

Baileigh CNC Brake Press

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| Description | CNC Press Brake- Baileigh BP-3305CNC |
| Size / Horse Power | 63" x 7" table / 33 Ton / 4HP main 1/2HP back gauge |
| Power source | 220V 3 Phase |
| Uses | Bending and forming sheet metals |

Safety Precautions

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| Hazards |
| Electrical Shock |
| Pinch and/or Crush |
| Abrasions/Sharp Edges |
| Quick Moving Material- rapid upward motion of material during bending/forming operation can contact operator |
| Training |
| Shop Safety Fundamentals |
| Site Specific Training |
| Protective Equipment |
| Cut resistant gloves |
| Safety glasses |
| Light curtain- installed on machine |



Operation

Startup

1. Put on PPE listed above
2. Ensure work area is clean and free of obstacles
3. Make necessary adjustments for safe operation
 - a. Material supports, back gauge, punch, and die configurations
4. Inspect the tool for damage, proper fluid levels, and obstructions to operations
5. Using the control key, turn to the "ON" position and wait for display to load
6. Press the "PUMP ON" button to engage the pump, the light should be green
7. Adjust bend parameters to desired settings and allow machine to complete adjustments before operating
8. Place material so it is resting on the material supports on the front of the machine and contacting the back gauges
 - a. If the piece is too large for one operator, use a second operator to assist with material handling
9. Keep hands below material, operators behind/to the side of and not overlooking material

Shutdown

1. Return machine to the setup page and press in raised position
2. Remove all materials from the machine
3. Switch machine off by turning the control key to the "OFF" position

Control Key Switch



Pump Switch

Adjustments

Back Gauge

1. With the machine on, use the control panel to adjust the XP value to the desired setting
2. Press the green “Start/Run” button and move the punch to the full up position
 - a. The machine will automatically adjust the back gauge to the set position once the punch is in position
3. If no additional adjustments are needed, complete the bending operation

Punch/Angle Adjustments

1. With the machine on, use the control panel to adjust the YP value to the desired setting
 - a. A reference chart is available on the face of the machine for common bend settings
2. Press the green “Start/Run” button and move the punch to the full up position
 - a. The machine will automatically adjust the punch depth to the set position once the punch is in position
3. If no additional adjustments are needed, complete the bending operation

Rotating Lower Die

1. With the machine on and in the start/run mode, lower the punch to the bottom of the stroke
2. Loosen the adjustment bolts securing the die in its current position
3. Install the lift chains on both ends of the die to the hangers on the punch and raise the punch fully
4. With the die raised, slowly rotate the die to the desired position and carefully lower the punch until the die is seated and the chains are free of tension
5. Align the lower die such that the clearance on either side of the punch is equal for the length of the die
6. Equally tighten the adjustment bolts to secure the lower die position and verify clearances before further operation
 - a. Improper alignment may cause uneven wear and damage to the machine

Maintenance

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| Storage | <ul style="list-style-type: none">• Return punch to raised position• Move control panel and foot controls close to machine |
| Care | <ul style="list-style-type: none">• Clean punch and dies before and after use• Prior to bending parts, ensure proper alignment of punch and die• Periodically apply a light film of oil to punch and die. Grease guides and bearings per interval in operators manual |
| Accessories | |