



Wood Working

OPERATOR'S MANUAL



POWER FEED MODEL: PF-3750

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

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

Table of Contents

THANK YOU & WARRANTY	1
INTRODUCTION.....	3
GENERAL NOTES.....	3
SAFETY INSTRUCTIONS	4
SAFETY PRECAUTIONS	7
Dear Valued Customer:.....	7
TECHNICAL SPECIFICATIONS.....	9
TECHNICAL SUPPORT	9
UNPACKING AND CHECKING CONTENTS.....	10
Cleaning	10
INSTALLATION.....	11
Locate Mounting and Boring Position	11
Light Duty	11
ASSEMBLY AND SET UP	12
HOUSING	13
ELECTRICAL	15
Power cord connection:	16
OPERATION.....	17
Specific Safety Rules for Power Feeder	17
Feeder Adjustment	17
Feeder Operation	19
POSITIONING POWERFEEDER ON MACHINES	20
FEED RATE SETTING	23
Gear Hub	23
LUBRICATION AND MAINTENANCE	24
Lubrication	24
Changing Gear Box Oil.....	25
Roller Replacement	25
Roller Tire Replacement.....	26
FEEDER PARTS DIAGRAM	27
Feeder Parts List	28
STAND PARTS DIAGRAM	31
Stand Parts List	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.



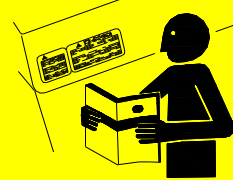
Note: *This symbol refers to useful information throughout the manual.*



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

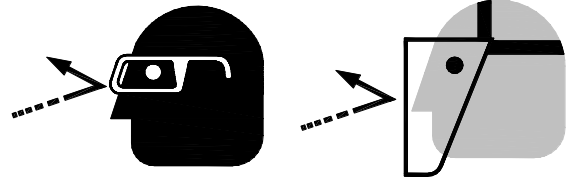


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



PROTECT EYES

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



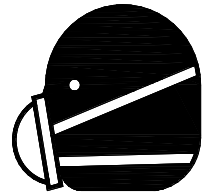
PROTECT AGAINST NOISE

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.



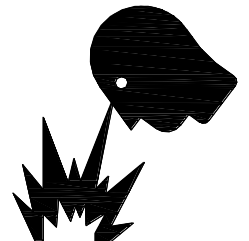
DUST HAZARD

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.



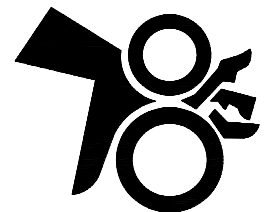
DUST PARTICLES AND IGNITION SOURCES

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



BEWARE OF PINCH POINTS

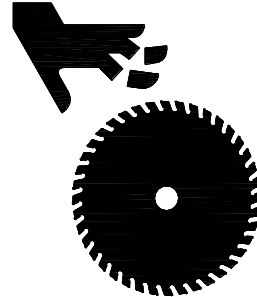
Keep hands and fingers away from the rolls when the machine is in operation. Keep hands and fingers clear of all potential pinch points. These include sprockets and chains along with belts and pulleys.





CUTTING HAZARD

Keep hands and fingers away from the rotating blades or cutters. These rotating blades or cutters can be extremely dangerous if you do not follow proper safety procedures. **NEVER place hands directly over or in front of the blade or cutter. Keep hand at least 6" (150mm) from the cutter while operating.**



Wear Eye Protection



Read Manual



Wear Ear Protection



Wear Respiratory Protection



Hand Crush / Rollers



Do NOT Remove Guard



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**

Dear Valued Customer:

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

Please enjoy your Baileigh machine!Please enjoy it SAFELY!

1. 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. **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.
7. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.



8. **Respiratory Protection.** Wear an approved dust mask or respirator while using this machine. Continued exposure to wood dust can cause allergies or long term respiratory problems.
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 alignment and 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. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
14. **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.
15. **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.
16. Watch for fire and keep a fire extinguisher close by.
17. **DO NOT** touch live electrical components or parts.
18. Turn off power before checking, cleaning, or replacing any parts.
19. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
20. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
21. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
22. **DO NOT** bypass or defeat any safety interlock systems.
23. Keep visitors a safe distance from the work area.
24. **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.



TECHNICAL SPECIFICATIONS

Horsepower / Rotation	1/2 HP (0.375KW), 1 phase; Forward / Reverse
Power	220V 60hz
Range of Speeds	9.5/15/25/38 FPM (3/4.5/7.5/11.5 M/min)
Rollers (Belts)	Φ4" x 2" x 3 pcs (Φ100 x 50 mm x 3 pcs) / Synthetic Rubber
Roller Suspension	.944" (24mm)
Net Weight	55 + 44Lb (25 + 20Kg)
Gross Weight	59 + 49Lb (27 + 22Kg)
Carton for Body	20-1/2" x 18-1/2" x 10-1/4" (520 x 470 x 260 mm)
Carton for Stand	30-3/8" x 9" x 10-1/4" (770 x 230 x 260 mm)

TECHNICAL SUPPORT

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

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



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



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



UNPACKING AND CHECKING CONTENTS

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



WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

Cleaning



WARNING: **DO NOT USE** gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.



CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



Important: This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.





INSTALLATION



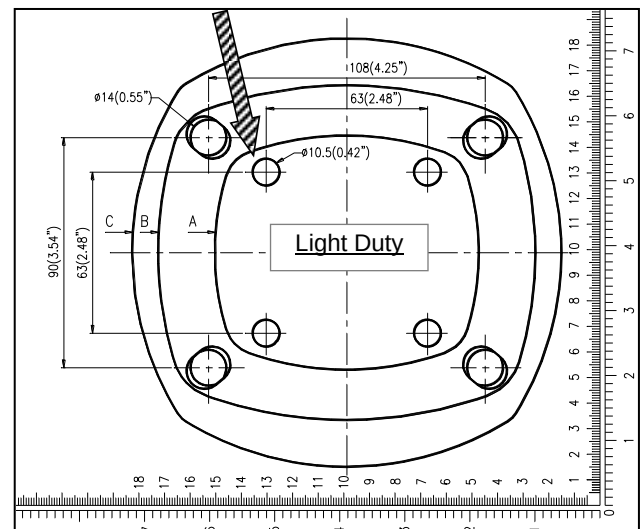
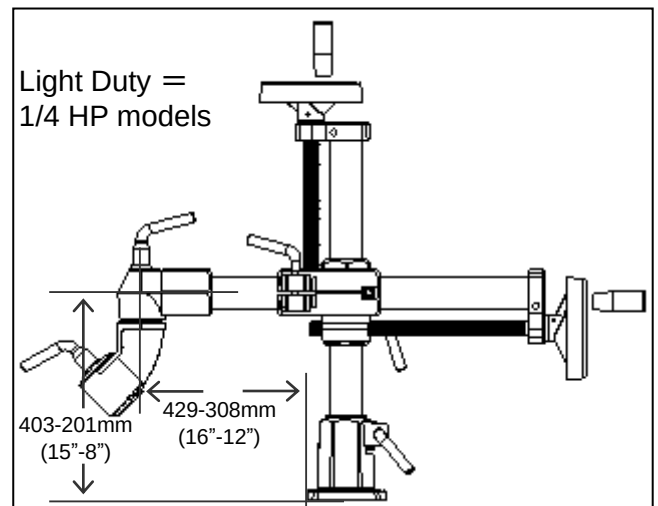
IMPORTANT:

Before installing this device onto a machine, verify that all the installation considerations for that machine have been met and followed.

Locate Mounting and Boring Position

For your boring convenience and accuracy, a 1:1 self-adhesive drilling template is provided and enclosed in the package.

1. Remove the mounting base from packaging.
2. Use it to verify the correct boring position on the drilling template.
3. Prepare 4 sets of bolts, lock washers and if preferred, nuts (not provided).
 - a. Size of bolts is M10.
 - b. Length of bolt will depend upon if you plan to drill and tap, or drill and secure with a nut.
 - i. Drill and tap Equal to the Mounting Base thickness + Tabletop thickness.
 - ii. Drill and nut $\leq$ Mounting Base thickness + Tabletop thickness + Nut thickness.
4. Avoid table ribs and support underneath the table.
5. Use self-adhesive drilling template. Tape it to desired position.
6. Mark the hole centers with a center punch.
7. If drilling and tapping, drill and tap the holes.
8. If drilling and using nuts, drill the holes.
9. Position the base over the holes and secure in place.





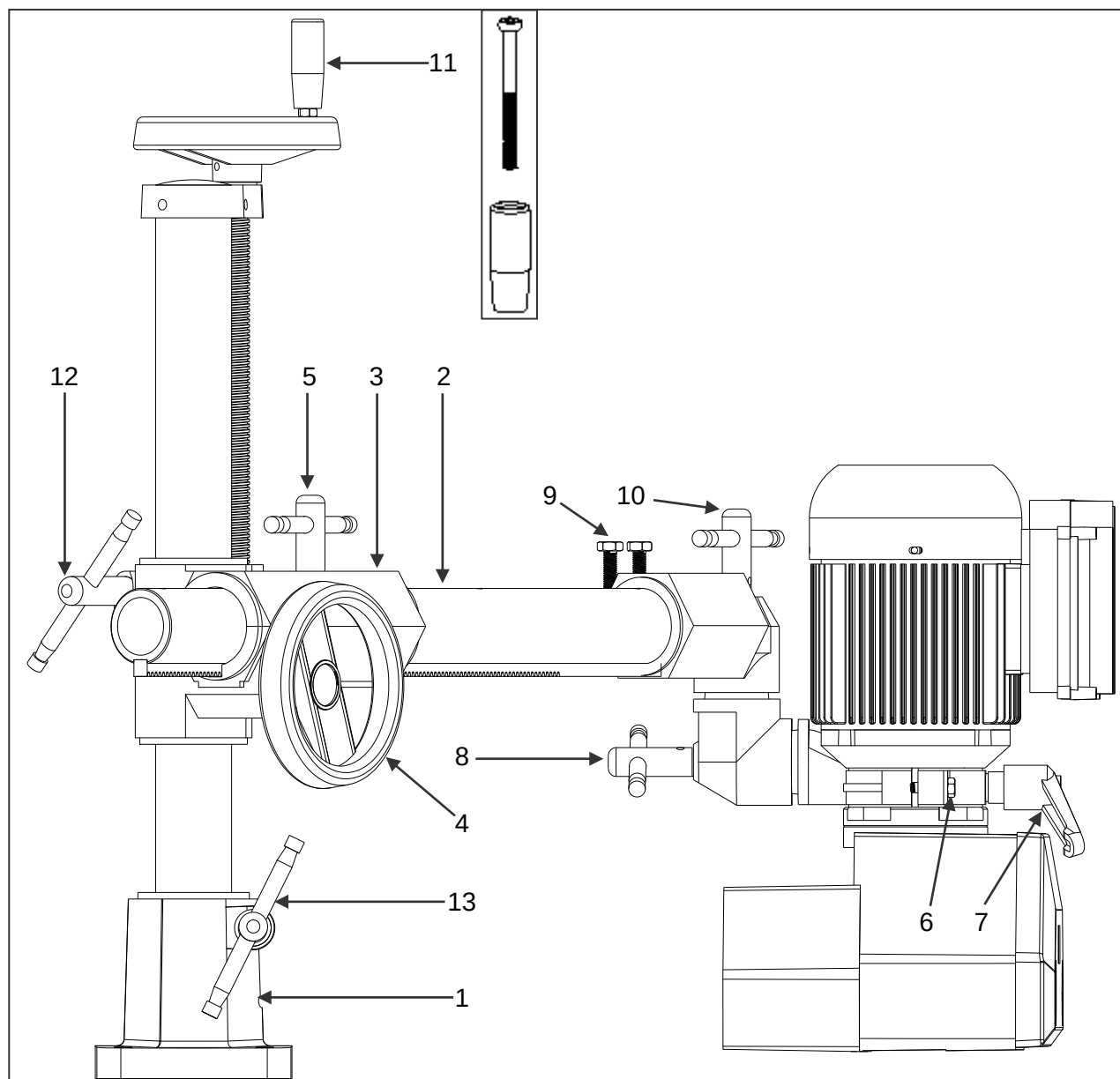
ASSEMBLY AND SET UP



WARNING: For your own safety, DO NOT connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.



Note: Use the part diagram as an additional guide for finding and identifying the parts being assembled, and how they fit.

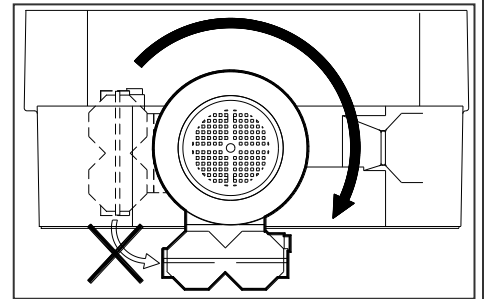




10. Secure Base (1) to the table.

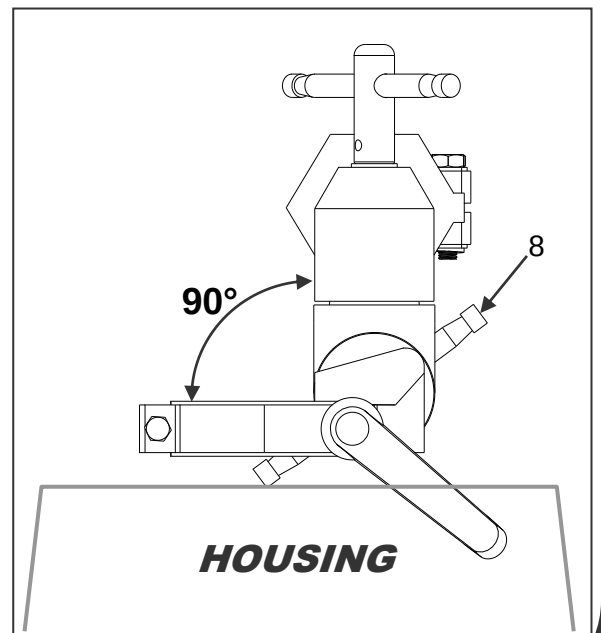
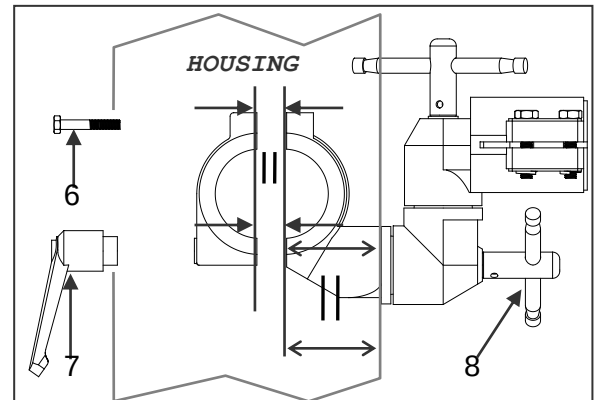
1. Insert Stand Assembly into the Base (1) and lightly secure with T-Handle (13).
2. Install Handle (11) onto Elevation Hand Wheel.
3. Install Overarm (2) into Elevating Bracket (3).
4. Engage the rack gear teeth into the pinion gear teeth and use the Extension Hand Wheel to feed the Overarm into the Elevation Bracket.
5. Lightly tighten -Handle Lever (5).
6. Reposition the motor. The motor is shipped with the switch / terminal box positioned over the feeder frame and requires a 90° rotation before being placed into service

- a. Loosen the 4 mounting screws.
- b. Rotate the motor 90° and tighten the screws to secure the motor.



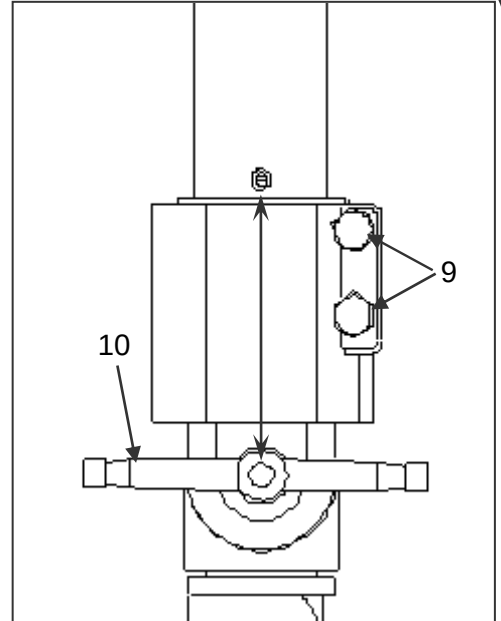
7. Assemble the Control Joint around the motor neck.

- a. Tighten the Screw (6) & Quick Release Lever (7) to keep the gap between the collar halves **EQUALLY SPACED**. This allows the motor and feeder assembly to easily rotate when the Quick Release Lever is loosened without having to loosen the Screw (6).
- b. Position the Motor Clamp Opening to be parallel to the feeder housing.
- c. Loosen T-Handle Lever (8) & rotate the Control Joint upright 90° to the Housing. Tighten the T-Handle Lever (8).

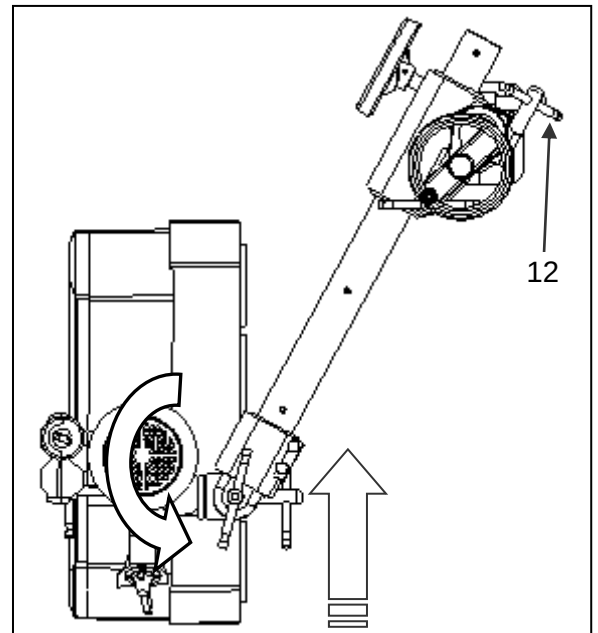




8. Assemble the Feeder and Motor Assembly to the Overarm and secure in place with the screws (9).
- Position the collar onto the Overarm so that the center of the T-Handle Lever (10) is in line with center of the Overarm (2).
 - Move the Feeder to the desired position by loosening the T-Handle Lever (10).
 - Adjust the height using the T-Handle (12) and Hand Wheel (11).
 - Adjust the extension using the T-Handle (5) and Hand Wheel (4).
 - Tighten all T-Handle Lever before use to hold the feeder in the desired location.



Important: There is a certain amount of Play between the Elevating Key and the Bracket Groove. To assure a smooth feeding pull the Feeder toward the IN-FEED direction (CCW), then tighten the T-Handle Lever (12). This will remove the backlash from the gear rack to minimize movement during operation. Do this each time the elevation is adjusted.





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.

Power Specifications

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

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your tools. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.



WARNING: In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.



- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
- Repair or replace damaged or worn cord immediately.

Extension Cord Safety

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

AMP RATING	LENGTH		
	25ft	50ft	100ft
1-12	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.

Power cord connection:

1. Turn the main disconnect switch on the control panel to the OFF position.
2. Unwrap the power cord and route the cord away from the machine toward the power supply.
 - a. Route the power cord so that it will NOT become entangled in the machine in any way.
 - b. Route the cord to the power supply is a way that does NOT create a trip hazard.
3. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
4. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation. Turn the switch OFF when the machine is not in operation.



OPERATION



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

Specific Safety Rules for Power Feeder

- Cutting tools MUST be On and rotating at full speed before feeding.
- DO NOT overload the cutting tool by feeding too fast.
- ALWAYS KEEP hands away from rotating parts.
- PROVIDE support for long stock on out feed end of table.
- STOP the feeder before stopping the cutting tool.
- DISCONNECT power before making repairs or adjustment.

Feeder Adjustment

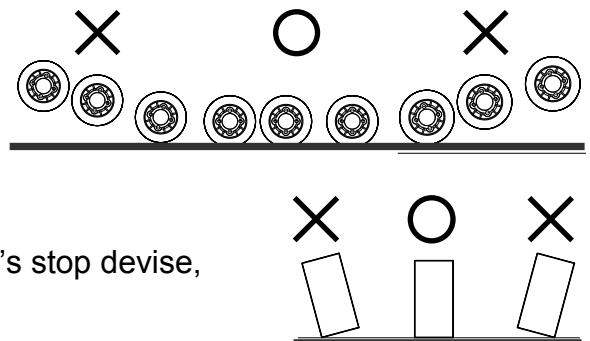


CAUTION: Do Not position the rollers in a location that will or may have the rollers contact the cutting tool. This will damage the roller and tooling.

Feeder operation is largely about positioning of the feeder to provide the proper contact, support and thus feeding pressure.

Feeder adjustment will be correct when:

- All three roller are pressing evenly on the work material.
- The rollers are flatly contacting the work material.
- The feeder is set at a slight angle to the machine's stop devise, fence and or table surface.
- Feed pressure (clearance [interference] from roller to work piece) is set correctly for the material and machine being used.



IMPORTANT: Always verify that ALL Levers are tight after each adjustment and before operation.



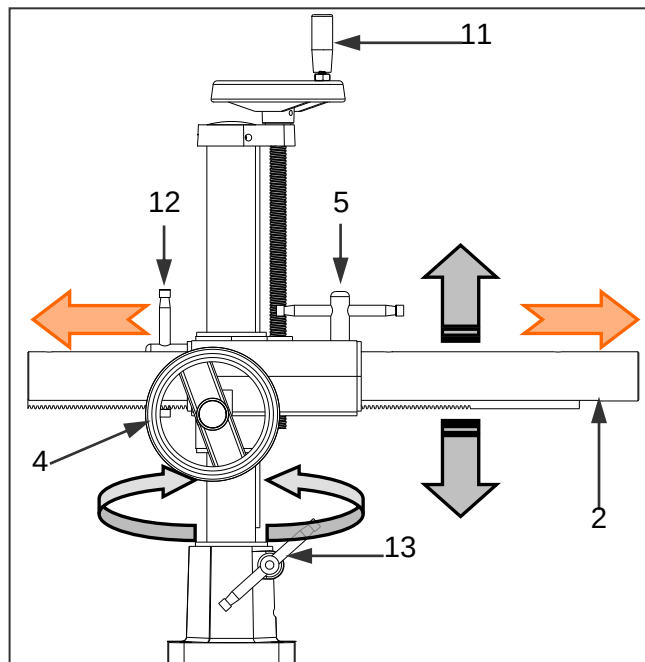
- Disconnect the feeder from the power source before and during all adjustments.

STAND

1. For Overarm (2) rotation ; Loosen the T-Handle Lever (13). Rotate the feeder assembly as desired and lock in position using the T-Handle Lever (13)

2. For Overarm (2) elevation ; Loosen the T-Handle Lever (12) and turn the top Hand Wheel (11). Raise or lower the feeder assembly to the desired height and lock in position using the T-Handle Lever (12).

3. For Overarm (2) extension ; Loosen the T-Handle Lever (5) and turn the side Hand Wheel (4). Extend or retract the feeder assembly to the desired location and lock in position using the T-Handle Lever (5).



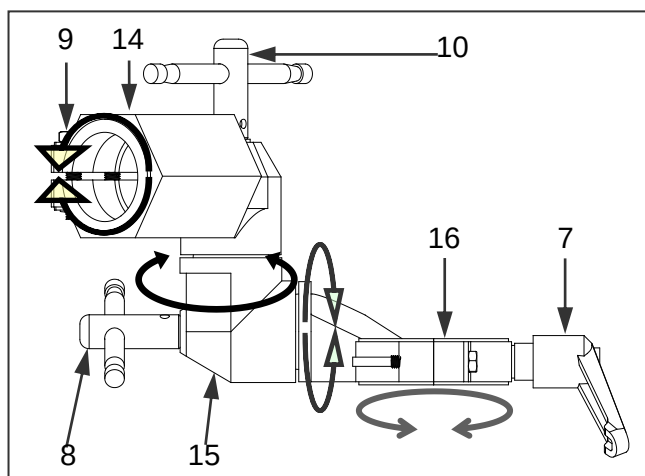
CONTROL JOINT

1. For Arm Bracket (14) rotation ; Loosen the Clamping Screw (9). Rotate the feeder assembly on the Overarm to the desired position and lock in place using the Clamping Screw (9).

2. For Angle Joint (15) rotation ; Loosen the T-Handle Lever (10). Rotate the feeder assembly to the desired angle and lock in position using the T-Handle Lever (10).

3. For Motor Clamp (16) vertical rotation ; Loosen the T-Handle Lever (8). Rotate the feeder and Motor assembly to the desired angle and lock in position using the T-Handle Lever (8).

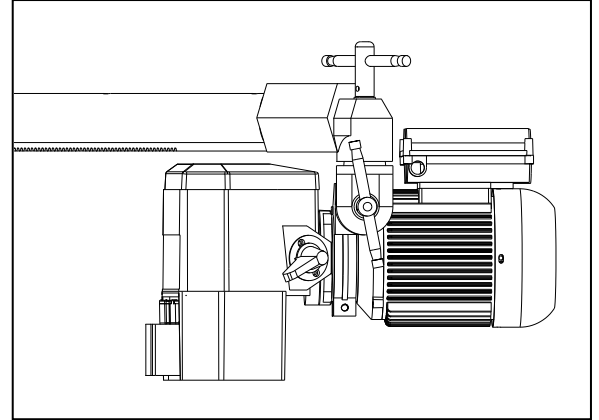
4. For Motor Clamp (16) horizontal rotation ; Loosen the Quick Release Lever (7). Rotate the feeder and Motor assembly within the Motor Clamp to the desired angle and lock in position using the Quick Release Lever (7).





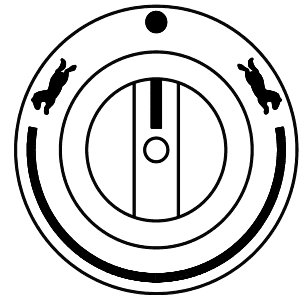
SIDE FEEDING

1. Disconnect the feeder from the power source.
2. Loosen the T-Handle Lever (13), and swing the Feeder off the table.
3. Loosen the T-Handle Lever (8), turn the Feeder 90° to the floor with the Rollers facing toward you. Tighten the T-Handle Lever (8).
4. Loosen the Quick Release Lever (7), turn the Feeder 90° with the Switch Box facing upward. Tighten the Quick Release Lever (7).
5. Loosen the T-Handle Lever (10), push the Feeder to the desired position. Tighten both Levers (10 & 13).
6. Make any final adjustments as needed to obtain proper wheel contact and pressure.
7. Verify that all of the levers and adjustment points are tight and secure before operation.



Feeder Operation

Once the feeder is properly adjusted, the feeder is operated by selected a feed direction. This will start the feed rollers turning the selected direction. Stop the feed rolls by turning the switch to the Off position. Feed the material smoothly and evenly into the rolls until the feeder begins to feed the material.

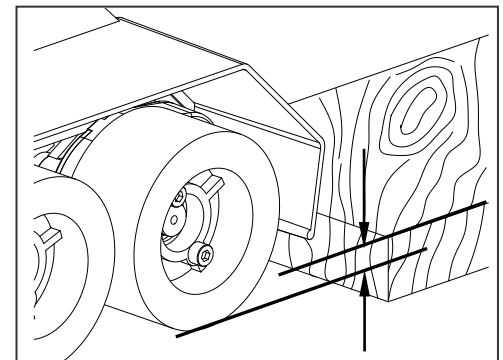
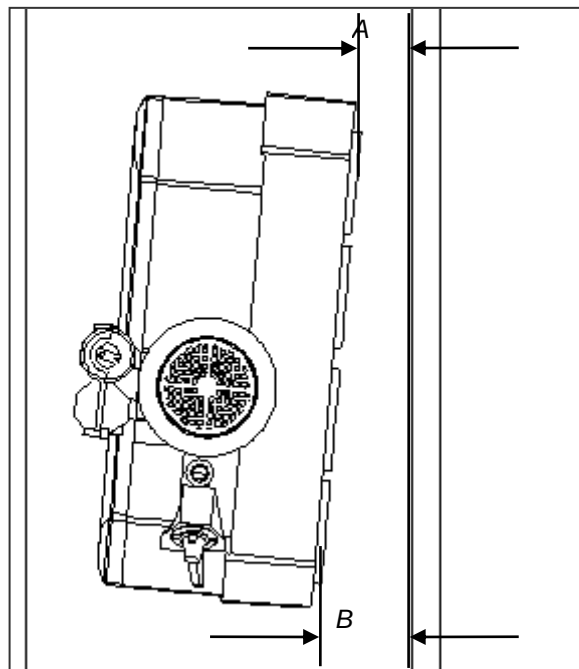
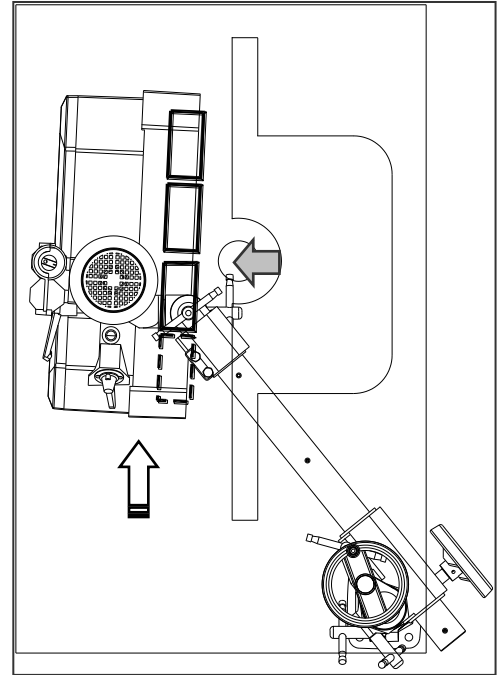




POSITIONING POWERFEEDER ON MACHINES

ON A SHAPER:

- Roller Position in relationship to Cutter
- Feeder Position in relationship to Fence
 $B - A \approx 3/16"$ (4.76mm)
- Feeder Pressure in relationship to Feeding Stock

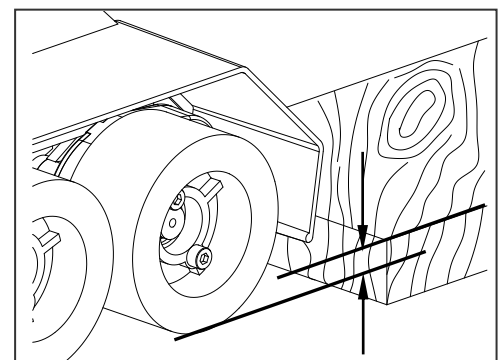
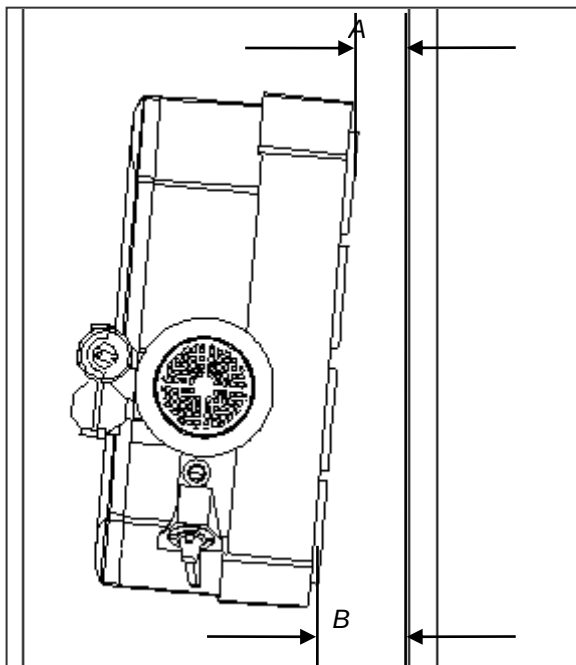
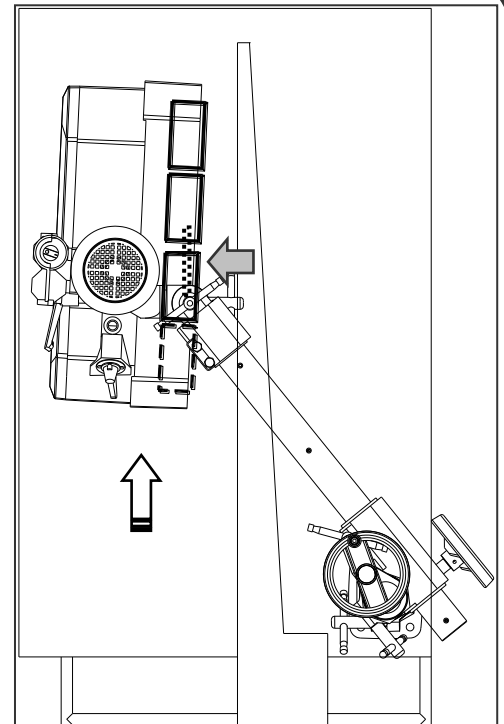


Feed Pressure $\approx 1/8"$ (3 ~ 4 mm)



ON A TABLE SAW:

- Roller Position in relationship to Saw Blade
- Feeder Position in relationship to Fence
 $B - A \approx 1/16''$ (2mm)
- Feeder Pressure in relationship to Feeding Stock

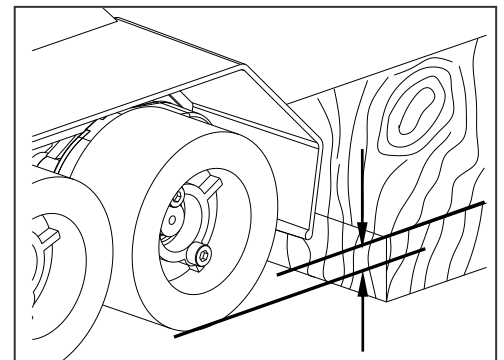
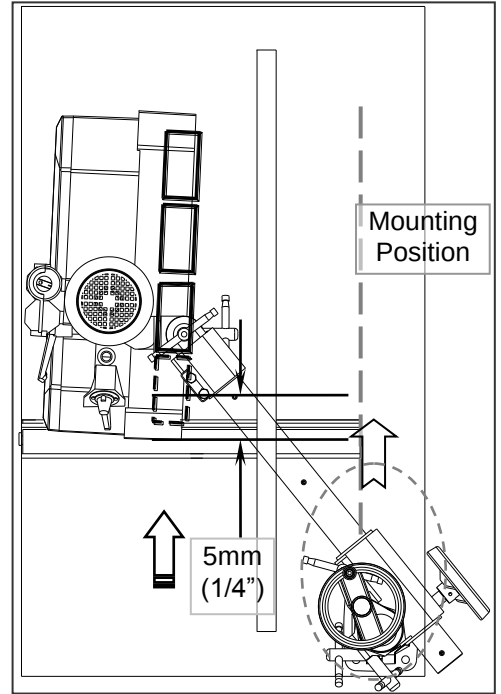
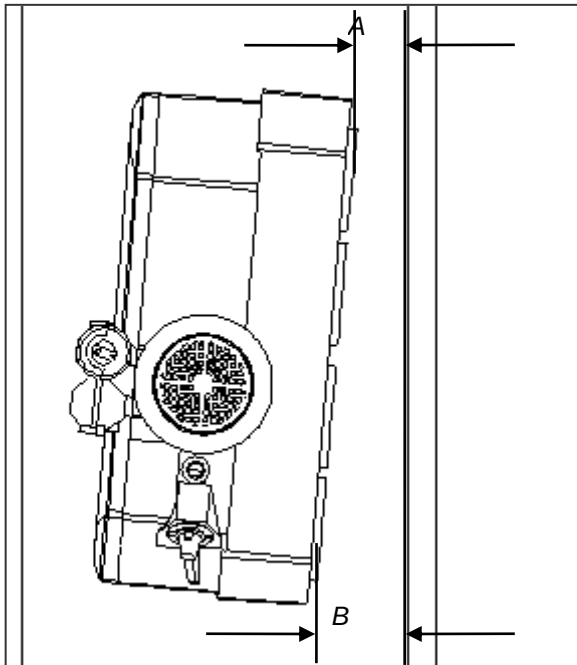


Feed Pressure 3 ~ 4 mm ($\approx 1/8''$)



ON A JOINTER:

- Roller Position in relationship to Cutter Blade
- Feeder Position in relationship to Fence
 $B - A \cong 3/16"$ (4.76mm)
- Feeder Pressure in relationship to Feeding Stock



Feed Pressure, as light as possible



FEED RATE SETTING

Choosing the right feed rate is important to achieve efficiency and quality. It is closely related to the speed of your machine, the sharpness of cutter, the hardness and the thickness of the material to be removed. Listening to the sound of your cutting tool, look (exam) closely at your sample pieces.

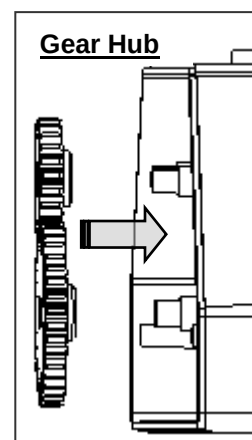
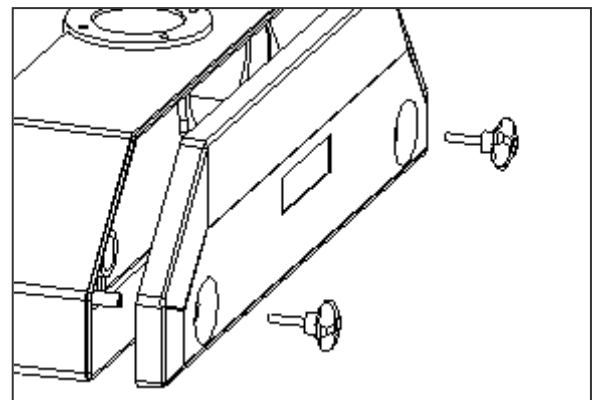
(Feed rate chart below is for reference only.)

Spindle Speed		6000 R.P.M.			8000 R.P.M.			10000 R.P.M.		
Feeding speed Thickness of work piece	Cutters									
										
6 mm		9	15	23	9	15	23	15	23	23
10 mm		8	12	15	8	15	15	12	15	15
20 mm		5	9	12	6	12	12	8	12	12
25 mm		3	5	6	5	6	8	6	8	9

Setting the available feed rate is based upon the gear position. Switching the positons of the gears will produce a different feed rate.

A gear arrangement and feed rate chart is attached to the inside of the gear box cover.

1. Disconnect feeder from power source.
2. Remove the knobs holding the cover to the feeder housing and remove the gearbox cover.
3. Remove the hex nuts and washer and rearrange the gear positions. Keep the sets matched. Do Not interchange gears between sets.
4. Install the gears in to positons to match the desired feed rate. Make sure that the gear hub faces the shaft.
5. Install the washer and hex nuts and tighten.





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

- Do a general cleaning by removing dust and chips from the machine.
- Check and tighten any loose mounting bolts.
- Sharpen or replace any worn or damaged tooling.
- Inspect the power plug and cord.
- Keep area around machine clear of debris.
- Check for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.



Note: When cleaning chips and debris from the machine, use a brush and a shop vacuum. **DO NOT** blow off the machine with compressed air. The force of the compressed air may force chips into critical mechanisms or may inflict injury to yourself or others.



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

Lubrication

Recommended Grease: # 2 GREASE. (Shell – Alvania Grease R2 or equivalents.)

- ROLLERS: Grease every 200hrs (30 days) through fittings, using grease gun.
- GEARS & CHAINS: Lubricate periodically with grease.



Changing Gear Box Oil

Change oil first 200hrs (30 days.)

Change oil every 1000hrs (6 months.)

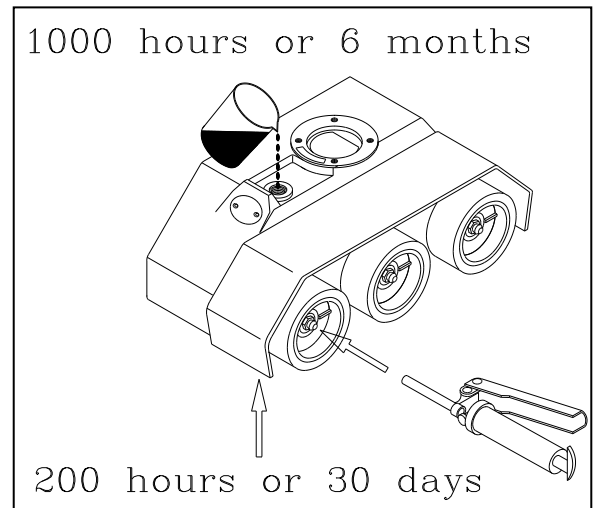
Oil Capacity – 4.4oz (130cc)

Recommended Gear Oil: MOBIL Mobilgear 630, Shell/Omala 150 BP, Energol GR-XP 150, or equivalents.

Above recommendation is based on 8 hours/day.

The oil is drained and filled through the same port.

1. Loosen the column T-Handle Lever (13) and swing the Feeder assembly off the table.
2. Loosen T-Handle Lever (8) on the Angle Joint.
3. Turn the Feeder and remove the oil plug and allow the oil to drain from the gear box.
4. When the oil is fully drained, return the feeder to the upright position and fill with fresh oil.



Roller Replacement

1. Disconnect the feeder from the power source.
 2. Rotate the feeder head so that the wheels are exposed and facing upward.
 3. Remove the screws securing the wheels to the drive shafts.
 4. Replace the tires as needed and the install the roller wheels onto the drive shafts.
 5. Tighten the new Roller assembly to the housing shaft using the 40mm screws.
 6. Tighten the 2 x 20mm screws in the remaining two holes.
- Disregard any slight wobbling of the new wheels. — This will adjust itself during use.
 - Check all screws and re-tighten them after first run.

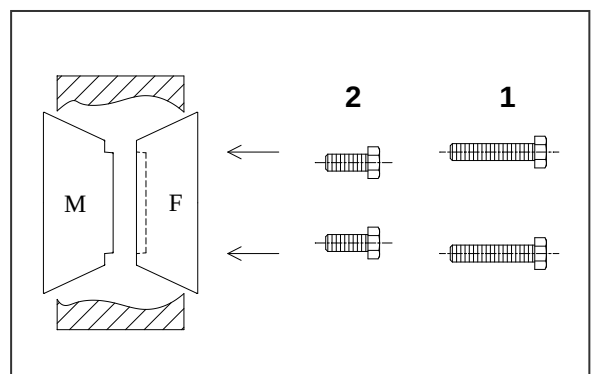
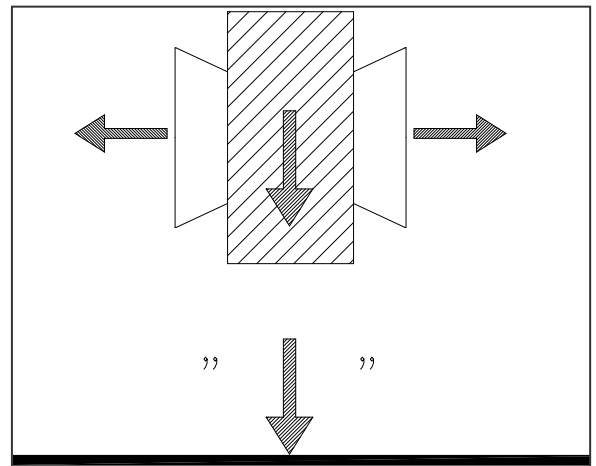
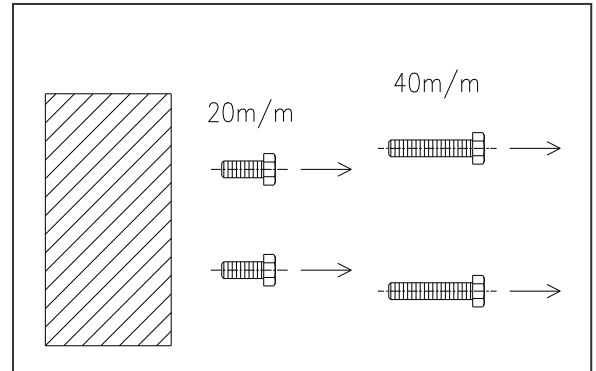


Note: Rotating the roller positions periodically will prolong the usage of rollers.



Roller Tire Replacement

1. Disconnect the feeder from the power source.
 2. Remove the feed wheel(s) from the feeder housing.
 3. Remove the 4 screws securing the two hubs onto the wheel (2 x 20mm and 2 x 40mm)
 4. Force the Roller Wheels out of the hubs by pounding the wheels firmly on a sturdy tabletop.
 5. Assemble the new roller wheel onto the two hub halves. Make note of the Male Hub half (marked M) and the Female Hub half (marked F). The Male half will be to the inside and the Female half to the outside.
 6. Lined up the unthreaded holes of both wheels.
 7. Install the 2 x 40mm screws all the way through the unthreaded holes.
 8. Tighten the new Roller assembly to the housing shaft using the 40mm screws.
 9. Tighten the 2 x 20mm screws in the remaining two holes.
- Disregard any slight wobbling of the new wheels. — This will adjust itself during use.
 - Check all screws and re-tighten them after first run.







Feeder Parts List

Item	Description	Qty.
B076203	Bearing	1
01B	Sprocket Case Kit	1
01B-1	Grease Nipple	1
01B-2	Sprocket Case	1
01B-3	Spring	1
01B-4.	Case Cover	1
02B	Sprocket Case Kit	1
02B-1	Grease Nipple	1
02B-2	Sprocket Case	1
02B-3	Spring	1
02B-4.	Case Cover	1
04B	Chain	3
05B	Tube Kit	3
05B-1	Tube	1
05B-2.	Snap Ring	1
06B	Sprocket Shaft Kit	2
06B-1	Sprocket Shaft	1
06B-2.	Snap Ring	1
07B	Main Sprocket Shaft Kit	1
07B-1	Main Sprocket Shaft	1
07B-2	Flat Washer	1
07B-3.	Nut	1
09B	Housing Frame Kit	1
09B-1	Housing Frame	1
09B-2	Bushing	1
09B-3.	Set Screw	3
11B	Housing Cover	1
13B	Taper Cone Kit	1
13B-1	Taper Cone	1
13B-2	Spring Washer	3
13B-3.	Cap Screw	3
14B	Transmission Kit	1
14B-1	Sprocket	1



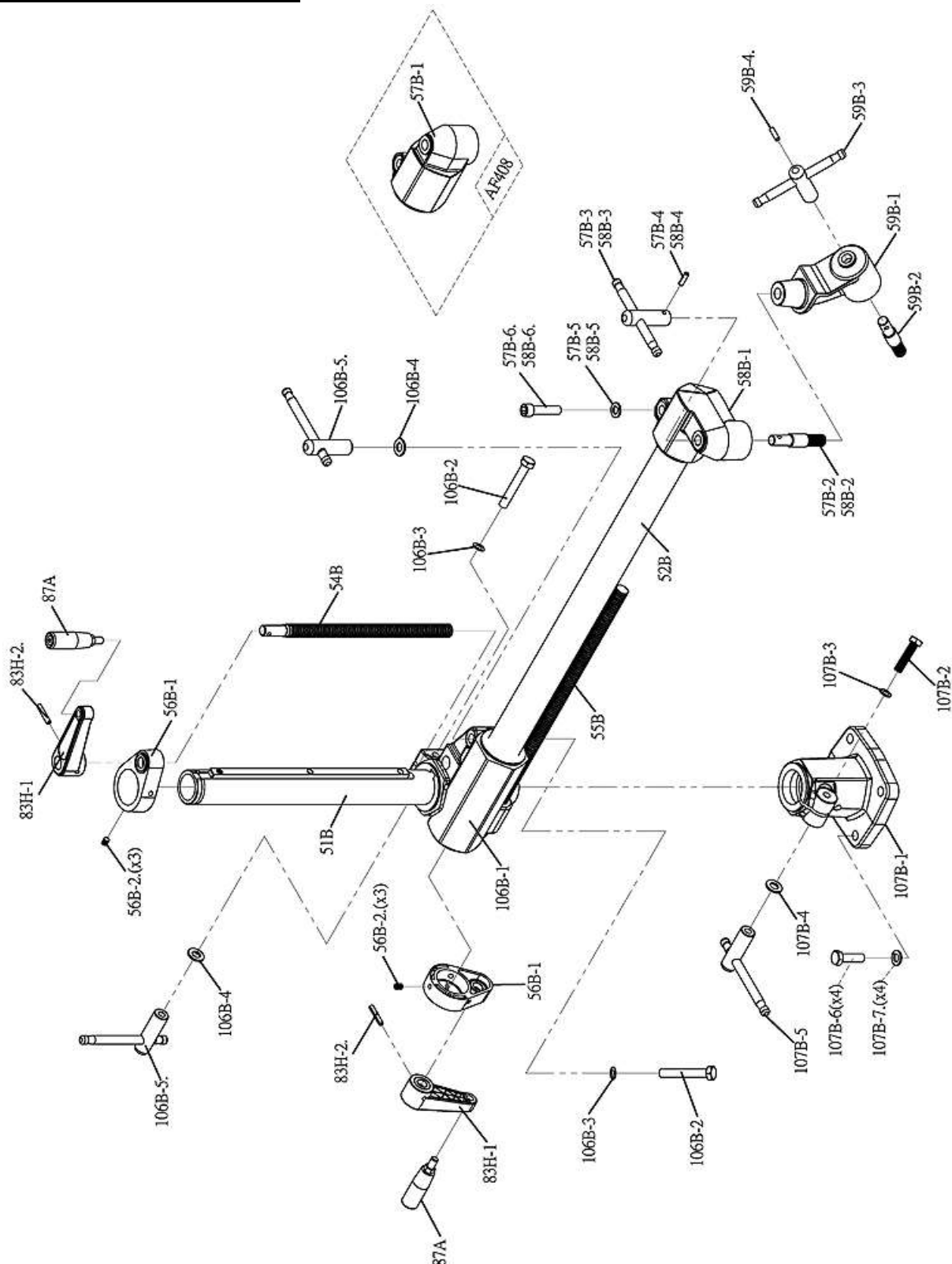
Item	Description	Qty.
14B-2	Double-Sprocket	3
14B-3	Bushing	1
14B-4	Chain	1
14B-5.	Chain	1
16B	Wormgear Shaft Kit	1
16B-1	Worm Gear	1
16B-2	Wormgear Shaft	1
16B-3	Key	1
16B-4	Flat Washer	1
16B-5.	Nut	1
17B	Wormgear Shaft Kit	1
17B-1	Worm Gear	1
17B-2	Wormgear Shaft	1
17B-3	Key	1
17B-4	Flat Washer	1
17B-5.	Nut	1
18A	Knob	2
18B	Wormgear Cover Kit	1
18B-1	Oil Seal	1
18B-2	Wormgear Cover	1
18B-3	Oil Seal	1
18B-4.	Cap Screw	4
19B	Gear Kit	1
19B-1	Gear	1
19B-2.	Gear	1
20B	Gear Kit	1
20B-1	Gear	1
20B-2.	Gear	1
21A	Oil-Cap Kit	1
21A-1	Oil Cap	1
21A-2.	"O" Ring	1
25M1	Motor w/ Switch	1
25M3	Motor w/ Switch	1
26B	Switch Kit	1
46A	Switch Box	1



Item	Description	Qty.
103B	Sprocket Case	1
103B-1	Grease Nipple	1
103B-2	Sprocket Case	1
103B-3	Spring	1
103B-4.	Case Cover	1
108B	Roller Spindle Kit	3
108B-1	Grease Nipple	1
108B-2	Snap Ring	1
108B-3	Roller Spindle	1
108B-4	Spring Washer	1
108B-5.	Hex Screw	1
111B	Roller Base Kit	3
111B-1	Roller Supporter	1
111B-2	Sprocket	1
111B-3	Cap Screw	2
111B-4	Lock Washer	2
111B-5	Cap Screw	2
111B-6.	Spacer	1
RO101	Roller	3



STAND PARTS DIAGRAM





Stand Parts List

Item	Description	Qty.
51B	Vertical Column Kit	1
52B	Overarm Kit	1
54B	Elevating Screw	1
55B	Extension Screw	1
56B	Column Cap Kit	2
56B-1	Column Cap	1
56B-2.	Set Screw	3
57B	Overarm Cone Kit	1
57B-1	Overarm Cone	1
57B-2	Stud	1
57B-3	Handle	1
57B-4	Lock Pin	1
57B-5	Spring Washer	1
57B-6.	Cap Screw	1
58B	Overarm Cone Kit	1
58B-1	Overarm Cone	1
58B-2	Stud	1
58B-3	Handle	1
58B-4	Lock Pin	1
58B-5	Spring Washer	1
58B-6.	Cap Screw	1
59B	Swivel Cone Kit	1
59B-1	Swivel Cone	1
59B-2	Stud	1
59B-3	Handle	1
59B-4.	Lock Pin	1
83H	Handle Kit	2
83H-1	Handle w/ Bushing	1
83H-2.	Lock Pin	1
87A	Handle-Grip	2
106B	Elevating Bracket Kit	1
106B-1	Elevating Bracket	1
106B-2	Hex Screw	2



Item	Description	Qty.
106B-3	Lock Washer	2
106B-4	Flat Washer	2
106B-5.	Handle	2
107B	Base Kit	1
107B-1	Column Base	1
107B-2	Hex Screw	1
107B-3	Lock Washer	1
107B-4	Flat Washer	1
107B-5	Handle	1
107B-6	Hex Screw	4
107B-7.	Spring Washer	4

NOTES



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

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

WWW.BAILEIGH.COM

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

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

BAILEIGH INDUSTRIAL LTD. UNIT 1 FULLWOOD CLOSE

SWIFT VALLEY INDUSTRIAL ESTATE, RUGBY

WEST MIDLANDS, CV21 1QH UNITED KINGDOM

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

WWW.BAILEIGH.CO.UK

BAILEIGH INDUSTRIAL PTY. LTD.

P.O BOX 1573, 126 MELROSE DRIVE TULLAMARINE,

VIC 3043 AUSTRALIA

PHONE: 61.383.743.888

WWW.BAILEIGH.COM.AU