecting Plate II	1

Item	Description	Qty.
8	Socketed Hex Cap Screw M8 x 20	3
9	Hex Nut M8	5
10	Socketed Hex Cap Screw M8 x 25	5
11	Socketed Hex Cap Screw M8 x 16	2
12	Hex Cap Screw M8 x 25	4
13	Washer M8	4
14	Spring Washer M8	4



EXPLODED PARTS DIAGRAM - 10



Exploded Parts List - 10

Item	Description	Qty.
1	Right Table	1
2	Supporting Plate	1
3	Turning Support Plate	1
4	Adjusting Nut	2
5	Block	2

Item	Description	Qty.
6	Socket Hex Cap Screw M8 x 25	4
7	Locking Block	1
8	Screw M4 x 12	1
9	Socket Hex Cap Screw M6 x 30	4



NOTES



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

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

WWW.BAILEIGHINDUSTRIAL.COM

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

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

BAILEIGH INDUSTRIAL LTD. UNIT 1 FULLWOOD CLOSE

ALDERMANS GREEN INDUSTRIAL ESTATE

COVENTRY, CV2 2SS UNITED KINGDOM

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

WWW.BIFABUK.CO.UK

BAILEIGH INDUSTRIAL GMBH HOFENER STRAÙE 64

70736 FELLBACH

DEUTCHSLAND

WWW.BAILEIGHINDUSTRIAL.DE