

Book 1 of 2

OPERATOR'S MANUAL



JOINTER / PLANER MODEL: JP-1898-NC

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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.



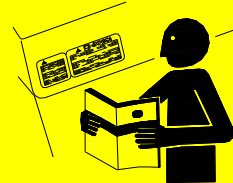
Note: This symbol refers to useful information throughout the manual.



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.



DANGER



WARNING



CAUTION

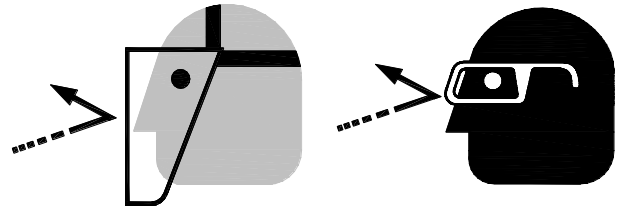


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



PROTECT EYES

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



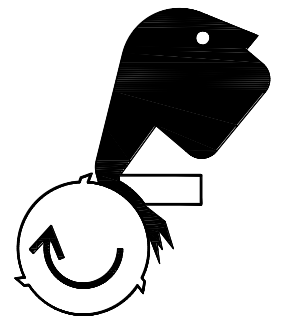
BLADE HAZARD

Keep hands and fingers away from the rotating knife blades. These rotating knives can be extremely dangerous if you do not follow proper safety procedures. **NEVER place hands closer than 3" (76mm) to the rotating cutting knives.**



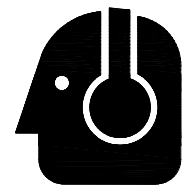
ENTANGLEMENT HAZARD – ROTATING BLADES

Contain long hair, **DO NOT** wear jewelry or loose fitting clothing.



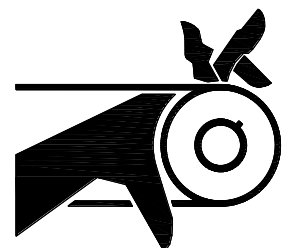
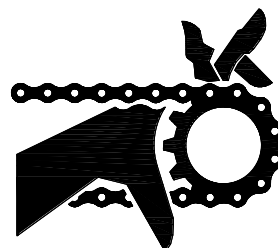
PROTECT AGAINST NOISE

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.



BEWARE OF PINCH POINTS

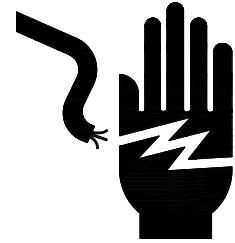
Keep hands and fingers clear of all potential pinch points. These include sprockets and chains along with belts and pulleys.





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. **Kickback.** Become familiar with the term "**Kickback**" before operating this jointer/planer. Kickback occurs when the piece part is thrown off the table by the force of the cutter head. Always use push blocks and wear safety glasses to reduce the likelihood for serious injury.
4. **Kickback Zone.** The path directly behind the end of the in-feed table is referred to as the "Kickback zone". **NEVER** stand or allow others to stand in this area while the machine is running. Position yourself to one side of the machine while the jointer/planer is running.
5. **Using Quality Stock.** Inspect the stock over carefully that you intend to joint or plane. **NEVER** joint or plane a board that has knots, staples, or nails in it. **DO NOT** joint or plane a piece of stock if you have any doubts about its structural integrity.
6. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.



7. **Dull / Damaged Knives.** Use only sharp, undamaged knives to avoid unnecessary kickback of the piece part. Dull and damaged knives will also affect cut quality.
8. **Maximum Cutting Depth.** The maximum cutting depth for one pass is 1/8" (3.2mm). **Never** set the machine to cut deeper than this in one pass.
9. **Keep work area clean.** Cluttered areas invite injuries.
10. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
11. **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.
12. **Use eye and ear protection.** Always wear ISO approved impact safety goggles
13. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
14. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
15. **Grain Direction.** There is an increased chance of kickback when jointing or planing end grain or against the grain. This could also produce chatter and excessive chip out of the material.
16. **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.
17. **DO NOT** bypass or defeat any safety interlock systems.
18. Know the location of the **ON - OFF** switch and the "**E**" - **STOP** button.
19. Keep visitors a safe distance from the work area.
20. **Push Blocks.** Always use push blocks when surface planing. **DO NOT** pass your hands directly over the cutterhead without using a push block.
21. **Cutterhead Alignment.** Keep the top edge of the out-feed table aligned with the cutterhead knife at top dead center (TDC). This will help to avoid kickback and possible operator injuries.
22. **Keep Guards in Place.** All operations are to be performed with the cutterhead guard in place.
23. **Support the piece part.** Supporting the piece part adequately while cutting, is crucial to making safe cuts and avoiding possible operator injury.
24. **Proper cutting.** While cutting, always keep the piece part moving towards the out-feed table until it has completely passed over the cutterhead. **NEVER** back the piece part toward the in-feed table.



25. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
26. **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.
27. **DO NOT** touch live electrical components or parts.
28. **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.
29. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
30. **Maintain machine in top condition.** Keep clean for best and safest performance. Follow instructions for lubricating and changing accessories.
31. **Reduce the risk of unintentional starting.** Make sure switch is in “**OFF**” position before plugging in power cord.
32. **Never leave machine running unattended. TURN POWER OFF.** Don't leave machine until it comes to a complete stop.
33. **Make sure machine is disconnected from power supply** while motor is being mounted, connected or reconnected.
34. **Using Correct Materials.** Using materials other than natural wood fiber can result in serious personal injury and machine damage. NEVER use this machine for anything except jointing and planing of wood.
35. **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 wood dust collection systems whenever possible.



EMERGENCY STOP BUTTON

This machine has two emergency stop buttons. In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing either **E-STOP** button. Twist the red cap to reset. Resetting will not restart the machine



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.



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.

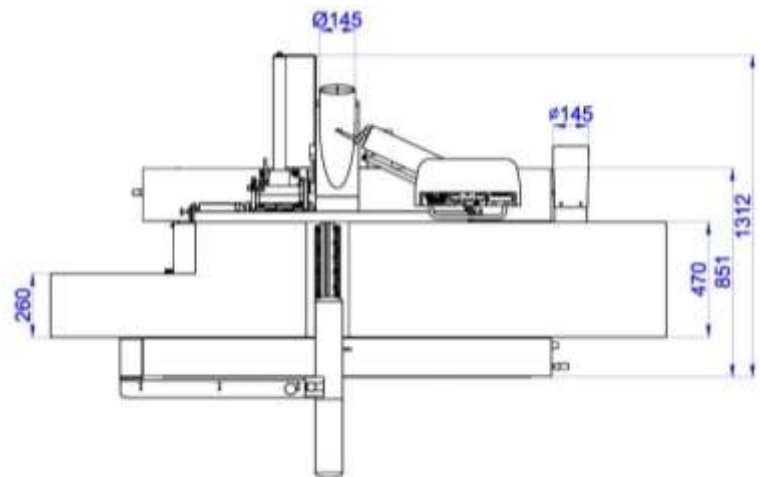
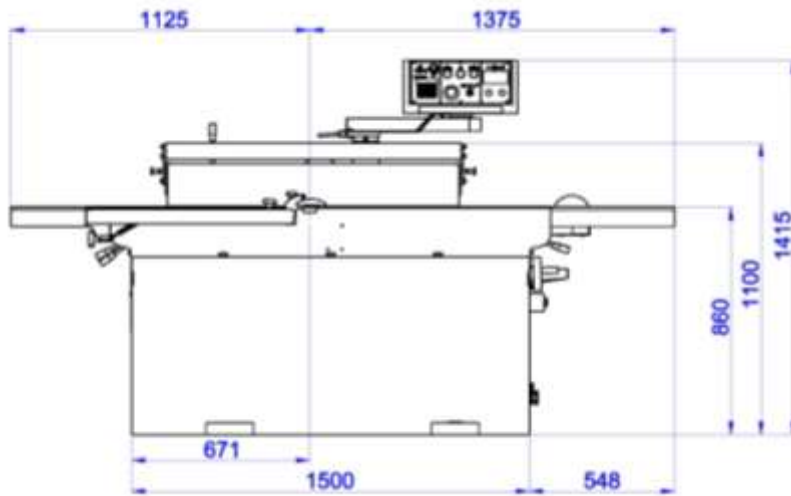
Motor Specifications

Your machine is wired for 220 volt, 3ph, 60Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.



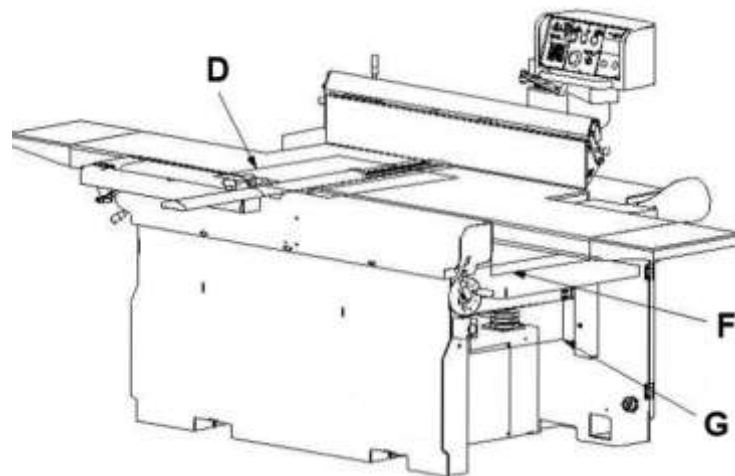
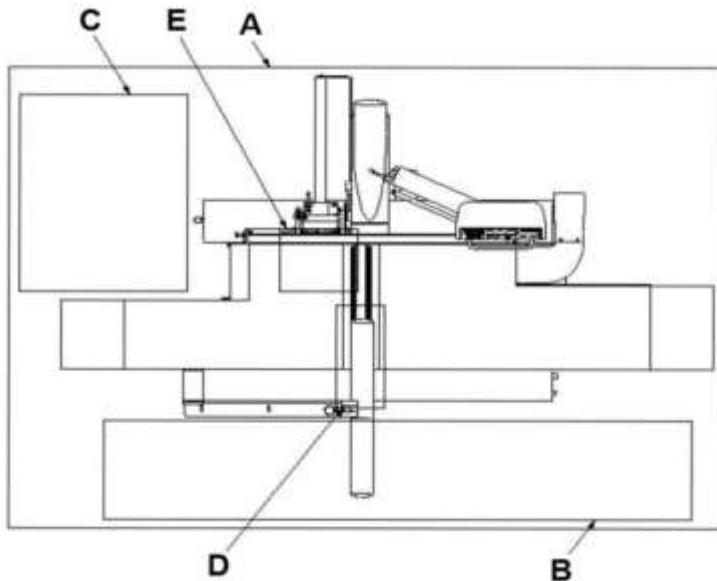
SPECIFICATIONS

Cutting Capacity (W x H)	18" x 9.5" (457 x 241mm)
Maximum Depth of Cut	5/16" (8mm)
Minimum Material Thickness	1/8" (3.2mm)
Cutterhead Speed	5700 RPM
Min/Max Operating Height	.18"- 9.8" (5-250mm)
Table Size	18" x 63" (460mm x 1600mm)
Variable Feed Drive	18-49.2 fpm (5.5-15m/min)
Flat Cutter Head	4.72" (120mm) Dia. 4-Blade
Dust Extraction Outlet Diameter	5.9" (150mm)
Motor	7.5Hp (5.6kw), 220V, 3Ph, 60Hz
Shipping Weight (Approx.)	1320 lbs. (602kg)





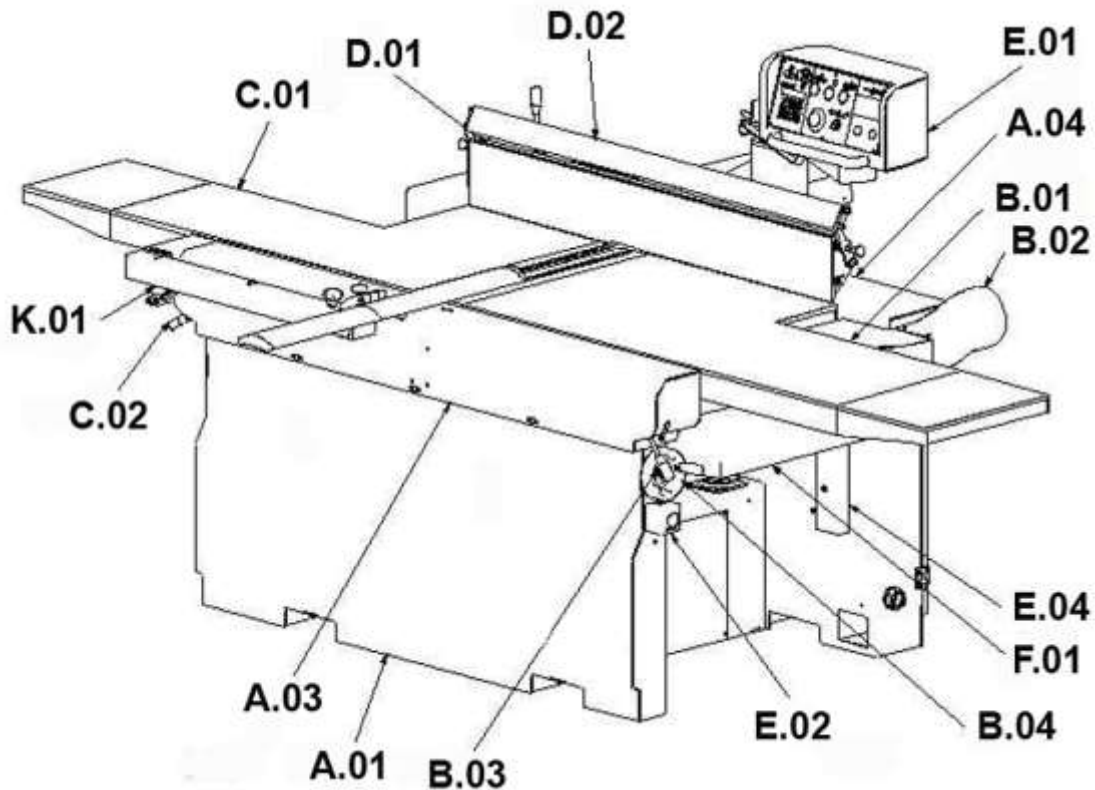
Working Zone and Hazard Zone



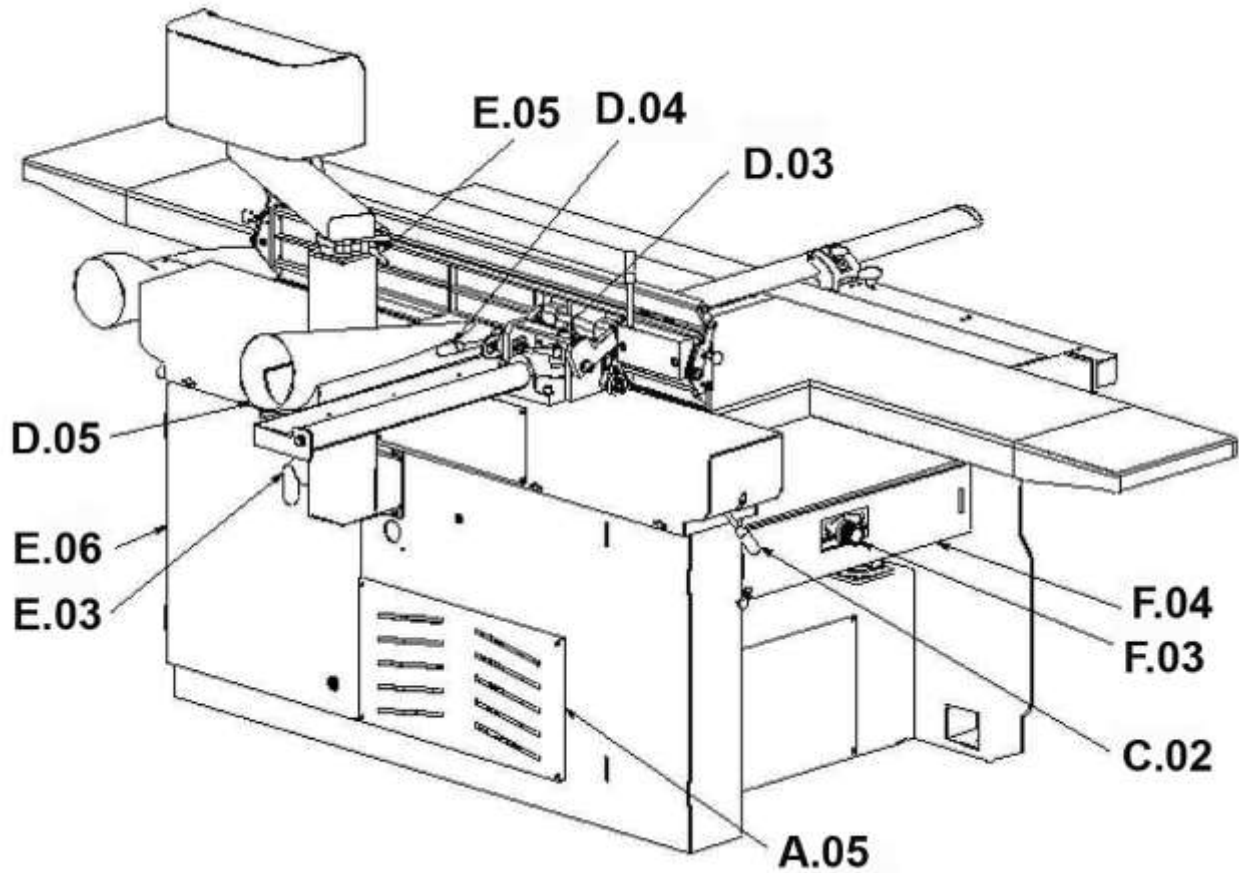
NO.	RISK PART	APPELLATION	DANGER CONDITION
A	Machine scope	Working Zone	Noise
B	Planer	Working zone	Noise
C	Thicknessing	Working zone	Noise
D	Cutterblock	Hazard zone	Sever
E	Angle Fence	Hazard zone	Squeeze
F	Thicknessing	Hazard zone	Squeeze / Sever
G	Middle of unit and unit	Hazard zone	Squeeze
H	Terminal boxes	Hazard zone	Electric shock



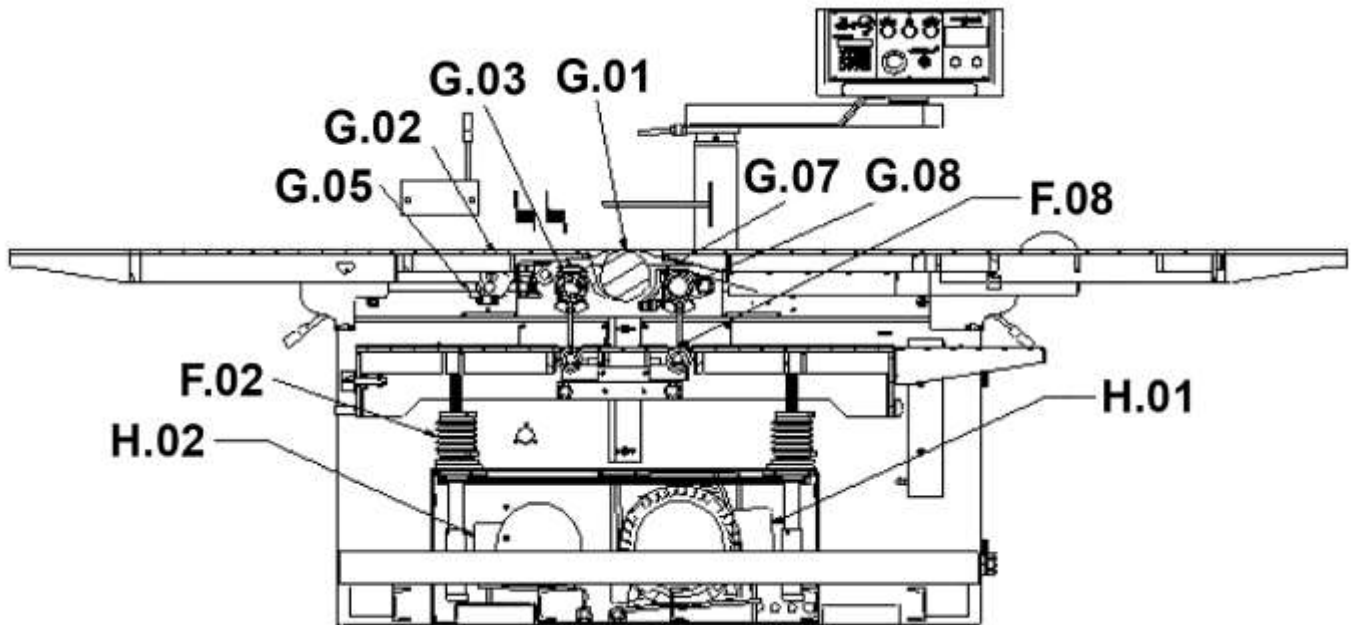
Technical Features



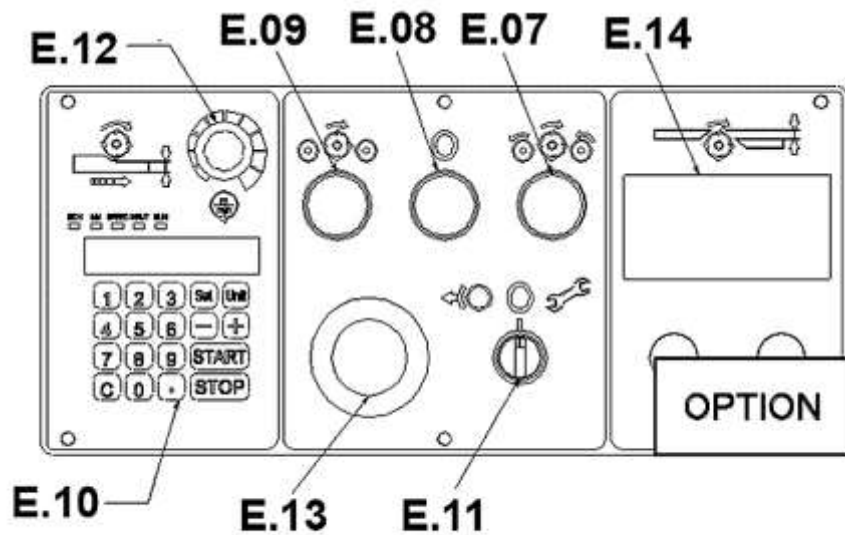
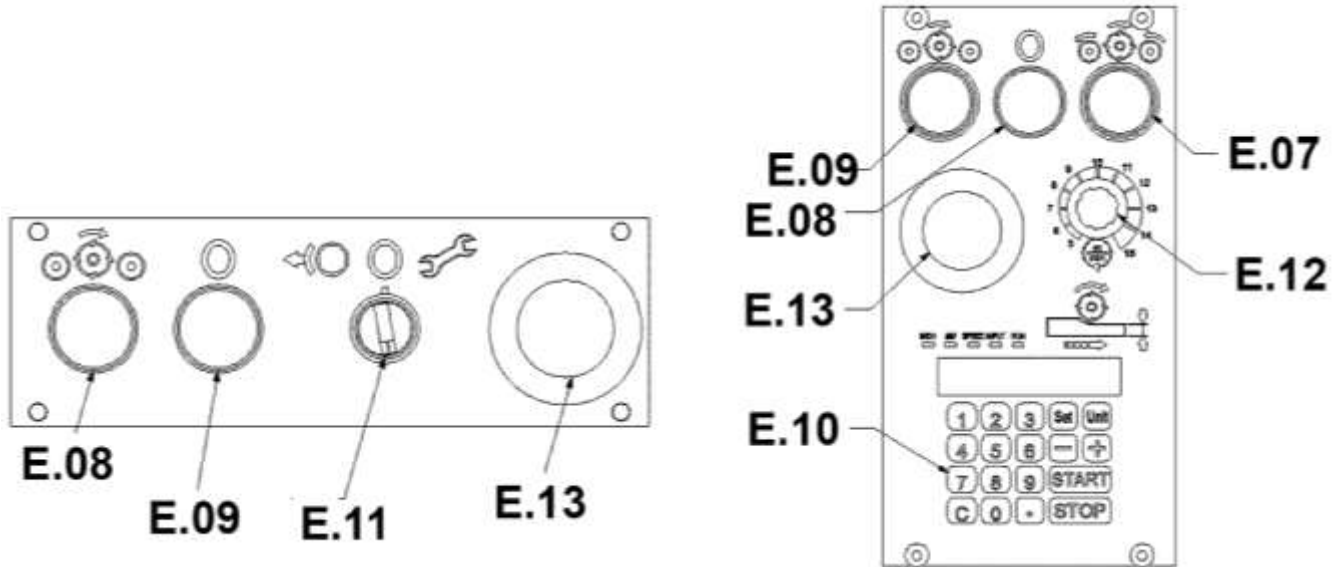
NO.	DESCRIPTION
A.01	Machine Base
A.02	Eye Bolt
A.03	Protecting Cover
A.04	Protecting Cover
B.01	In-Feed Table
B.02	Guard For Planers Mode
B.03	Lock Handles For In-Feed Table
B.04	In-Feed Table Height Adjustment
C.01	Out-Feed Table
C.02	Lock Handles For Out-Feed Table
D.01	Angle Fence
D.02	Side Plate
E.01	Electrical Control Assembly
E.02	Emergency Stop
E.04	Limit Switch
F.01	Stretch Table
K.01	Safety Guard



NO.	DESCRIPTION
A.05	Motor Cover
C.02	Lock Handles For Out-Feed Table
D.03	Lock Handles
D.04	Adjustment Handles
D.05	Guard For Thicknessing Mode
E.03	Power Switch
E.05	Lock Handles
E.06	Electrial Control
F.03	Adjustment Knobs
F.04	Thicknessing Table



NO.	DESCRIPTION
F.02	Table Elevation Screw
F.06	Table Rollers
G.01	Cutterblock
G.02	In-Feed Block
G.03	In-Feed Roller
G.04	Anti-Kickback fingers
G.05	Depth cut Limiter
G.06	Out-Feed Roller
G.07	Out-Feed Block
H.01	Cutterblock Motor
H.02	Feed Motor



NO.	DESCRIPTION
E.07	Feed Start
E.08	Stop
E.09	Cutterblock Start
E.10	Operation Instructions
E.11	Repair Switch
E.12	Potentiometer
E.13	Emergency Stop
E.14	LED Displays



Machine operating conditions

In a dry environment, at a temperature between 5°C and 40°C
Relative humidity: 30% ~ 95% RH.

Dismantling and scrapping

Before dismantling the machine, disconnect all energy sources carefully.

1. Dismantling of Electrical Systems

Before disconnecting the cables from the power cabinet, please confirm first that all switches have been closed.

2. Dismantling of Mechanical Components

Before dismantling the mechanical body, please clean the whole structure in order to dismantle conveniently.

3. Scrapping and Disposal

Comply with local laws when disposing of materials according to their composition. If in doubt, please contact local officials.

Noise Production Values

Noise production level:

IDLING 84 dB (A)

WORKING 91 dB (A)

Noise production values at workstation environment:

Environment 49 dB (A)



WARNING: Prolonged exposure to a level higher than 85 dB (A) may cause damage to your health; users are always recommended to make use of suitable personal protection systems (e.g. headphones, ear plugs).

- The values shown are production levels and are not necessarily levels for safe working.
- While there is a relationship between production levels and exposure levels, this may not be used reliably to determine whether any further precautions are necessary.
- Factors which influence the real level of exposure for workers include the duration of exposure, the characteristics of the buildings, other sources of dust and noise etc., for example the number of machines and other processes being carried out in the vicinity.

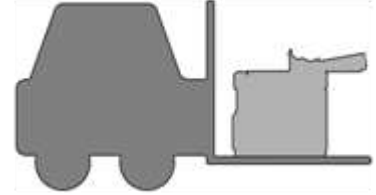
HOWEVER, THIS INFORMATION WILL ENABLE A MACHINE USER TO MAKE A BETTER ASSESSMENT OF THE DANGERS AND RISKS INVOLVED



CARRYING AND INSTALLATION

The machine's weight is about 2420 lbs (1100kgs)

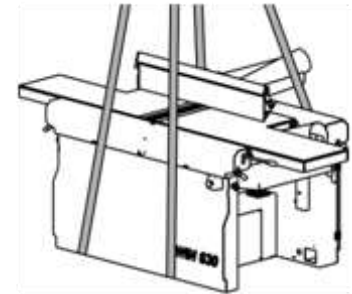
USE LIFT TRUCK TO TRANSPORT MACHINE



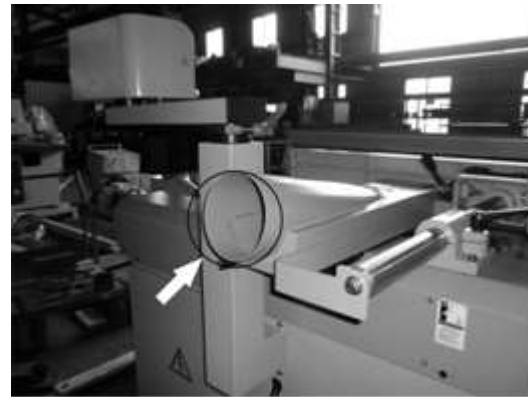
⚠ WARNING: Make sure the machine is balanced. While transporting, avoid any unnecessary vibration.

USE GANTRY OR CRANE TO REMOVE MACHINE FROM PALLET

⚠ WARNING: Before the machine is put on the floor, install the level adjusting bases and adjust the level of the machine's working table.



Suction



1. Before the machine is started it must be connected to two suction hoods.
2. The hoses must be of a fire resistant type material and have an internal diameter of 5.9" (150mm)
3. The suction generator must be able to provide a capacity of no less than 1100m³/h with a speed of at least 20m/sec.



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

1. The connection of the machine to the main power must be carried out by a skilled electrician in accordance with the specifications of the standards in force.
2. Use the specific purpose tool in the toolbox (Fig. 1), Turn on the power control cabinet and introduce the electric wire. (Fig. 2)
3. The conductors must be connected to the terminals marked: L1 - L2 - L3 (Fig.3), and the yellow and green earth wire to the terminal: PE.
4. Start the machine for a few seconds to ensure that the tool is turning in the direction indicated by the arrows on the plate of the casing. (Fig. 4)
5. IF NOT, SWITCH OFF THE MACHINE, DISCONNECT THE POWER AND INVERT THE TWO PHASES.



Figure 1



Figure 2

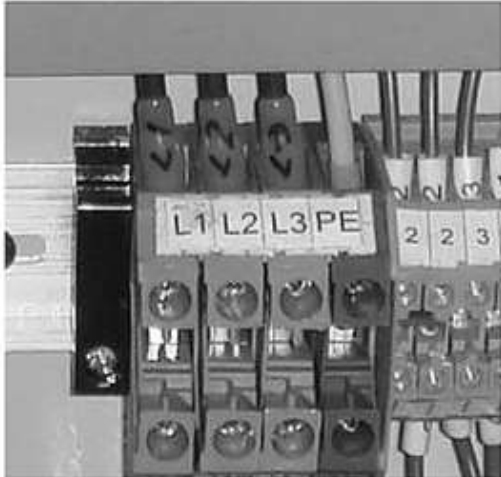


Figure 3

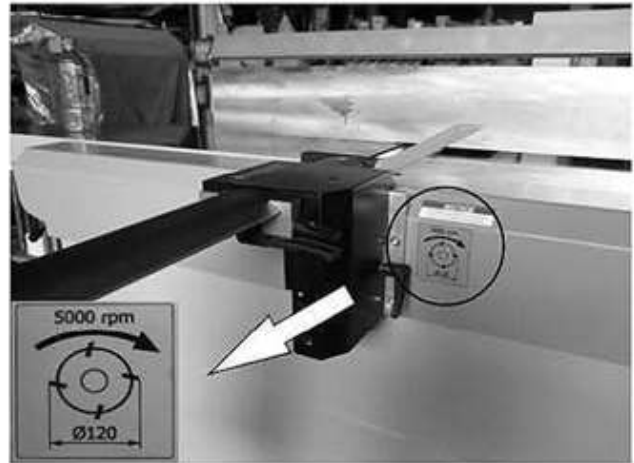


Figure 4

- 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.

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 manual cover photo illustrates the current production model. All other illustrations 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.*



ADJUSTING

⚠ 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.

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

- During initial running of the machine, the belts ride a little tighter in the pulley grooves and this can cause a slight reduction in belt tension.
- Adjust the tension after a few days of use, without over-tightening so as not to overload and cause consequent damage to the motor bearings and the planer shaft.
- Check the belts for wear at least once every two months and restore optimum tension.
- Never use different brands of belts together, but use only those supplied by the manufacturer.

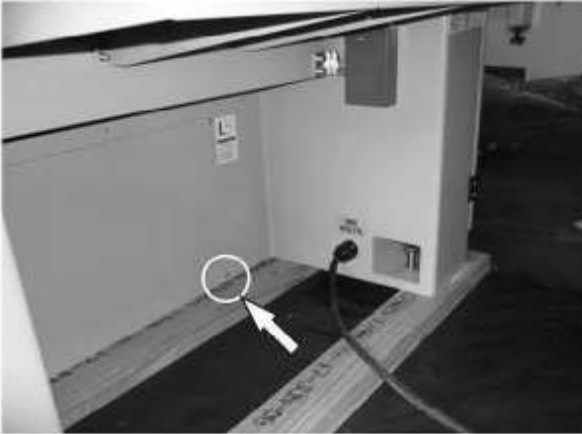
Adjusting the Tension and Replacing the Belts for Cutter



1. Adjust or change the belt position, as drawn.



2. Remove the protective casing of the machine.(4 screws)

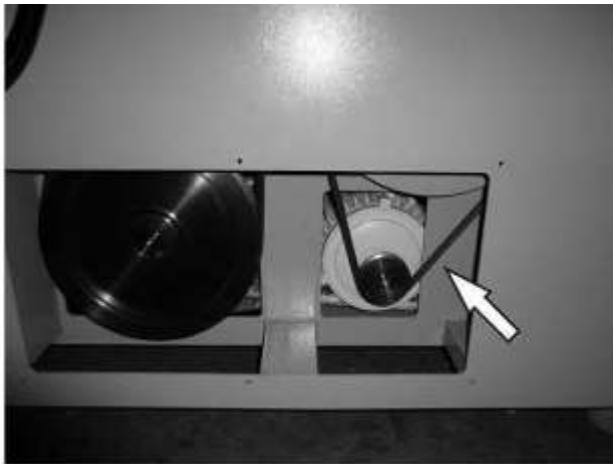


3. Remove the protective casing of the machine.(4 screws)



4. Unscrew the nut and adjust the nut, restore optimum tension. Install the protective casing.

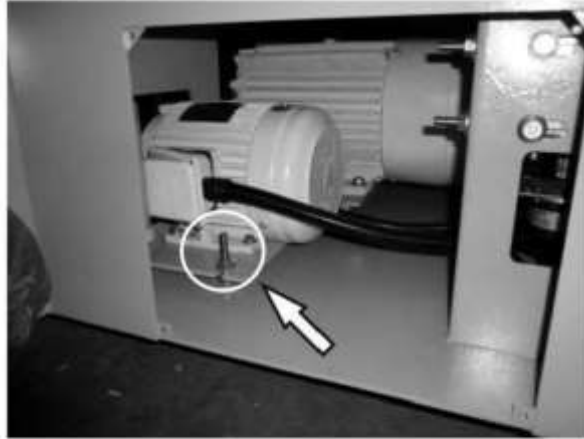
Adjusting the Tension and Replacing the Belts for Feed



1. Adjust or change the belt position, as drawn.



2. Remove the protective casing of the machine.(4 screw)



3. Unscrew the nut and adjust the nut, restore optimum tension. Install the protective casing.

Adjusting the Chains

The drive chains stretch naturally due to play which occurs after a certain working period and must be tightened in order to ensure perfect operation and maximum torque drive to the movement.



1. Adjust the chains position, as drawn.



2. Remove the protective casing of the machine.(4 screws)



3. Unscrew the 4 screws.



4. Adjust the nuts (2). Then tighten the screws (4), Install the protective casing.



SAFETY INSPECTIONS



WARNING: Do a safety inspection twice weekly of the safety switch

Check of emergency stop switch

1. Connect to power, start the Cutterhead to make the machine run.
2. Push each emergency stop on machine and check if the Cutterhead completely stops within 5 seconds.
3. When the emergency stop is pressed, the machine should not have any movement.
4. If the emergency stop is out of order, please immediately stop operation and respond to the supplier.

Check of safety connection switch

1. Connect to power, open safety door.
2. Operate the machine. At this time, the machine doesn't have any movement.
3. Close the safety door and operate the machine again.
4. If machine works normally, that means the safety connection switch is normal.
5. If machine doesn't have any movement when the safety door is closed, please stop operation immediately and respond to the supplier.

Check of brake

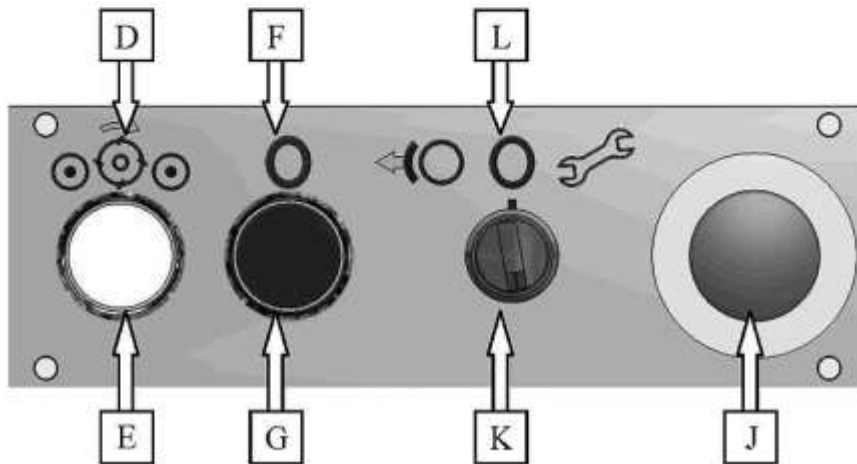
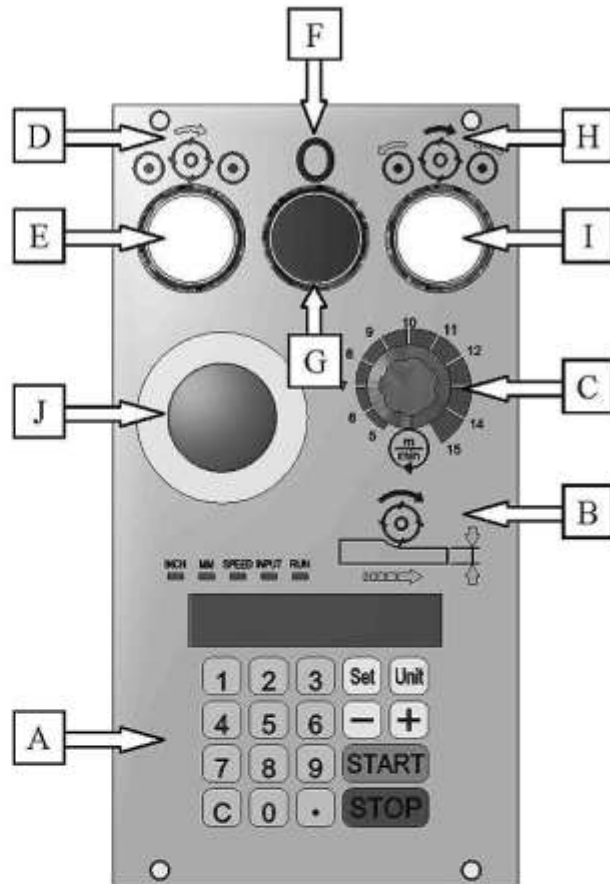
1. While the Cutterhead is running, push the saw stop switch or the emergency stop switch.
2. At this time, the Cutterhead should completely stop within 5 seconds.
3. If the brake time exceeds 5 seconds, please immediately stop operating machine and respond to the supplier.



CONTROL PANEL

Description of the Panel

- A..... M-10-e
- B..... Thickness label
- C..... Speeding switch
- D..... Cutterblock start label
- E..... Cutterblock start
- F..... Stop label
- G..... Stop
- H..... Feed start label
- I..... Feed start
- J..... Emergency Stop
- K..... Repair switch
- L..... Repair switch label
- M..... Planing label





Operating the VFD-E

Description of the digital keypad



1. Status Display

Display the driver's current status.

2. LED Display

Indicates frequency, voltage, current, user defined units, and etc.

3. Potentiometer

For master frequency setting.

4. RUN Key

Start AC drive operation.

5. UP and DOWN Key

Set the parameter number and changes the numerical data, such as Master Frequency.

6. MODE

Change between different display mode.

7. STOP/RESET

Stops AC drive operation and resets the drive after fault occurred.

8. ENTER

Used to enter/modify programming parameters



Operation Steps for the Digital Keypad

Setting Mode



NOTE: In the selection mode, press **ENTER** to set the parameters. **GO START**

Setting parameters



NOTE: In the parameter setting mode, you can press **ENTER** to return the selecting mode.

To shift data



Setting direction (When operation source is digital keypad)

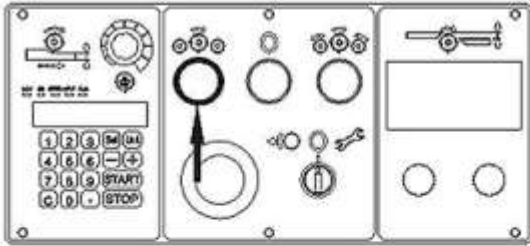


Setting PLC Mode

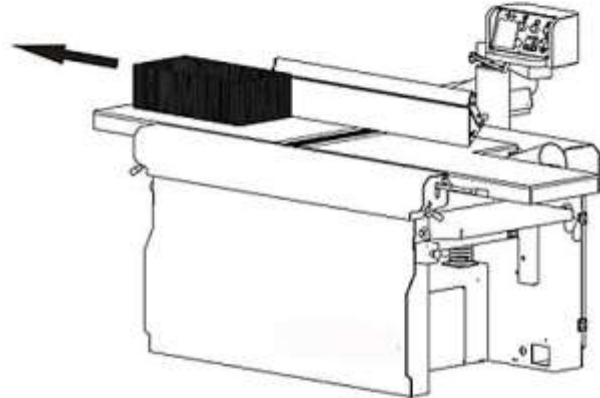
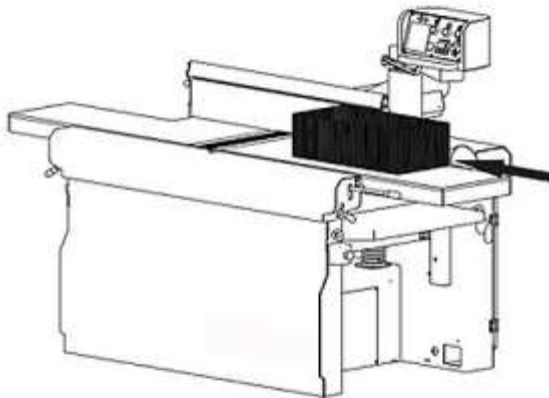
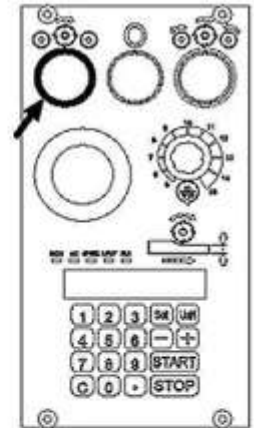




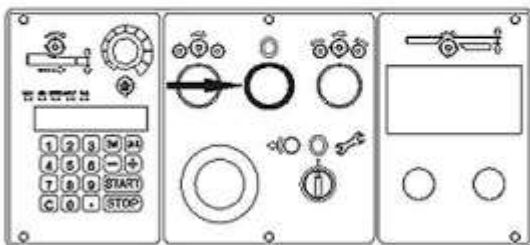
Starting and Stopping the Machine



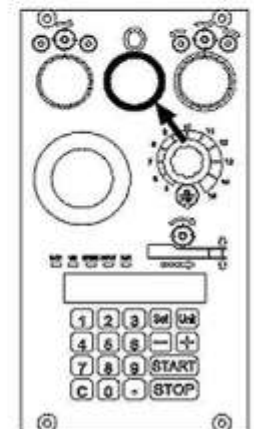
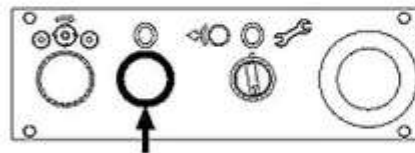
1. Start button of the cutterblock.

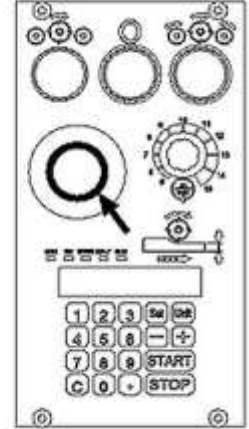
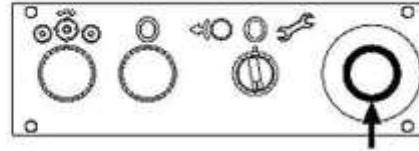
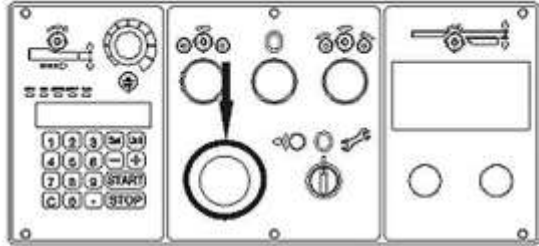


2. Processing direction.



3. Push the stop button, to stop machinery.

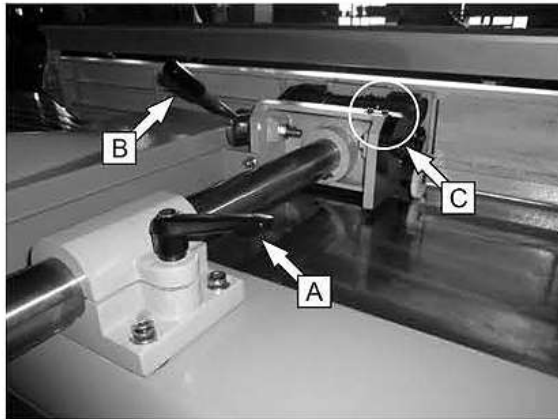




Or push the emergency stop, to stop machinery.

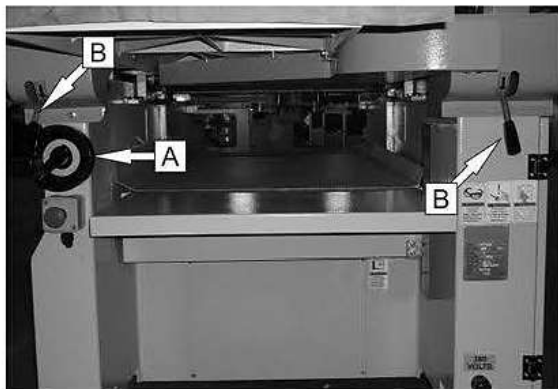


Angle fence



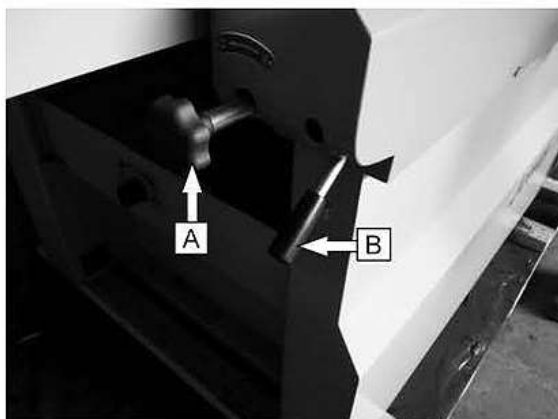
- A- Lock handle
- B- Lock handle for angle fence
- C- Scale

Adjust in-feed table height



- A- In-feed table adjust handle
(0~5mm)
- Before adjusting, Unscrew the lock handle B of two sides.

Adjust out-feed table height



- A- Out-feed table adjust handle
(0-2mm)
- Before adjusting, Unscrew the lock handle B of two sides.



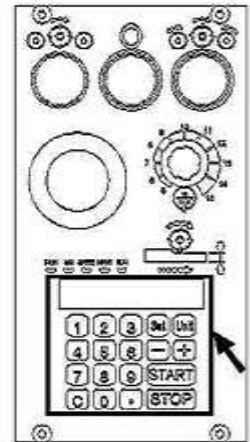
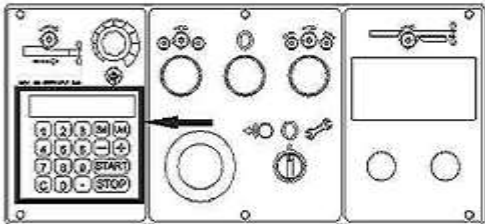
Thickening

Side plate

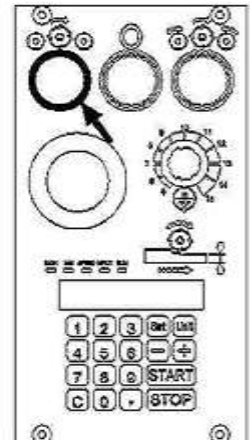
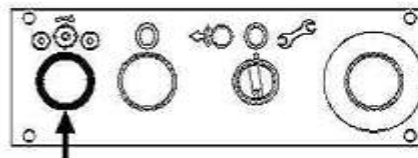
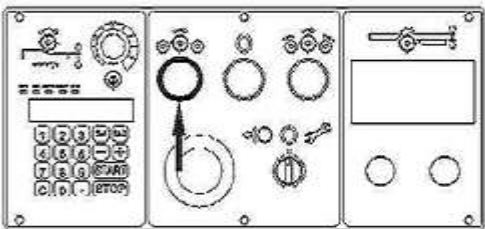


The arrow points to the bolt to orient clicking.

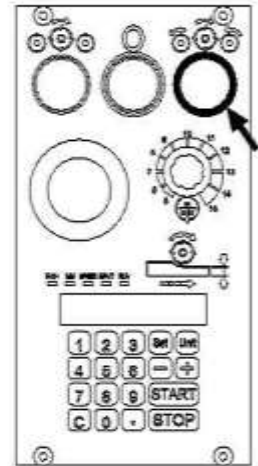
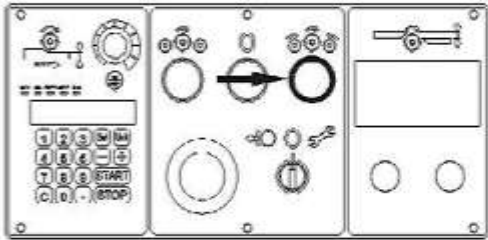
1. Use M10-e to adjust thickening table height



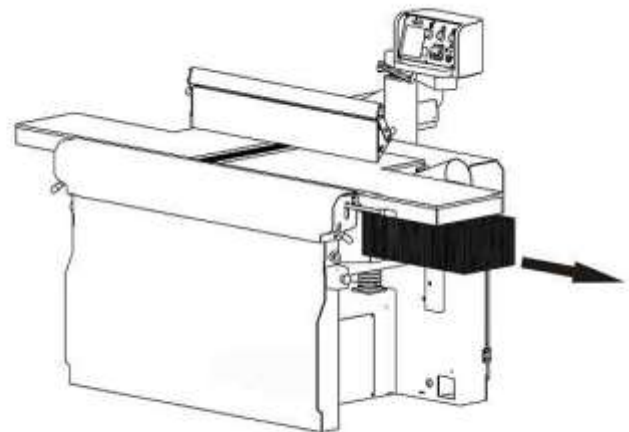
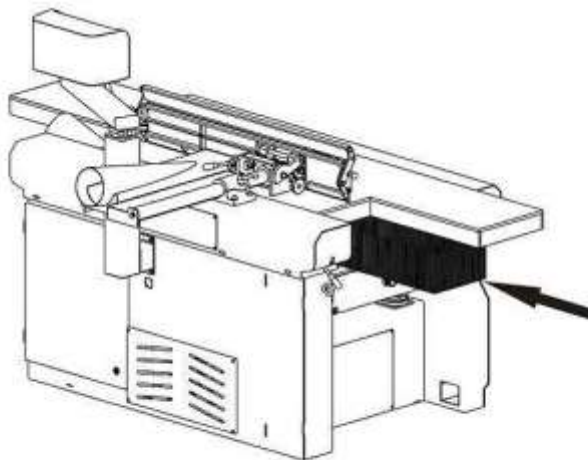
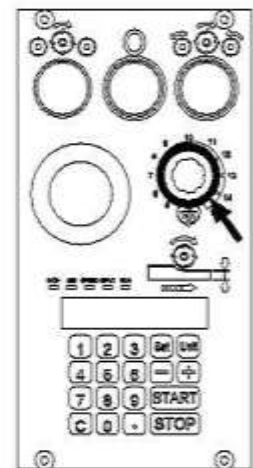
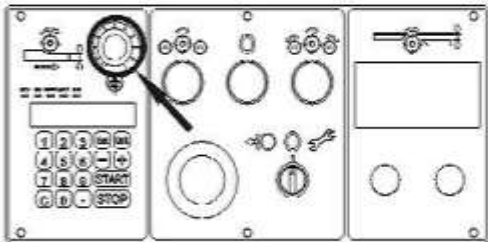
2. Start button of the cutterblock.



3. Start button of feed roller.



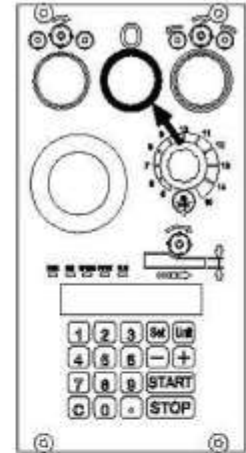
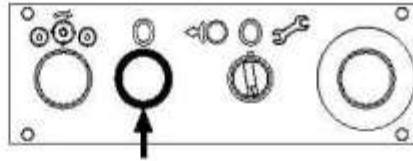
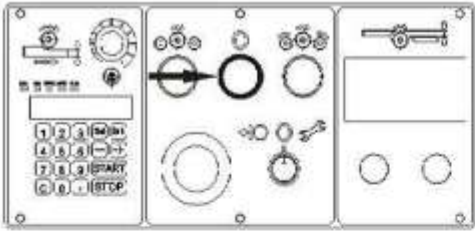
4. Use power resistor to adjust the speed.



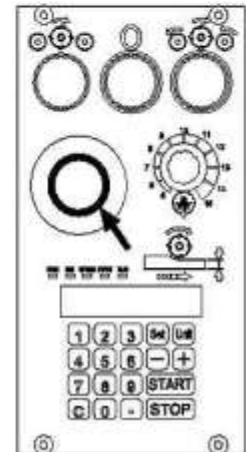
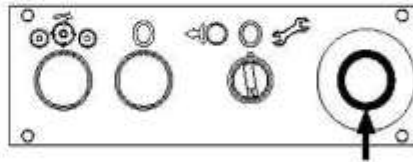
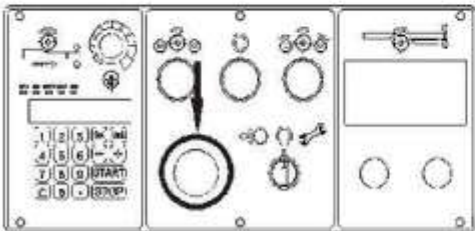
5. Processing direction



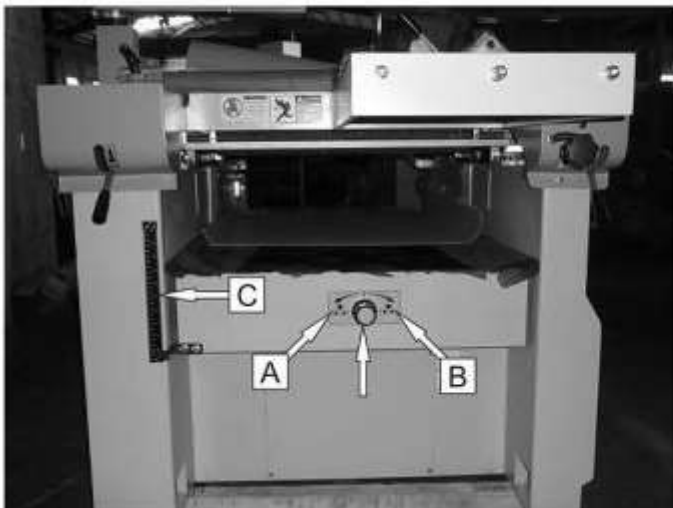
6. Push the stop button, to stop machinery



7. Or push the emergency stop, to stop machinery



Adjust rollers on the table



- A- rollers fall
- B- Rollers rise
- C- Scale for thickening



MAINTENANCE



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

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

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

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

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



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

- Check all fasteners to make sure they are tight and check all adjustments that they are in order.
- Clean and oil the tables so that the material will slide easily. Clean any rust spots that may develop on the bed with a commercial rust remover.
- Use compressed air to blow out the interior of the machine in order to keep chips and sawdust from accumulating on the belts and pulleys.
- Check the drive belt for tightness. It should be snug but not overly tight.
- Use a mill file to remove any nicks or dings from the infeed or outfeed tables.



1. Lubricate the chains



2. Loosen 4 fixing screws

Lubricating cycle	1 month	
Brand		
MOBIL	ESSO	SHELL
MOBILUX2	BEACON2	ALVANIAR2



1. Lubricate the chains



Lubricating cycle	1 month	
Brand		
MOBIL	ESSO	SHELL
MOBILUX2	BEACON2	ALVANIAR2



1. Loosen fixing screw, as shown in above Drawing. (There are 4 parts need lubricating)



2. Remove the sheath. (can use the set screw Substitution it)



3. After installing the nozzle , use the attached oil gun to pour the lubricating oil into the nozzle.
 4. Remove the nozzle ,install the sheath, and tighten fixing screw.

Lubricating cycle	1 month	
Brand		
MOBIL	ESSO	SHELL
MOBILUX2	BEACON2	ALVANIAR2



1. Lubricate the rail

Lubricating cycle		1 week
Brand		
MOBIL	ESSO	SHELL
MOBILUX2	BEACON2	ALVANIAR2



1. After work is finished, please clean the in-feed table, out-feed table and thicknessing table.

Lubricating cycle		After work is finished	
Ambient temp	ISO VG	MOBIL	SHELL
-30° ~5° C	BP-150	Mobil Gear 629	Omala Oil 150



Anti-Reject Arms

- The machine is equipped with a series of anti-reject arms which run continually as they pivot idly in relation to the supporting pin and operate with any thickness of wood, thus preventing the workpiece from being rejected in the direction of the operator and ensuring efficient active protection.
- Before starting work, check that all the arms rotate freely on their axis.
- To prevent any of the arms from sticking or seizing keep them constantly clean and remove any shavings or pieces of wood which are stuck between them with a strong blast of compressed air.
- Any residual resin must be removed by washing the entire unit using a brush and turpentine and drying with compressed air.
- The machine is fitted with an over stroke limiting bar for preventing removal exceeding 0.31" (8mm)

Additional Maintenance procedures

1. The belt must never come into contact with solvents or lubricants.
2. The shaft bearings in the machine do not need to be lubricated, as there is sufficient grease inside to last their entire working life.
3. Grease driving shaft of the table.
4. Grease rotation hinge of the planing table.
5. Grease driving chain of the feeding rollers.
6. As well as these points, clean and oil all moving parts, rods, threaded bars, pins and any part that may be subject to oxidation.



TROUBLESHOOTING

⚠ WARNING: Disconnect machine from the power source before attempting any troubleshooting

Problem	Probable Cause	Remedy
The machine does not start.	1. No voltage in line.	Check voltage in line with instrument.
	2. Fuses broken.	Check fuses and replace if necessary
	3. Emergency stop button pressed.	Reset emergency button.
	4. Main switch in position "0".	Turn main switch to position "1".
	5. Motor protection or thermal protection switched off.	Reset the motor protection or thermal protection.
Decreased shaft revs.	1. Loose belt.	Adjust the belt tightening device.
	2. Worn belt.	Change it.
	3. Traces of lubricant on the belt and pulleys.	Clean carefully with a cloth or paper.
The rollers advance noisily.	1. The chain is not lubricated.	Lubricate the chain.
	2. The chain lightener is not adjusted.	Tighten the chain.
Vibrations in the shaft.	1. Belt is worn or faulty.	Change it.
	2. The knife edges are inconsistent	Change
	3. Resin on the flanges and blades.	Clean and check.
The shaft does not stop within 10" (when the machine is provided with a self-braking motor)	1. Worn brake.	Adjust the brake following the indications.
The shaft turns very slowly	1. The motor brake is working poorly.	Check that the diode jumper inside the motor is working properly, replace it if necessary. If the problem persists, change the motor brake.



NOTES



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