



OPERATOR'S MANUAL

Metal Working



PORTABLE BEVELING MACHINE MODEL: CM-10P

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THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial Holdings LLC. 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 an 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 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator 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 attorney 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 Holdings LLC 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 Holdings LLC reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at sales@baileigh.com



INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial Holdings LLC 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
- Setup 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 Holdings LLC and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any modifications.



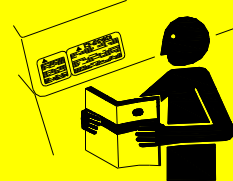
Note: This symbol refers to useful information throughout the manual.



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

DANGER: Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING: Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION: Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE: Indicates a situation which, if not avoided, could result in property damage.

DANGER

WARNING

CAUTION

NOTICE

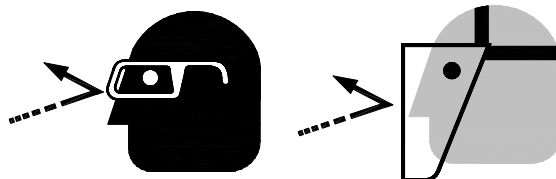


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



PROTECT EYES

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



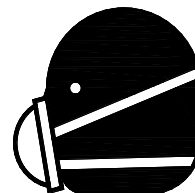
PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as earmuffs 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.



CALIFORNIA PROPOSITION 65

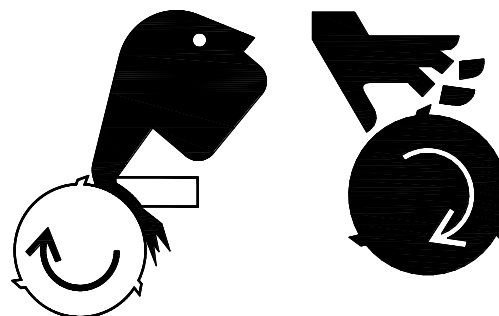
WARNING: Cancer and Reproductive Harm.
www.P65Warnings.ca.gov



ROTATING BLADES – CUTTER – ENTANGLEMENT HAZARD

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

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





SAFETY PRECAUTIONS



Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard will not make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



**WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN
SERIOUS PERSONAL INJURY**

Dear Valued Customer:

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

PLEASE ENJOY YOUR BAILEIGH MACHINE!PLEASE ENJOY IT SAFELY!

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel can operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
5. **Keep work area clean.** Cluttered areas invite injuries.
6. **Overloading machine.** By overloading the machine, you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
7. **Dressing material edges.** Always chamfer and deburr all sharp edges.



8. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machine's rated capacity.
9. **Use the right tool for the job.** **DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.
10. **Dress appropriately.** **DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. **Use eye protection.** Always wear ISO approved protective eye wear when operating machinery. Wear a full-face shield if you are producing metal filings. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specification. Use of eye wear which does not comply with ANSI Z87.1 specification could result in severe injury from breakage of eye protection.
12. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
13. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
14. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. **Observe work area conditions.** **DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
16. **Blade adjustments and maintenance.** Always keep blades sharp and properly adjusted for optimum performance.
17. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
18. Keep visitors a safe distance from the work area.
19. **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.
20. **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.
21. **Turn off** power before checking, cleaning, or replacing any parts.
22. Be sure **all** equipment is properly installed and grounded according to national, state, and local codes.
23. Keep **all** cords dry, free from grease and oil, and protected from sparks and hot metal.
24. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!** **DO NOT** touch live electrical components or parts.



TECHNICAL SPECIFICATIONS

Brushless Servo Motor	1hp. 1Ph, 750W output (0.75Kw)
Cutter Speed	5000 RPM max. (Variable)
Chamfer @ 45 deg.	0 - .393" (0 – 10mm)**
Power Requirements	110V / 60Hz. / 10A
Shipping Dim. (L x W x H)	20" x 12" x 12" (508 x 305 x 305mm)
Shipping Weight	20 lbs. (9.28kgs.)

** Maximum 0.16" (4mm) per pass.

Machine Features

- Portable
- Includes Bench Mount
- Brushless Motor Technology
- Light Weight
- Indexed Cutter
- Breakaway Cord
- 3/8" (9.5mm) Capacity**

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:

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

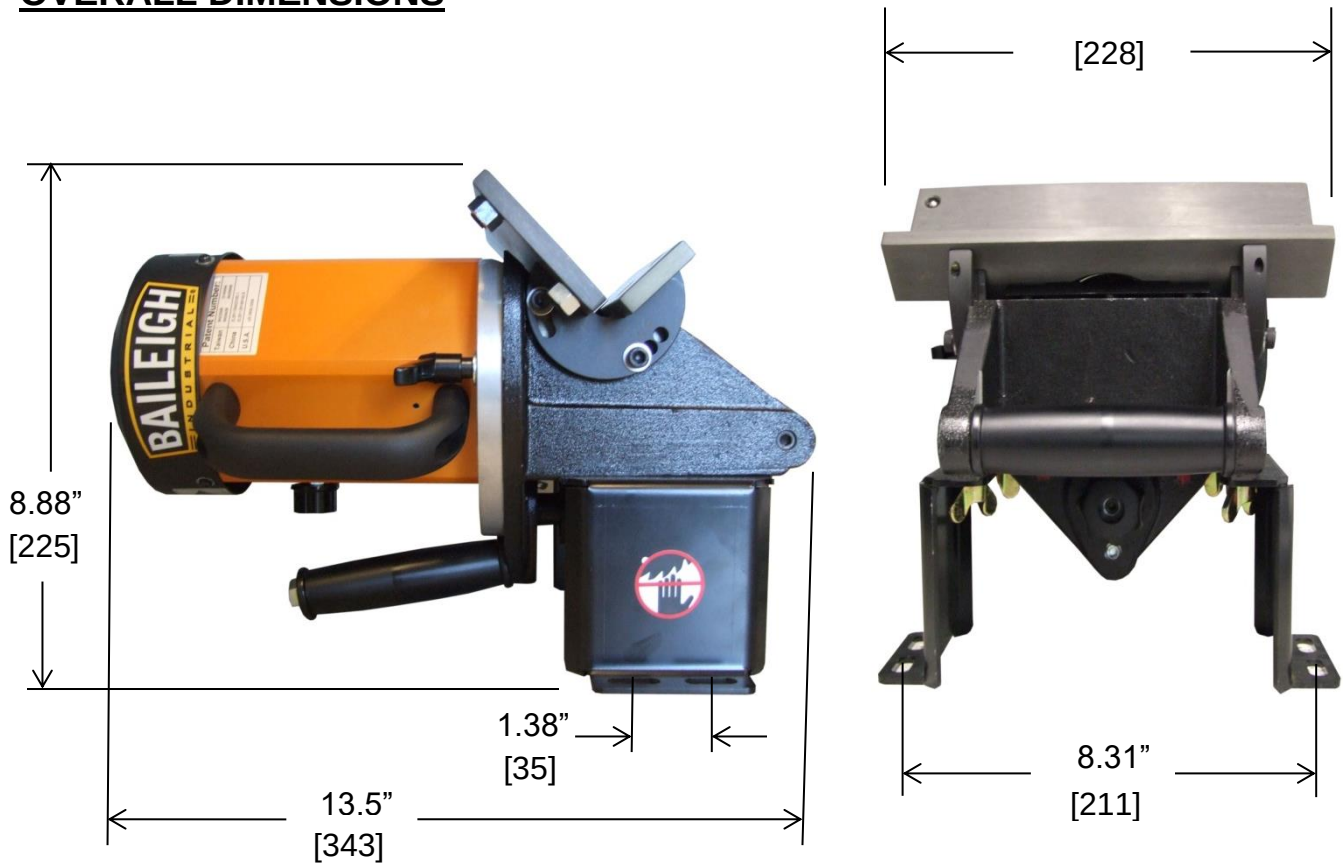
- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, worktables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

If you intend to mount the Baileigh machine on a workbench be aware of the following:

- Overall weight of the machine.
- Weight of material being processed.
- Make sure the workbench is properly reinforced to support the total weight.
- The strongest mounting option is where the holes are drilled all the way through the workbench and the machine is secured with bolts, washers, and nuts.



OVERALL DIMENSIONS





GETTING TO KNOW YOUR MACHINE





Item	Description
1	Cutter Tool
2	Cutter Tool Insert (5 required)
3	Power Cable – 15' (4.57M)
4	Adjustable Handle
5	Small Chamfer Guide
6	Large Chamfer Guide
7	Variable Speed Control
8	Rear Handle
9	Cutting Tool Depth Knob
10	Mounting Bracket
11	Wing Nut Stud
12	Adjustable Ball Pins
13	Front Handle Grip
14	Motor Base
15	Brushless Servo Motor

Carton Contents

1. M3 L-hex Wrench
2. M8 L-hex Wrench
3. M24 x 27 Double Open-End Wrench
4. M22 Open-End Wrench
5. M32 Open-End Wrench



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 machine is wired for 110 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

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 an amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machines. 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 machine.
- 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 machine 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 qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine 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 in 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.
5. 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 to protect from burrs and sharp edges. When handling large heavy materials make sure they are properly supported.

The Baileigh **CM-10P** Beveling Machine can be used as a portable or as a desktop beveller.



WARNING: NEVER place your hands or fingers over the cutter when feeding material.

Portable Beveling

The **CM-10P** beveling machine can be set for 15°, 30°, and 45° bevel cuts. When used as a portable beveller, set the angle of bevel required. Then set the cutter for the depth of material to be removed from the piece part. Set the adjustable ball pins so the bevel machine glides along the piece part with minimal effort. **Before starting the cut, put on proper eye and hearing protection.**

BE SURE the speed knob is **OFF** before reconnecting the power.

Turn on and set the desired speed with the speed control knob. The Power indicator light will light **RED**. Grasp the beveling machine with both hands and move into the piece part to start the cut.



Note: Use readily available engineering tables and charts to determine rpm and feed rates. Read the chips. Proper feed and rpm rates will produce chips that are uniform in size and blue but not burnt.



Desktop Beveling

Secure the beveling machine base to the desktop using the slots provided.

The **CM-10P** beveling machine can be set for 15°, 30°, and 45° bevel cuts. When used as a desktop beveller, set the angle of bevel required. Then set the cutter for the depth of material to be removed from the piece part. Set the adjustable ball pins so the piece part glides along the chamfer guides with minimal effort. **Before starting the cut, put on proper eye and hearing protection.**

BE SURE the speed knob is OFF before reconnecting the power.

Turn on and set the desired speed with the speed control knob. The Power indicator light will light **RED**. Grasp the piece part with both hands and move into the cutter to cut the desired chamfer.



Note: Use readily available engineering tables and charts to determine rpm and feed rates. Read the chips. Proper feed and rpm rates will produce chips that are uniform in size and blue but not burnt.



ADJUSTMENTS

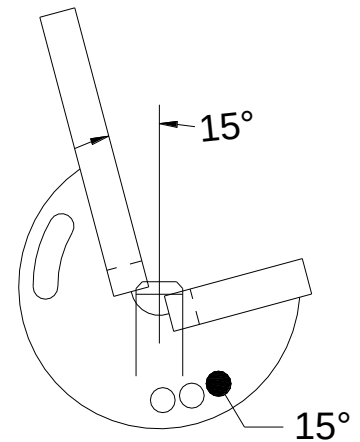
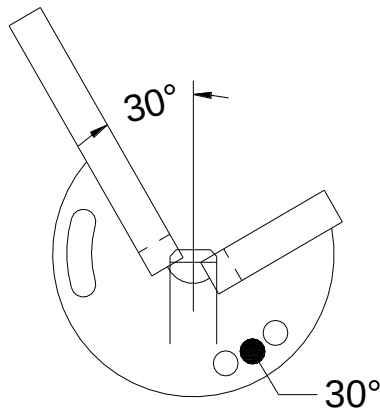
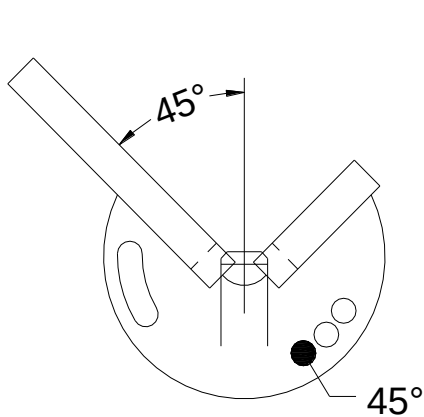
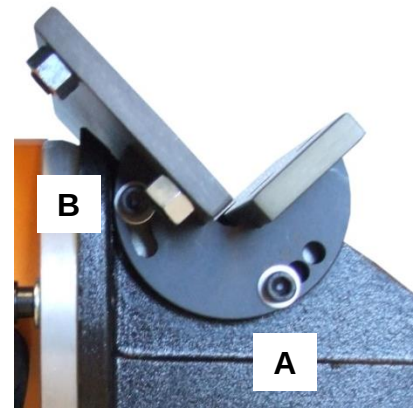


WARNING: Make sure the electrical power is OFF before making any adjustments on the beveling machine.

Setting The Chamfer Angles

To change the chamfer angles you must rotate the chamfer guides.

1. Loosen cap screw (B) on both ends of the chamfer guides.
2. Remove cap screw (A) and the flat washer from both ends. Rotate the chamfer guide to the desired angle setting and re-install the flat washers and cap screws (A).
3. Tighten (A) and (B) securely on both ends.



Shown above are the three angle settings available.



Setting Depth Of Cutter

The Baileigh **CM-10P** is able to chamfer 1/4" (6.35mm) at 45° from the front width and 3/8" (9.5mm) at 45° from its side width.\

1. Loosen the two adjustable handles (**A**).
2. To extend the cutter for more material removal, rotate the knob (indicated with the arrow) counter clockwise (**ccw**).

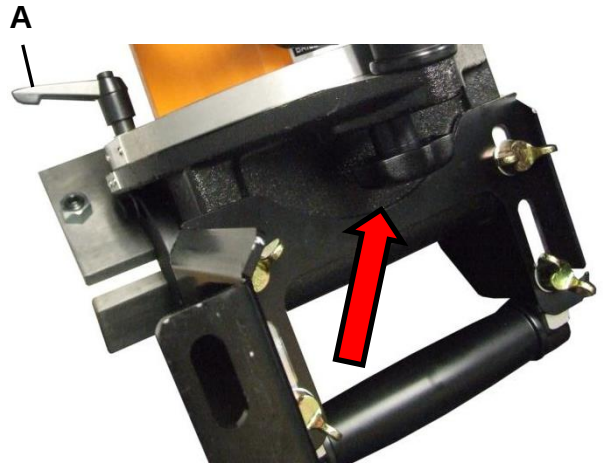


IMPORTANT: DO NOT set the depth to remove more than 0.16" (4mm) on the first pass. If a deeper chamfer is desired, complete the first pass at 0.16" (4mm) and then set the depth and complete the second pass.

3. To retract the cutter for less material removal, rotate the knob clockwise (**cw**).
4. With the cutter at the desired depth, tighten the adjustable handles (**A**).



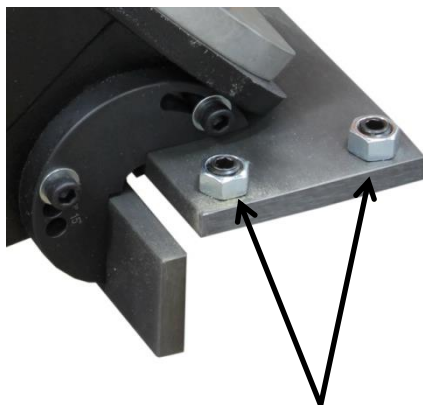
Note: Pulling up on the handle disengages it, while the insert or stud remains stationary, allowing you to adjust the handle to the desired position.



Adjustable Ball Pins

The three ball pins on the large chamfer guide, when adjusted properly, allow the piece part to slide easily for a smooth chamfer.

5. To adjust, first loosen the hex nut on the back side.
6. Using a hex allen wrench turn the setscrew clockwise (**cw**) to extend the ball out. Turn counter clockwise (**ccw**) to retract the ball.
7. When satisfied with the adjustment, re-tighten the hex nut.





Replacing Cutter Inserts

The cutter on the **CM-10P** bevelling machine has (5) cutting inserts that are indexable and replaceable. This means that each insert can be rotated to one of four sharp edges.

1. To have access to the cutter, remove the two adjustable handles.



Note: Pulling down on the handle disengages it, while the insert or stud remains stationary, allowing you to remove each handle.

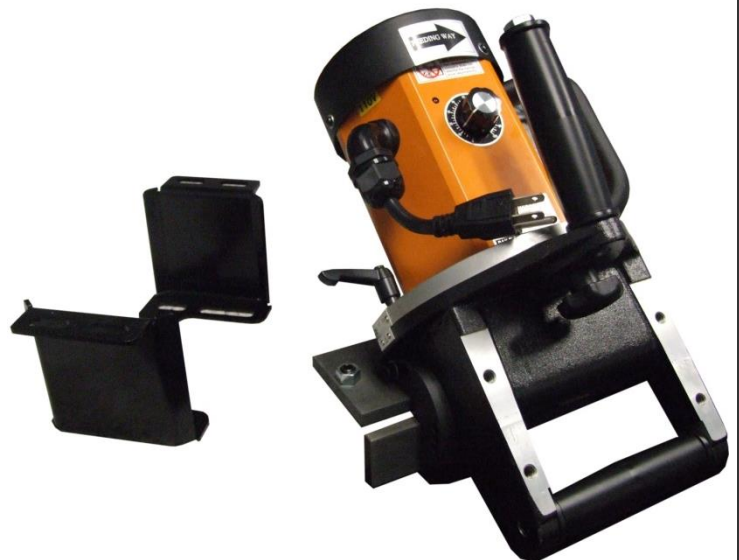
2. With the handles removed, carefully lift off the mounting bracket assembly to expose the cutter as shown at right.
3. To remove an insert from the cutter, loosen and remove the allen set screw. Lift the insert from the groove and replace with a new one. Re-install and tighten the set screw.
4. To present a new cutting edge, remove the set screw and rotate the insert. Re-install and tighten the set screw.



Removing The Mounting Bracket

When using the **CM-10P** in the position as shown in the photo at right, the mounting bracket can be removed if desired.

1. Take out the (four) wing nut studs and lift off the bracket.
2. Re-attach bracket when using as a desktop beveller.





Push Tray

The push tray can be used when beveling the end of a bar (as an example).

1. Set the height of the cutter.



Note: *DO NOT* set the cutter higher than the slot in the push tray will allow.

2. Note the direction arrow on the tray. Always push into the cutter moving from left to right.



LUBRICATION AND MAINTENANCE



WARNING: Make sure the electrical power is Disconnected 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.

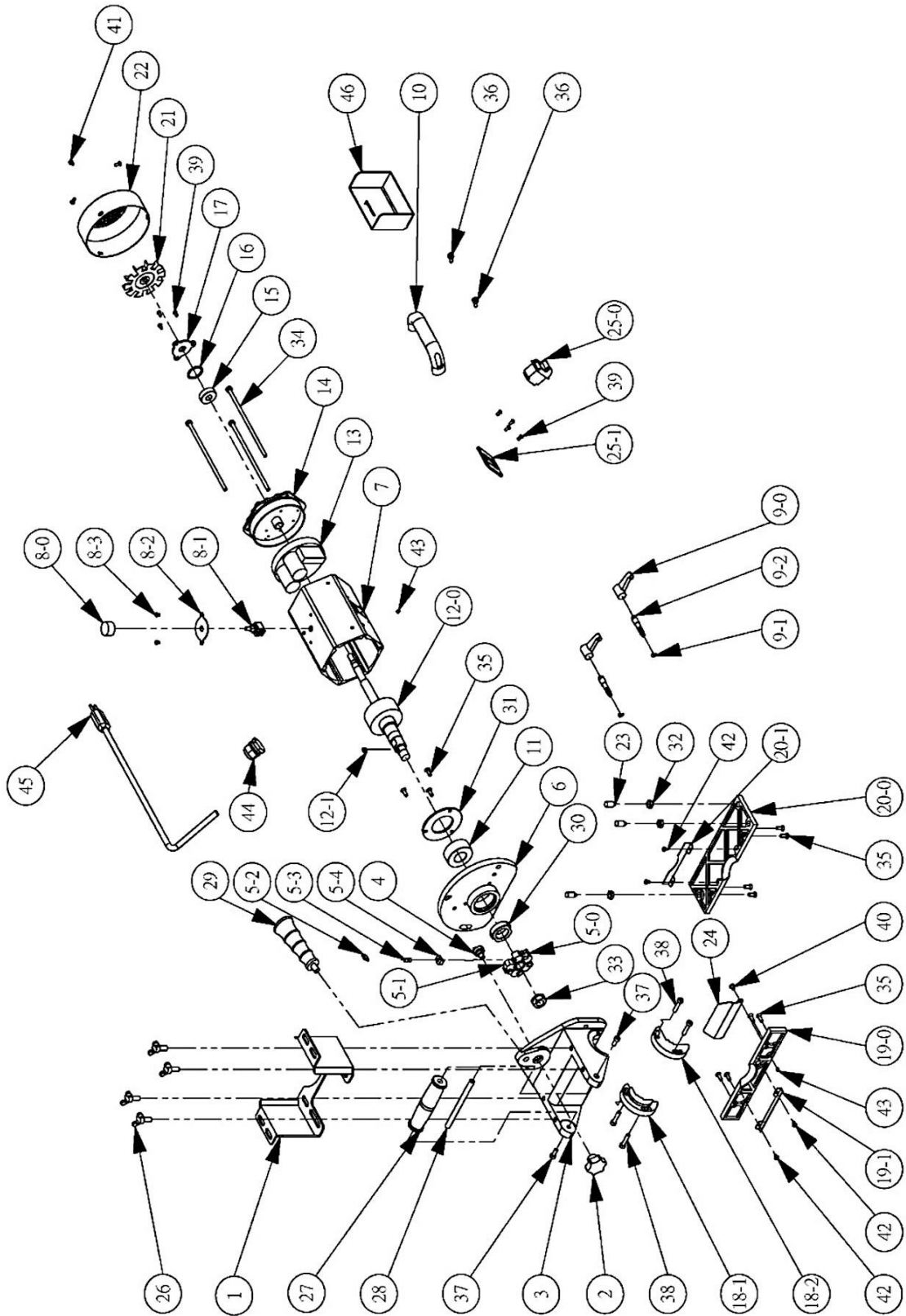
- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.



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



PARTS IDENTIFICATION DRAWING





Parts Identification List

Item	Part No.	Description	Qty
1	CM10P-1	PEDESTAL	1
2	CM10P-2	DEPTH ADJUST NUT	1
3	CM10P-3	CUTTER COVER	1
4	CM10P-4	ECCENTRIC WHEEL	1
5-0	CM10P-CM05-1	CUTTERHEAD SET (WITH BLADES)	1
5-1	CM10P-5	CUTTERHEAD (NO BLADES)	1
5-2	CM10P-CM05-2	CUTTER BLADE	5
5-2-R3	CM10P-5-R3	CUTTER BLADES R3	5
5-2-R5	CM10P-5-R5	CUTTER BLADES R5	5
5-3	CM10P-5-3	CUTTERHEAD SCREW	5
5-4	CM10P-5-4	BLADE PRESS BLOCK	5
6	CM10P-6	FRONT MOTOR ENDSHIELD	1
7	CM10P-7	MOTOR HOUSING WITH STATOR WINDING	1
7A	CM10P-7A	MOTOR ASSEMBLY	1
8	CM10P-8	SPEED ADJUST NUT	1
8-1	CM10P-8-1	VARIABLE RESISTOR (Including wire)	1
8-2	CM10P-8-2	VR PLATE	1
8-3	CM10P-8-3	SOCKET HD BUTTON SCREW M4-0.7X6	2
9-0	CM10P-9	LOCK HANDLE	2
9-1	CM10P-9-1	E-RETAINING RING, EXT E5	2
9-2	CM10P-9-2	LOCK HANDLE SCREW M8	2
10	CM10P-10	U-HANDLE	1
11	CM10P-11	BALL BEARING 5205ZZ	1
12-0	CM10P-12	MOTOR SHAFT	1
12-1	CM10P-12-1	FLAT KEY, DBL RD HD 5X5X10 mm	1
13	CM10P-13	MOTOR DRIVER	1
14	CM10P-14	REAR MOTOR ENDSHIELD	1
15	CM10P-15	BALL BEARING 6201ZZ	1
16	CM10P-16	O-RING (2532)	1
17	CM10P-17	BEARING COVER	1
18-1	CM10P-18-1	GUIDE BASE B	1
18-2	CM10P-18-2	GUIDE BASE A	1
	CM10P-18-3	Optional guide base - Left - Slotted for variable angles	1



Item	Part No.	Description	Qty
	CM10P-18-4	Optional guide base - Right - Slotted for variable angles	1
19	CM10P-19	SMALL GUIDE PLATE	1
19-1	CM10P-19-1	SMALL SIDE PLATE	1
20	CM10P-20	LARGE GUIDE PLATE	1
20-1	CM10P-20-1	LARGE SIDE PLATE	1
21	CM10P-21	FAN	1
22	CM10P-22	FAN COWL	1
23	CM10P-23	STEEL BEAD SCREW M10	3
24	CM10P-24	SAFETY COVER	1
25-0	CM10P-25	POWER SWITCH	1
25-1	CM10P-25-1	SWITCH PLATE	1
26	CM10P-26	WING SCREW M8X20	4
27	CM10P-27	HANDLE	1
28	CM10P-28	HANDLE SHAFT	1
29	CM10P-29	RUBBER HANDLE	1
30	CM10P-30	BEARING ID NUT	1
31	CM10P-31	BEARING OD RING	1
32	CM10P-32	HEX NUT M10-1.5	3
33	CM10P-33	HEX NUT M16-1.5	1
34	CM10P-34	HEX CAP SCREW M6-1.0X170	3
35	CM10P-35	FLAT HEAD SOCKET SCREW M5-0.8X14	11
36	CM10P-36	SOCKET HEAD CAP SCREW M5-0.8X14	2
37	CM10P-37	SOCKET HEAD CAP SCREW M6-1.0X14	2
38	CM10P-38	SOCKET HEAD CAP SCREW M6-1.0X25	4
39	CM10P-39	SOCKET HEAD BUTTON SCREW M4-0.7X8	7
40	CM10P-40	SOCKET HEAD BUTTON SCREW M5-0.8X6	1
41	CM10P-41	SOCKET HEAD BUTTON SCREW M4-0.7X8	3
42	CM10P-42	SOCKET HEAD BUTTON SCREW M4-0.7X6	4
43	CM10P-43	SOCKET SET SCREW M5-0.8X5	2
44	CM10P-44	CABLE GLAND MG20A	1
45	CM10P-45	CABLE WITH PLUG 3x14AWG SJT 300V	1
46	CM10P-46	SAFETY PLATE	1
47	CM10P-SB	HALL SIGNAL ELECTRONAL BOARDS	1



TROUBLESHOOTING



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

FAULT	PROBABLE CAUSE	REMEDY
Red Power Light Will Not Light When Speed Control Is Turned On.	Power cable not plugged in.	Plug in the power cable.
	No power at the outlet	Reset breaker or have qualified electrician check wiring.
Poor cut	Dull or broken cutter insert(s)	Replace dull or broken insert(s)
	Speed too fast or too slow for material type.	Adjust speed to improve cut.
	Removing too much material.	Take off smaller amount of material in several passes.



NOTES

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