



# OPERATOR'S MANUAL

Metal Working



## THREE WHEEL BELT GRINDERS MODEL: BG-142S, BG-248S, BG-260S

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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, (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 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](mailto: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**

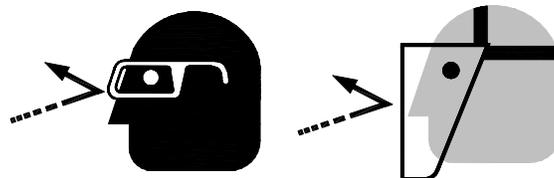


**SAVE THESE INSTRUCTIONS.**  
**Refer to them often and use them to instruct others.**



**PROTECT EYES**

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



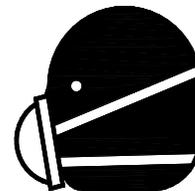
**PROTECT AGAINST NOISE**

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.



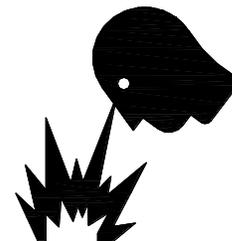
**DUST HAZARD**

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.



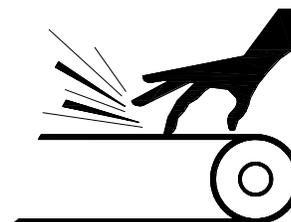
**DUST PARTICLES AND IGNITION SOURCES**

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



**MOVING BELT ABRASIONS**

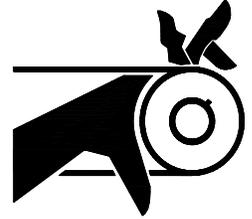
**DO NOT** place hands or fingers near, or in contact with sanding belt during operation.





### **MOVING BELTS CAN CRUSH AND DISMEMBER**

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



### **HIGH VOLTAGE**

**USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT** assume the power to be off.  
**FOLLOW PROPER LOCKOUT PROCEDURES.**



### **Power Switch with Lock Out**

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the Power Switch paddle downward. Remove the yellow lock key to prevent the machine from starting.



**Note:** Resetting the Power Switch WILL start the machine.



### **CALIFORNIA PROPOSITION 65**

WARNING: Cancer and Reproductive Harm.  
[www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)





## **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. **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 machines rated capacity.
8. **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.
9. **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.
10. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
11. **Wear a dust mask.** Some of the dust created by grinding activities may contain chemicals known to cause cancer, birth defects or other harm. Provide adequate ventilation.
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. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
17. Keep visitors a safe distance from the work area.
18. **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.
19. **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.
20. **Sparks and hot material** from grinding can easily go through small cracks and openings into adjacent areas.
21. **Do not** grind where the atmosphere might contain flammable dust, gas, or liquid vapors such as from gasoline.
22. Watch for fire and keep a fire extinguisher close by.
23. Be sure **all** equipment is properly installed and grounded according to national, state, and local codes.
24. Keep **all** cords dry, free from grease and oil, and protected from sparks and hot metal.



25. 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.
26. **Never leave machine running unattended. TURN POWER OFF.** Don't leave machine until it comes to a complete stop.
27. **Do not** operate this grinder if the gap between a moving belt, wheel or disc, and the work support surface exceeds 0.118" (3mm).
28. **Minimum Stock Dimensions. DO NOT** sand material thinner than 1/16" (1.58mm), narrower than 1/8" (3.175mm), or shorter than 8" (203mm).
29. **Changing Sanding Belt. DO NOT** operate the sander if the belt is damaged or badly worn. Replace at once.
30. **Do Not Use Damaged Belts.** Belts that show signs of wear or are torn should be replaced before continuing use.
31. **Install Belts in Correct Direction.** Install belts with the arrows on the back of the belt facing the correct direction. Belts with a lap joint must be mounted facing the correct direction. Use abrasive belts of proper size.
32. **AVOID USING DIRECTIONAL BELTS.** Using belts with a butt joint will outperform belts that have a lap joint and also do not require directional installation. Lap joint style belts are prone to separation.
33. **Inspect Piece Part.** Always inspect piece part for staples, nails, knots, or other imperfections that could become projectiles causing personal injury.
34. **Correctly Feeding The Stock.** Grasp the piece part firmly with both hands and ease into the belt with light pressure. **NEVER** force the piece part into the belt. **DO NOT** sand tapered or pointed stock with the point facing into the feed direction of the belt. **NEVER** sand more than one piece of stock at a time.
35. **Avoid Contact With The Belt.** The abrasive belt when running is an aggressive cutting tool. Extra care should be exercised when using coarse grit belts due to their rapid cutting action.
36. Bolt this grinder securely to the stand ensuring that the stand is bolted to a stable surface to stop it from tipping over or moving when in use.
37. **Sharpen Cutting Tools In Proper Direction.** Always sharpen cutting tools especially knives, scissors, chisels, etc. with the cutting edge facing downwards and in the direction of rotation of the belt. **NEVER** face the cutting edge upward against the rotation of the belt; this can result in injury.
38. **Hold Material Tightly.** Always hold the work piece firmly when grinding and apply light and steady pressure against the abrasive belt.
39. **Never Use The Back Of The Large Drive Wheel.** Using the back of the large drive wheel will cause debris to travel upwards and contact operator or bystanders.



40. **Keep the grinder properly maintained.** Ensure contact wheels and drive wheels are in good condition and are free from cuts or splits that can be a danger in operation. Replace all damaged contact wheels before operating machine.
41. **Turn off** power before checking, cleaning, or replacing any parts.
42. **USE ABRASIVE BELTS FROM RESPECTED BELT MANUFACTURES.** Not all abrasive belts are created equal. Belts that are very inexpensive are usually manufactured cheaply.
43. **KNOW WHAT YOUR GRINDING.** Avoid mixing different metals, alloys, and materials. To mix such materials might create a fire or explosion hazard. Exotic materials such as titanium, magnesium, and other chemically active materials will present fire and explosion hazards that if ignored can result in grave personal injury and/or property damage. Consult with the material supplier or other qualified expert regarding the materials on which you wish to work.



## TECHNICAL SPECIFICATIONS

Model number	BG-142S	BG-248S	BG-260S
<b>Motor and Electricals</b>			
Motor type	Totally enclosed fan cooled, induction		
Motor Power	.75hp (.55kw)	1hp (.75kw)	1.5hp (1.1kw)
Motor speed (RPM)	3450		
Power Supply	115V, 1ph, 60hz		
Listed FLA (full load amps)	11.5	12	14.6
Starting amps	36	48	52
Running amps (no load)	8	7.3	7
Start capacitor	200MFD 125VAC		400MFD 125VAC
Run capacitor	n/a	45µF 250VAC	70µF 250VAC
Power cord	SJT 14AWG x 3C, 6 ft. (1830 mm)		
Power plug installed	125V, 15A		
On/off switch	Toggle with safety key		
Power transfer	Poly V-belt		
Recommended circuit size 2	20 Amp		
Noise Rating (reference only)	74 dB at 100cm, 77 dB at 50cm	80 dB at 100cm, 84 dB at 50cm	78 dB at 100cm, 82 dB at 50cm
<b>Abrasive and wheels</b>			
Abrasive provided	Aluminum oxide, 120-grit		
Abrasive size	1" x 42" (25 x 1067mm)	2" x 48" (50 x 1219 mm)	2" x 60" (50 x 1524 mm)
Abrasive speed	5500 FPM (1676 MPM)	6000 FPM (1829 MPM)	8000 FPM (2438 MPM)
Number of wheels	3		
Wheel size	Ø4.75" x 1" (120 x 25 mm)	Ø5" x 2" (127 x 50 mm)	Ø7" x 2" (178 x 50 mm)
Wheel speed (RPM)	4500	4600	4400
<b>Dust collection</b>			
Dust port outside diameter	2" (50.8 mm)		
Recommended dust extraction	400 CFM (0.5 CMM)		
<b>Main materials</b>			
Housing	Aluminum and steel		
Motor shroud	Steel		
Platen	Cast iron		



Table	Cast iron		
Base	Cast iron		
Contact wheel	Aluminum, rubber coated (65 Duro)		
Driven wheels	Aluminum, PU coated		
Dimensions			
Work rest (L x W)	2.25" x 4.5" (57 x 115 mm)		
Base (L x W)	13.5" x 15.04" (343 x 382mm)		13.5" x 17" (343 x 432 mm)
Overall dimensions (H x W x D)	20.31" x 15.63" x 20.51" (516 x 397 x 521 mm)	22.32" x 19" x 20.63" (567 x 482 x 524 mm)	26.69" x 21" x 23.11" (678 x 533 x 587 mm)
Shipping dimensions (H x W x D)	24.8" x 22.44" x 24.4" (630 x 570 x 620 mm)		29.14" x 25.6" x 28.74" (740 x 650 x 730 mm)
Weights			
Net weight (approx.)	106lb. (48kg)	115lb. (52kg)	137lb. (62kg)
Shipping weight (approx.)	124lb. (56kg)	133lb. (60kg)	161lb. (73kg)

## 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](mailto: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.





## TRANSPORTING AND LIFTING

### Follow these guidelines when lifting:

- Use proper lifting techniques when moving the saw from location to location.
- Make sure the machine is balanced, level, and securely tied or strapped to the transport vehicle or device so that all the supporting feet are taking the weight of the machine and no rocking is taking place.
- While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.

## 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.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This machine distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **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.

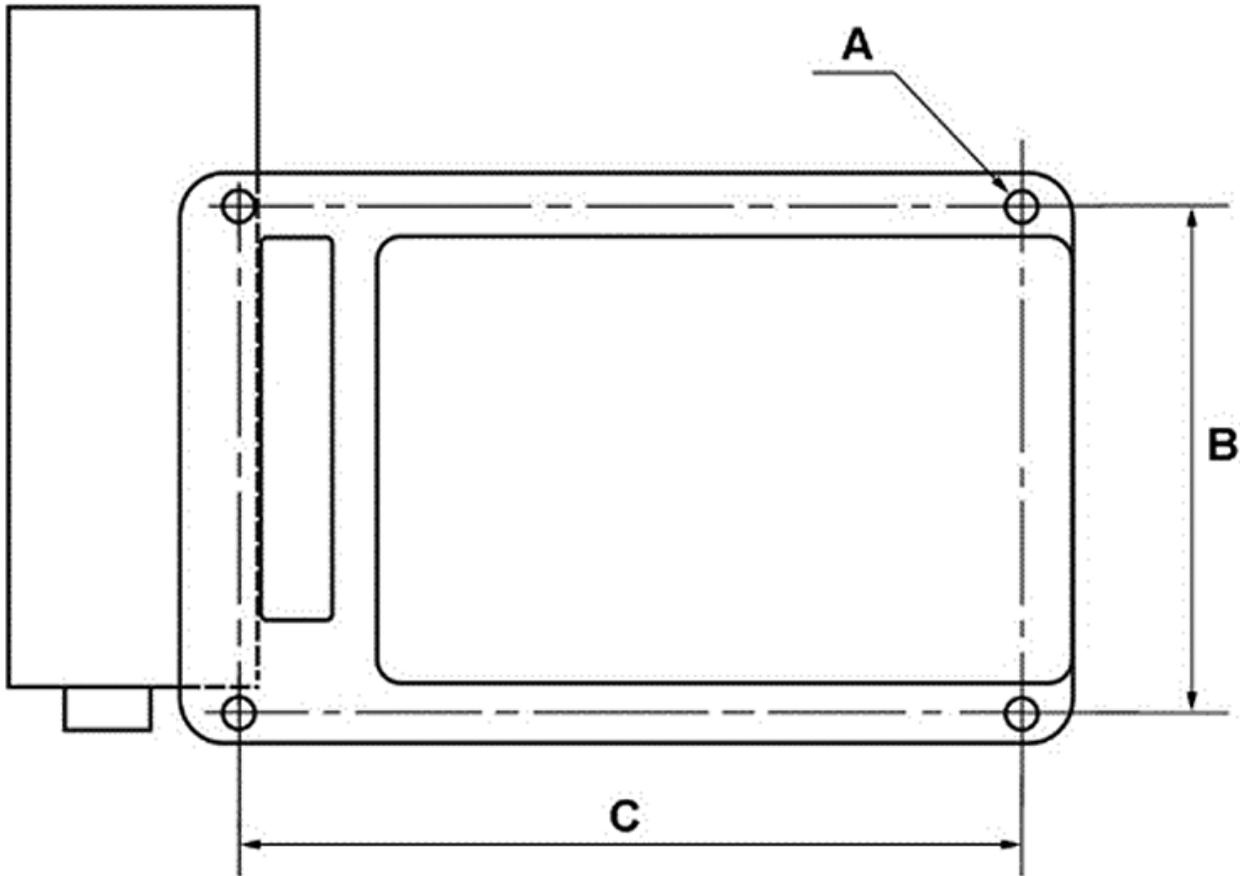


- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

When mount the Baileigh machine on a workbench be aware of the following:

- Overall weight of the machine and the 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.

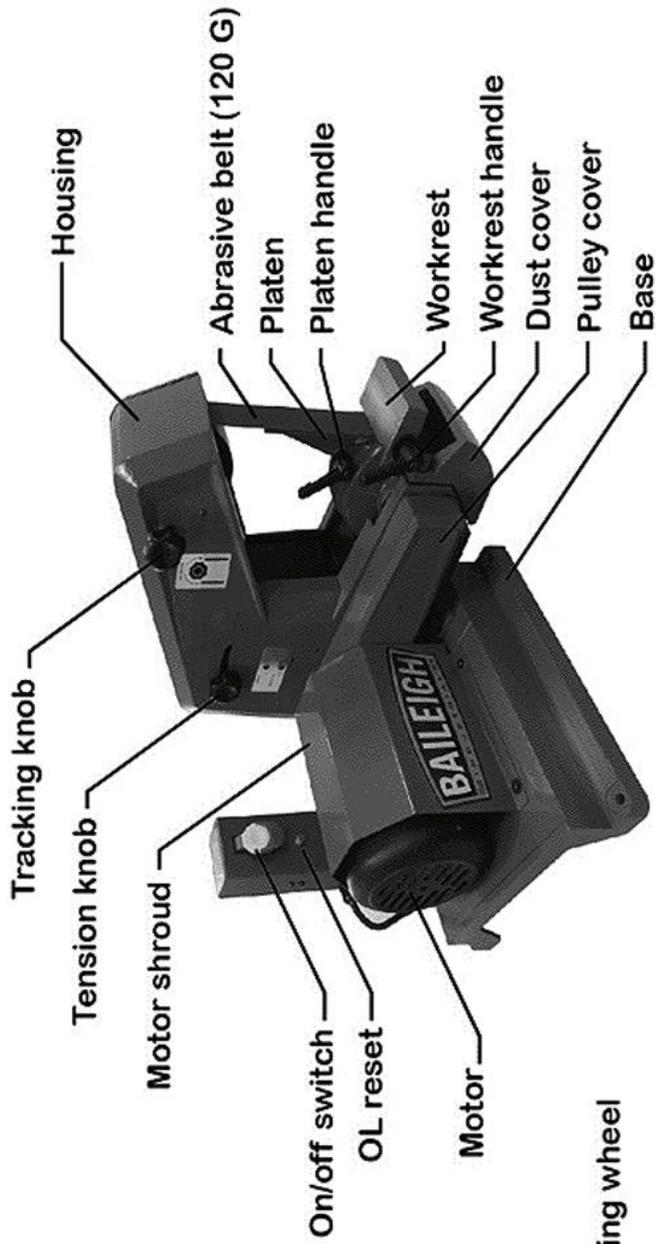
**Mounting Dimensions**



	A	B	C
BG-124S	Ø 0.433" (11mm)	12.598" (320mm)	13.385" (340mm)
BG-248S	Ø 0.433" (11mm)	12.598" (320mm)	13.385" (340mm)
BG-260S	Ø 0.433" (11mm)	12.598" (320mm)	14.960" (380mm)



## GETTING TO KNOW YOUR MACHINE





## 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 115 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. Verify that the On/off switch is OFF. Remove the yellow lockout key as well to prevent unintended start up.
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 power switch may be turn ON to test the operation. Turn the switch OFF when the machine is not in operation. Remove the yellow lock key to prevent the machine from starting.



## 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.

### Operating controls

- On/off switch (A) with safety key – Pull up to start motor, push down to stop.



**Important:** To prevent accidental or unauthorized starting of grinder, shut off machine and pull out key (yellow portion) of switch and store in safe place. This key must be reinserted to start machine.

- Overload reset (B) – If motor overheats, allow machine a few minutes to cool down, then push button to reset.



### General operating tips

- Always use platen when grinding workpiece.
- Adjust gap between work rest and belt to 1/16-inch or less.
- Handles must be tight and covers closed before operating.
- Some metals may create a fire hazard during grinding; consult workpiece supplier for instructions on proper use and cautions.
- Allow machine to come up to speed before applying workpiece.
- Place workpiece upon work rest and apply only moderate pressure into abrasive belt; do not apply excessive pressure.



## MACHINE ADJUSTMENTS

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

### Work Rest Adjustment

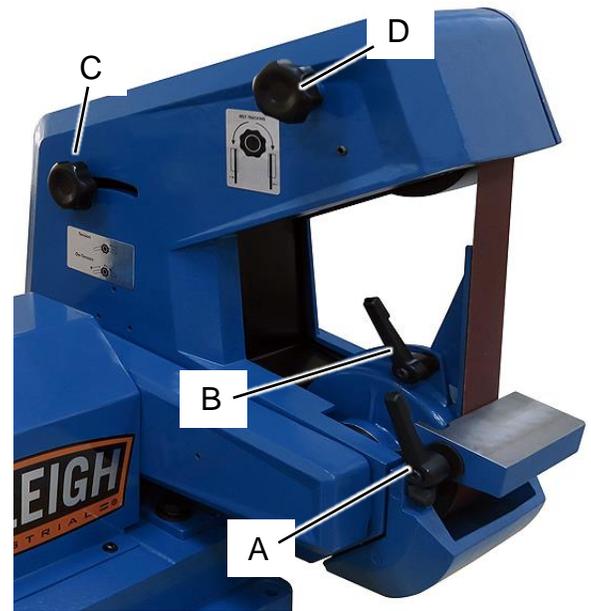
- Loosen work rest handle (A) and adjust work rest to desired angle. Minimize gap between edge of work rest and abrasive belt; 1/16-inch or less.
- Tighten work rest handle before operating.

### Platen Adjustment

- Loosen platen handle (B) and adjust platen so it is parallel to back of abrasive belt and almost touching the back of the abrasive belt.



**Note:** The Work Rest and Platen Handles are adjustable; pull handle straight out and rotate it on the pin, then release. Make sure handle reseats itself on the pin.



### Abrasive Belt Tension

- To de-tension abrasive belt, turn tension knob (C) counterclockwise and pull knob toward the front (work area) of the grinder.
- To tension, push knob toward the back (away from the work area). The pawl will “click” as it engages each ratchet tooth. Tighten the belt until it is just taut. Do not over tension. A moderate tension will provide faster cutting and longer belt life, as well as better tracking.



**Note:** When belt grinder is not being used, de-tension the abrasive belt. This will prolong the life of the belt, and reduce load on wheels, bearings and other components.

### Abrasive Belt Tracking

The abrasive belt should remain centered upon the wheels during operation. If it tends to slide off-center, adjust as follows:

- Disconnect machine from power source and pull open side cover.
- Turn the tracking wheel by hand and rotate tracking knob (D) left or right as the belt is moving. Do this in small increments and allow time for belt to respond to changes.



- Clockwise knob rotation moves belt toward left, counterclockwise toward right.
- If belt refuses to track properly, slightly increase belt tension and repeat above steps.

### V-Belt Tension

- Disconnect machine from power source.
- Remove four button head screws and open motor shroud.
- Remove two screws from pulley cover (access through housing) and remove pulley cover.
- Loosen screws on motor mount and slide motor backward to tension belt.
- Tighten motor mount screws, reinstall pulley cover and shroud.

## 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.

- 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.



**Note:** When cleaning dust 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 grinding dust into critical mechanisms or may inflict injury to yourself or others.

### General Cleaning

Keep exterior of machine clean and free of chips. Periodically clean out interior of housing with vacuum or brush – do not use bare hands. Periodically empty grinding dust and particles from the dust collection system (sold separately).



### **Lubrication**

Lubrication of the grinder is not required. Bearings are pre-lubricated and sealed.

### **Abrasive Belt Replacement**

- Disconnect machine from power source.
- Open side cover, and open dust cover by unscrewing dust cover screw.
- De-tension and slip belt off wheels.
- Install new belt around wheels, tension, and test tracking. Make further adjustments as needed.
- Close all covers before operating.

### **Contact Wheel Replacement**

- Disconnect machine from power source.
- Open side cover and dust cover and remove abrasive belt.
- Loosen and remove hex nut and flange washer, and slide contact wheel off spindle.
- Install new wheel. Reinstall flange washer and hex nut and tighten.
- Install abrasive belt, tension, and check tracking.
- Close all covers before operating.

### **V-Belt Replacement**

- Disconnect machine from power source.
- Remove four button head screws and open motor shroud.
- Remove two screws from pulley cover (access through housing) and remove pulley cover.
- Slide motor forward to loosen belt and slip belt off pulleys.
- Install new belt and slide motor back to tension it.
- Tighten motor mount screws.
- Secure all covers and screws.





## TROUBLESHOOTING

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

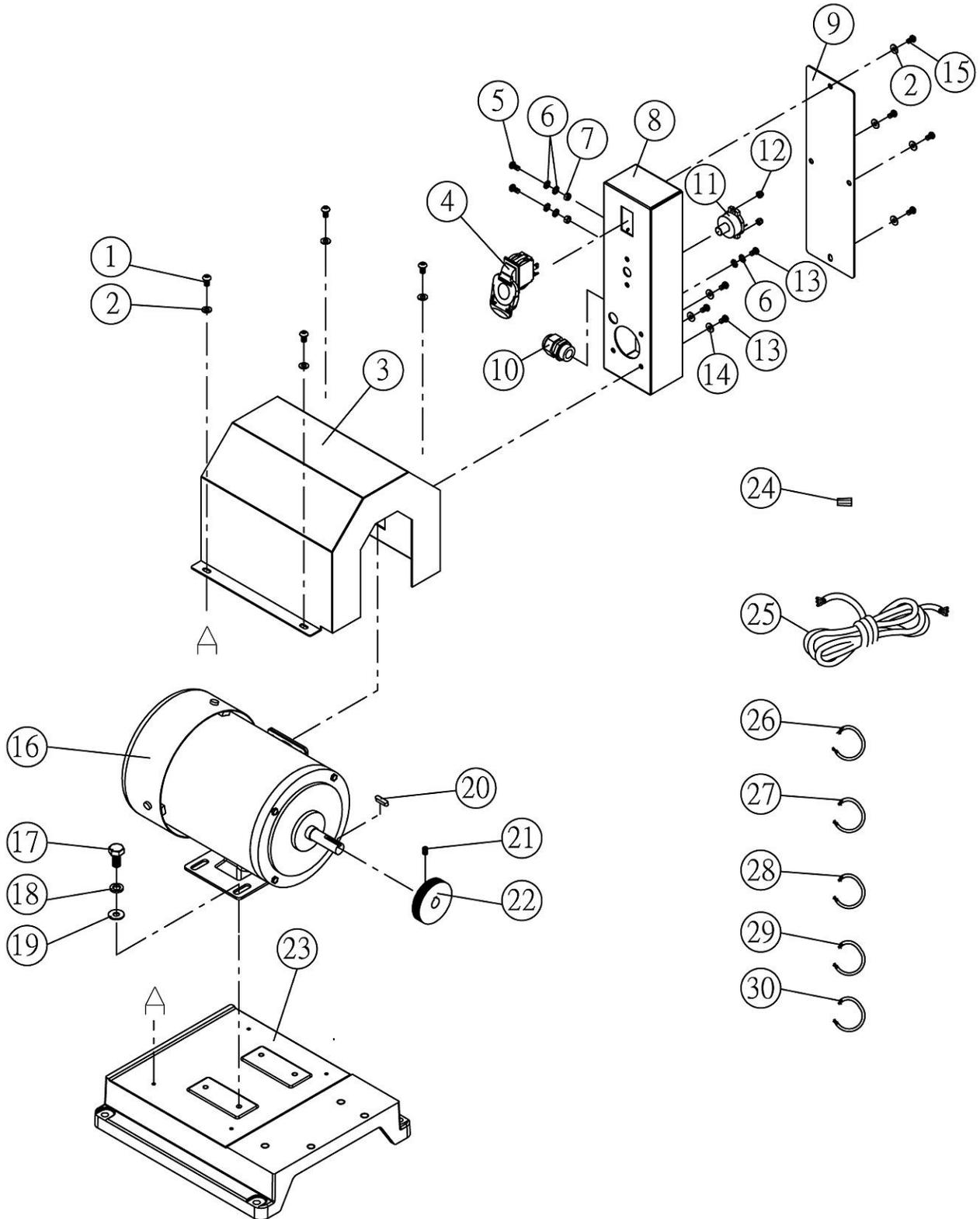
Symptom	Possible Cause	Correction*
Motor will not start	Low voltage.	Check power line for proper voltage.
	Open circuit in motor or loose connection.	Inspect all lead connections on motor for loose or open connections.
Motor will not start fuses or circuit breakers blow	Short circuit in line cord or plug.	Inspect cord or plug for damaged insulation and shorted wires.
	Short circuit in motor or loose connections.	Inspect all connections on motor for loose or shorted terminals or worn insulation.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses or circuit breakers.
Machine slows when operating	Applying excessive pressure of workpiece against platen.	Reduce pressure against abrasive/platen.
	V-belt loose.	Tighten V-belt.
Loud, repetitive noise coming from machine	Pulley setscrews or keys are missing or loose.	Inspect keys and setscrews. Replace or tighten if necessary.
	Motor fan is hitting the fan cover.	Tighten fan or shim cover.
	V-belt is defective.	Replace V-belt.
Poor tracking	Improper abrasive belt splice.	Check belt for irregular seam or shape.
	Excessive belt tension.	Set tension so belt is just taut.
	Insufficient belt tension.	Set tension so belt is just taut.
	Worn contact surfaces.	Check surface of contact wheels. Replace worn wheels.
	Misaligned contact surfaces.	Check alignment of tracking wheels and contact wheel. Realign if needed.
	Lack of crown on drive wheel.	Check for 1/16-inch crown. Replace drive wheel if crown is not present.
	Worn bearings.	Check all bearings for overheating or damage. Replace worn or damaged bearings.
Slack abrasive belt	Insufficient belt tension.	Set tension so belt is just taut.
Contact wheel	Excessive belt tension.	Set tension so belt is just taut.



Symptom	Possible Cause	Correction*
wear	Grinding in one area on belt.	Use entire work surface of belt whenever possible.
	Excessive grinding deposits on belt and debris in machine.	Periodically clean interior of grinder.
Short abrasive belt life.	Excessive grinding pressure.	Allow belt to do the cutting. Excessive pressure dulls belt and removes grit from it.



# MOTOR AND BASE ASSEMBLY – EXPLODED VIEW - BG-142S/248S/260S





### Motor and Base Assembly – Parts List – BG-142S

Item	Part No	Description	Size	Qty.
1	TS-2245102	Socket Head Button Screw	M5 x 0.8 x 10L	4
2	TS-1550031	Flat Washer	5.1 x 12 x 1T	8
3	81011047	Motor Shroud		1
4	JSG96-135	Switch		1
	JSG96-135A	Switch Key (not shown)		1
5	TS-1533032	Phillips Pan Hd Machine Screw	M5 x 0.8P x 10L	2
6	F002097	Lock Washer, Ext. Tooth	M5	4
7	50201021	Hex Nut	M5 - 0.8P	2
8	81011048	Control Pedestal		1
9	81011049	Control Pedestal Cover		1
10	BGB248-116	Strain Relief		1
11	BGB248-109	Overload Protector		1
12	50202001	Hex Nut, Nylon Lock	M4 - 0.7P	2
13	50154039	Phillips Pan Hd Machine Screw	3/16" - 24 x 3/8"L	4
14	50301144	Flat Washer	5.2 x 16 x 1T	3
15	50104047	Phillips Round Hd Tapping Screw	M5 x 0.8P x 8L	4
16	81021501	Motor	3/4HP, 115/230V, 1Ph	1
	BGB248-120SC	Starting Capacitor (not shown)	200MFD 125VAC	1
	BGB248-120SCC	Starting Capacitor Cover (not shown)		1
	BGB248-120CF	Cooling Fan (not shown)		1
	BGB248-120FC	Fan Cover (not shown)		1
17	TS-2228161	Hex Cap Screw	M8 x 1.25P x 16L	4
18	TS-2361081	Lock Washer	M8	4
19	TS-1550061	Flat Washer	8.5 x 20 x 1.5T	8
20	6296048	Key, Double Rd Head	5 x 5 x 25L mm	1
21	50124003	Set Screw w/thread lock	M6 x 1.0P x 10L	2
22	BGB142-126	Motor Pulley		1
23	81021012	Base		1
24	BGB248-137	Wiring Nut	SW-P4H	4
25	42041801	Power Cable		1
26	81011914	Single Internal Cable	14AWG, 25cm, Black	1
27	81011906	Single Internal Cable	14AWG, 10cm, White	1



Item	Part No	Description	Size	Qty.
28	81011905	Single Internal Cable (No.5 marked)	14AWG, 15cm, Red	1
29	81011913	Single Internal Cable (No.6 marked)	14AWG, 15cm, Red	1
30	81011915	Single Internal Cable	14AWG, 20cm, Green	1
	34090302	Aluminum Logo Plate (not shown)		1

### **Motor and Base Assembly – Parts List – BG-248S**

Item	Part No	Description	Size	Qty.
1	TS-2245102	Socket Head Button Screw	M5 x 0.8 x 10L	4
2	TS-1550031	Flat Washer	5.1 x 12 x 1T	8
3	81011047	Motor Shroud		1
4	JSG96-135	Switch		1
	JSG96-135A	Switch Key (not shown)		1
5	TS-1533032	Phillips Pan Hd Machine Screw	M5 x 0.8P x 10L	2
6	F002097	Lock Washer, Ext. Tooth	M5	4
7	50201021	Hex Nut	M5 - 0.8P	2
8	81011048	Control Pedestal		1
9	81011049	Control Pedestal Cover		1
10	BGB248-116	Strain Relief		1
11	BGB248-109	Overload Protector		1
12	50202001	Hex Nut, Nylon Lock	M4 - 0.7P	2
13	50154039	Phillips Pan Hd Machine Screw	3/16" - 24 x 3/8"L	4
14	50301144	Flat Washer	5.2 x 16 x 1T	3
15	50104047	Phillips Round Hd Tapping Screw	M5 x 0.8P x 8L	4
16	81011521	Motor	1HP, 115/230V, 1Ph	1
	BGB248-120SC	Starting Capacitor (not shown)	200MFD 125VAC	1
	BGB248-120SCC	Starting Capacitor Cover (not shown)		1
	BGB248-120CF	Cooling Fan (not shown)		1
	BGB248-120FC	Fan Cover (not shown)		1
17	TS-2228161	Hex Cap Screw	M8 x 1.25P x 16L	4
18	TS-2361081	Lock Washer	M8	4



Item	Part No	Description	Size	Qty.
19	TS-1550061	Flat Washer	8.5 x 20 x 1.5T	8
20	6296048	Key, Double Rd Head	5 x 5 x 25L mm	1
21	50124003	Set Screw w/thread lock	M6 x 1.0P x 10L	2
22	BGB248-126	Motor Pulley		1
23	81011046	Base		1
24	BGB248-137	Wiring Nut	SW-P4H	4
25	42041801	Power Cable		1
26	81011914	Single Internal Cable	14AWG, 25cm, Black	1
27	81011906	Single Internal Cable	14AWG, 10cm, White	1
28	81011905	Single Internal Cable (No.5 marked)	14AWG, 15cm, Red	1
29	81011913	Single Internal Cable (No.6 marked)	14AWG, 15cm, Red	1
30	81011915	Single Internal Cable	14AWG, 20cm, Green	1
	34090302	Aluminum Logo Plate (not shown)		1

### **Motor and Base Assembly – Parts List – BG-260S**

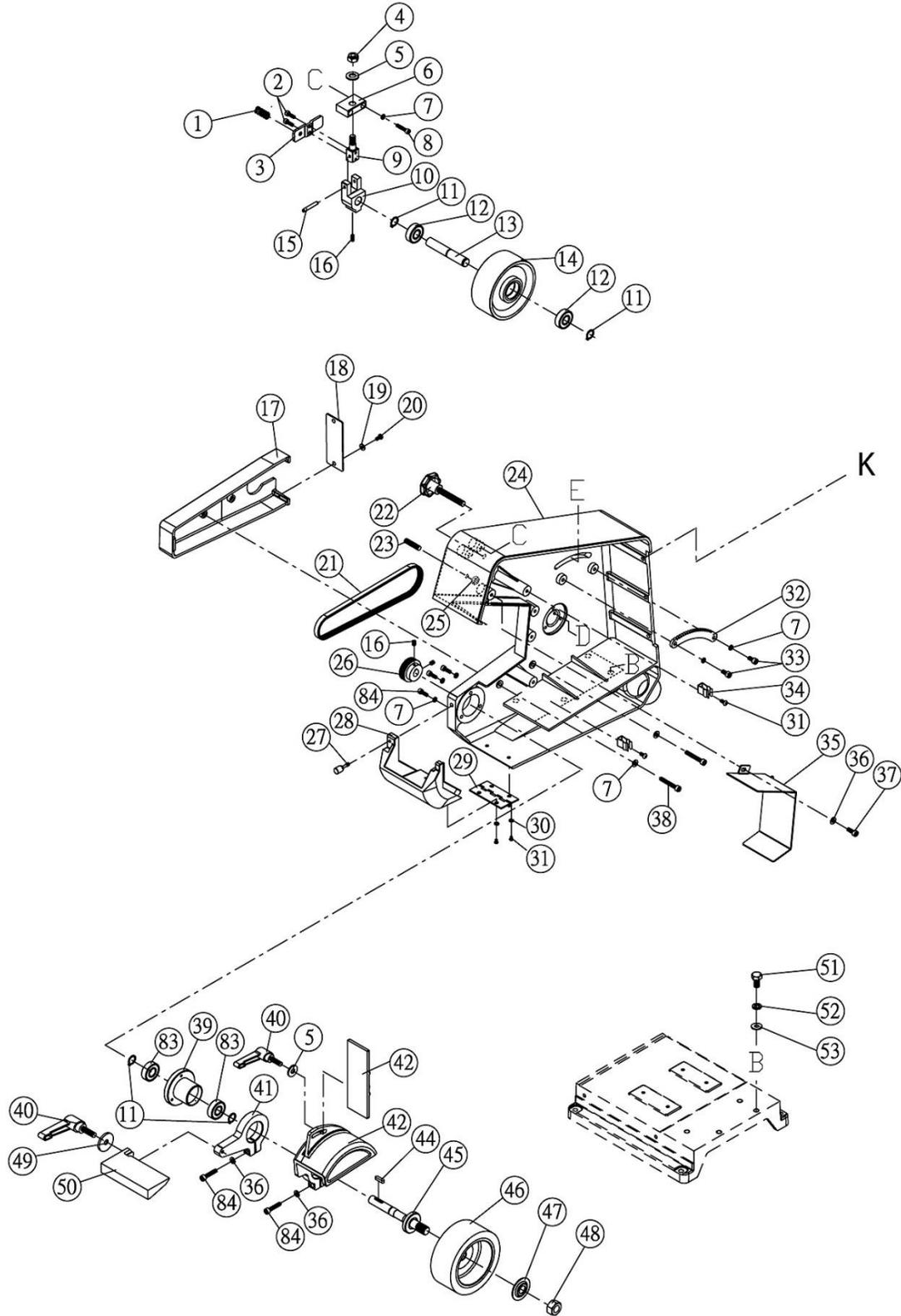
Item	Part No	Description	Size	Qty.
1	TS-2245102	Socket Head Button Screw	M5 x 0.8 x 10L	4
2	TS-1550031	Flat Washer	5.1 x 12 x 1T	8
3	81031022	Motor Shroud		1
4	JSG96-135	Switch		1
	JSG96-135A	Switch Key (not shown)		1
5	TS-1533032	Phillips Pan Hd Machine Screw	M5 x 0.8P x 10L	2
6	F002097	Lock Washer, Ext. Tooth	M5	4
7	50201021	Hex Nut	M5 - 0.8P	2
8	81011048	Control Pedestal		1
9	81011049	Control Pedestal Cover		1
10	BGB248-116	Strain Relief		1
11	BGB260-1-109	Overload Protector		1
12	50202001	Hex Nut, Nylon Lock	M4 - 0.7P	2
13	50154039	Phillips Pan Hd Machine Screw	3/16" - 24 x 3/8"L	4
14	50301144	Flat Washer	5.2 x 16 x 1T	3
15	50104047	Phillips Round Hd Tapping	M5 x 0.8P x 8L	4

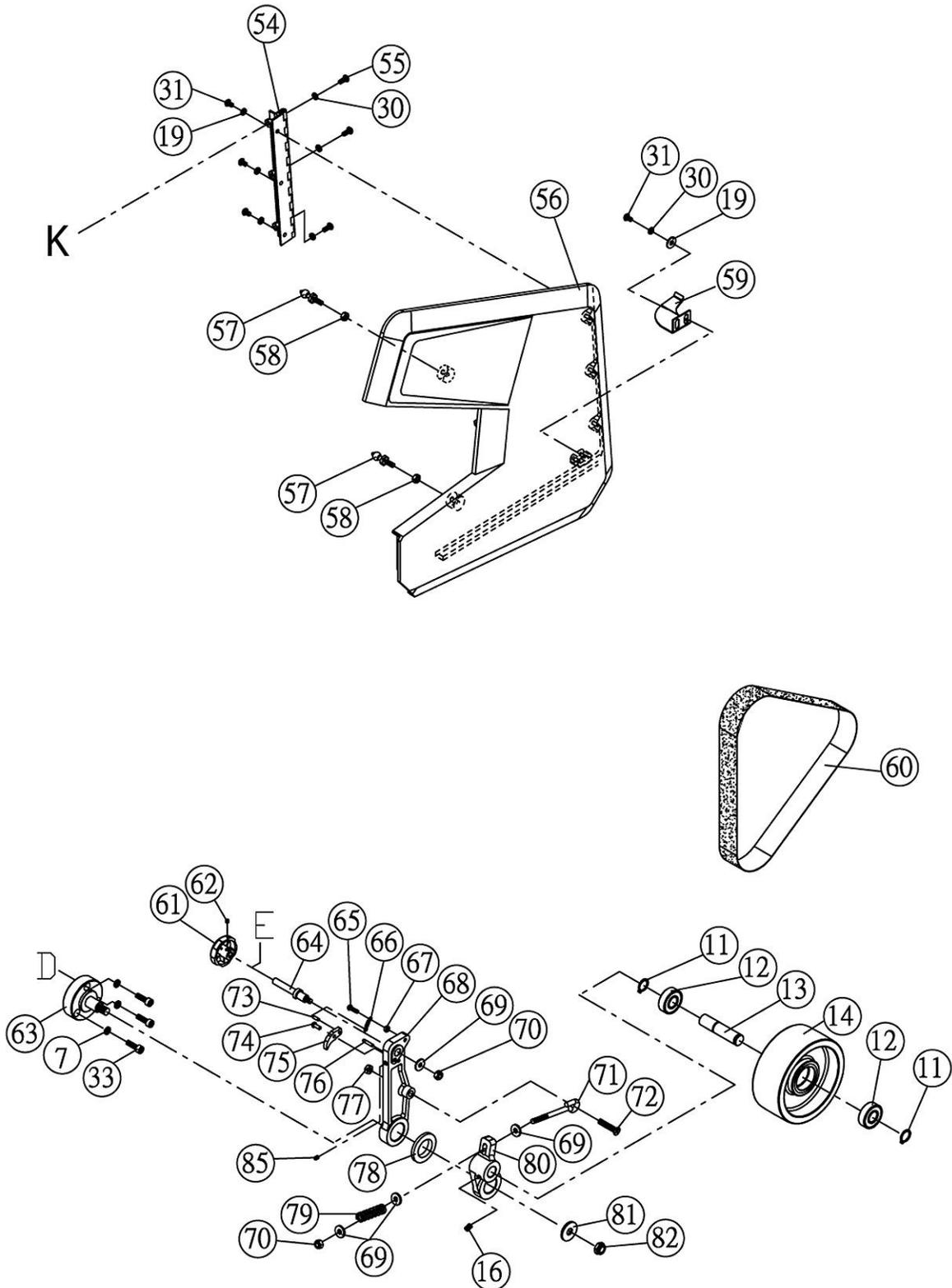


Item	Part No	Description	Size	Qty.
		Screw		
16	81031521	Motor	1-1/2HP, 115/230V, 1Ph	1
	BGB260-1-120SC	Starting Capacitor (not shown)	450MFD 125VAC	1
	BGB260-1-120SCC	Starting Capacitor Cover (not shown)		1
	BGB248-120RC	Running Capacitor (not shown)	70µF 250VAC	1
	BGB248-120RCC	Running Capacitor Cover (not shown)		1
	BGB248-120CF	Cooling Fan (not shown)		1
	BGB248-120FC	Fan Cover (not shown)		1
17	TS-2228161	Hex Cap Screw	M8 x 1.25P x 16L	4
18	TS-2361081	Lock Washer	M8	4
19	TS-1550061	Flat Washer	8.5 x 20 x 1.5T	8
20	6296048	Key, Double Rd Head	5 x 5 x 25L mm	1
21	50124006	Set Screw w/thread lock	M5 x 0.8P x 8L	2
22	81031018	Motor Pulley		1
23	81031021	Base		1
24	BGB248-137	Wiring Nut	SW-P4H	4
25	42041801	Power Cable		1
26	81011914	Single Internal Cable	14AWG, 25cm, Black	1
27	81011906	Single Internal Cable	14AWG, 10cm, White	1
28	81011905	Single Internal Cable (No.5 marked)	14AWG, 15cm, Red	1
29	81011913	Single Internal Cable (No.6 marked)	14AWG, 15cm, Red	1
30	81011915	Single Internal Cable	14AWG, 20cm, Green	1
	34090302	Aluminum Logo Plate (not shown)		1



# BELT AND HOUSING ASSEMBLY – EXPLODED VIEW – BG-142S







**Belt and Housing Assembly – Parts List – BG-142S**

Item	Part No	Description	Size	Qty.
1	BGB248-201	Compression Spring		1
2	TS-1502031	Socket Head Cap Screw	M5-0.8P x 12L	4
3	BGB248-203	Supporting Plate		1
4	TS-1541031	Hex Nut, Nylon Lock	M8-1.25P	1
5	TS-1550061	Flat Washer	8.5 x 19 x 2T	2
6	BGB248-206	Fixed Bracket		1
7	TS-2361061	Lock Washer	M6	12
8	50102026	Socket Head Cap Screw	M6-0.8P x 30L	2
9	BGB248-209	Pivoting Shaft		1
10	BGB248-210	Tracking Wheel Hub		1
11	6292752	Ext. Retaining Ring	STW-15	6
12	BB-6002ZZ	Ball Bearing	6002 ZZ	4
13	BGB142-213	Tracking Wheel Axle		2
14	BGB142-214	Tracking Wheel		2
15	5509829	Roll Pin	6 x 36L mm	1
16	50124003	Set Screw w/ thread lock	M6-1.0P x 8L	3
17	81011042	Pulley Cover		1
18	81011042	Pulley Cover Rear Plate		1
19	TS-1550031	Flat Washer	5.1 x 12 x 1T	7
20	TS-1533032	Phillips Pan Hd Machine Screw	M5-0.8P x 10L	2
21	BGB248-221	Poly V-Belt		1
22	50111027	Knob		1
23	F010433	Socket Head Set Screw	M8-1.25P x 40L	1
24	81021001	Housing		1
25	TS-1541031	Hex Nut	M8-1.25P	1
26	BGB142-226	Spindle Pulley		1
27	BGB248-227	Knob Screw		1
28	81021003	Dust Cover		1
29	BGB248-229	Hinge		1
30	TS-2361051	Lock Washer	M5	9
31	TS-2245102	Socket Head Button Screw	M5-0.8P x 10L	9
32	BGB248-232	Ratchet		1
33	TS-1503041	Socket Head Cap Screw	M6-1.0P x 16L	5



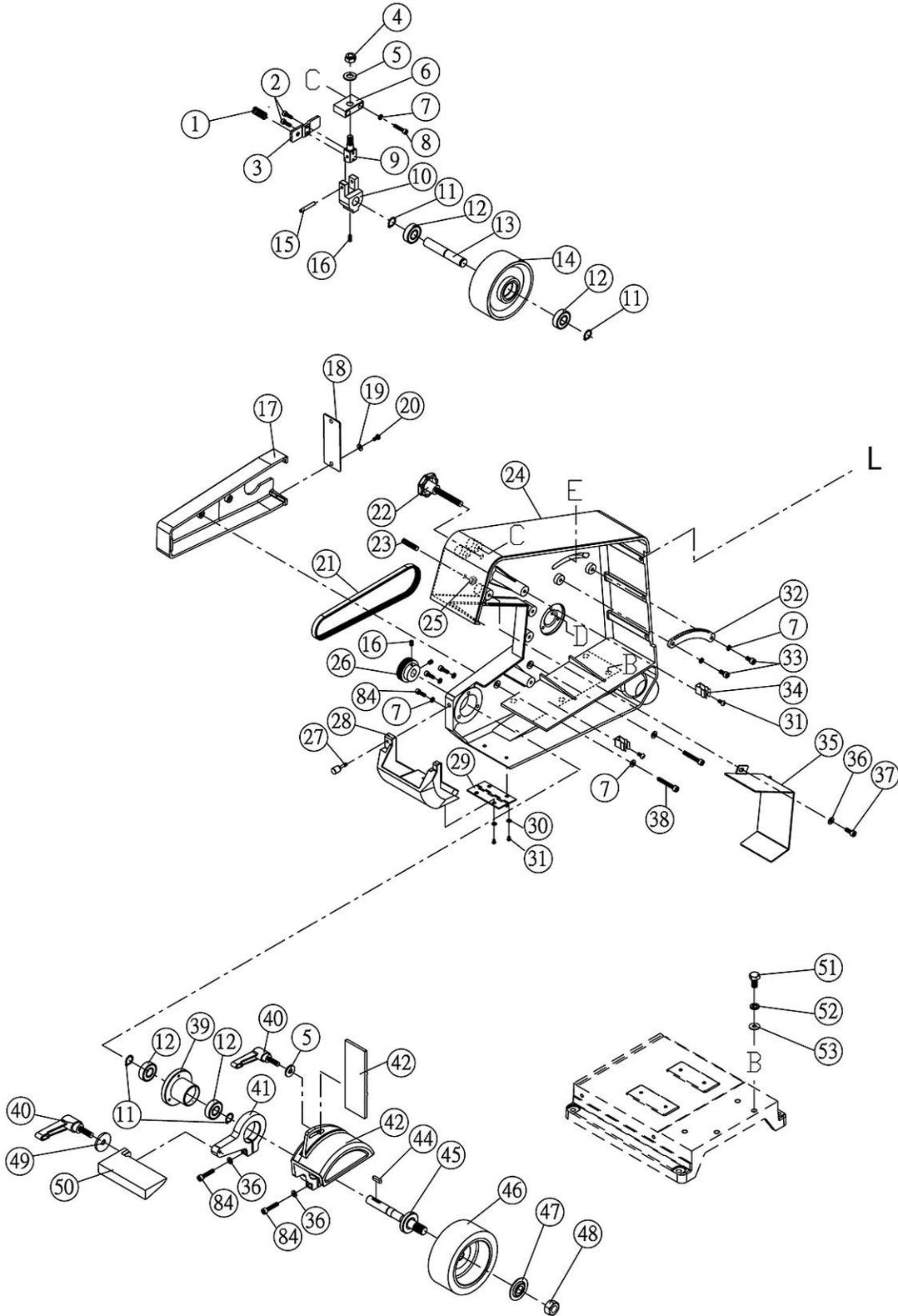
Item	Part No	Description	Size	Qty.
34	BGB248-234	Clip		2
35	BGB142-235	Spine Central Guard		1
36	TS-1550041	Flat Washer	6 x 12 x 1T mm	5
37	TS-1503021	Socket Head Cap Screw	M6-1.0P x 10L	3
38	TS-1503131	Socket Head Cap Screw	M6-1.0P x 60L	2
39	BGB248-239	Bearing Housing		1
40	BGB248-240	Universal Handle		2
41	81011013	Table Support Arm		1
42	81021005	Platen		1
43	81021004	Contact Wheel Cover		1
44	6296048	Key, Double Rd Head	5 x 5 x 25L mm	1
45	BGB142-245	Contact Wheel Spindle		1
46	BGB142-246	Contact Wheel		1
47	BGB248-247	Flange Washer		1
48	TS-0561071	Hex Nut	5/8"-11UNC	1
49	TS-1550061	Flat Washer	8 x 30 x 3T mm	1
50	BGB248-250	Work Rest		1
51	TS-1492011	Hex Cap Screw	M12-1.75P x 25L	4
52	TS-2361121	Lock Washer	M12	4
53	TS-155009	Flat Washer	13.5 x 28 x 3T mm	4
54	BGB248-254	Continuous Hinge		1
55	F009887	Socket Head Button Screw	M5-0.8P x 16L	3
56	BGB142-256	Side Cover		1
57	BGB248-257	Peg		2
58	TS-1540041	Hex Nut	M6-1.0P	2
59	BGB248-259	Door Latch		1
60	BGB142-260	Abrasive Belt	1"Wx42"L 120G	1
61	50204010	Knob		1
62	F010391	Socket Head Set Screw	M5 x 0.8P x 5L	1
63	BGB248-263	Hub Supporting Shaft		1
64	BGB248-264	Rod		1
65	TS-1532052	Phillips Pan Hd Machine Screw	M4 x 0.7P x 16L	1
66	BGB248-266	Tension Spring		1
67	TS-1540021	Hex Nut	M4-0.7P	1
68	BGB248-268	Tension Wheel Arm		1

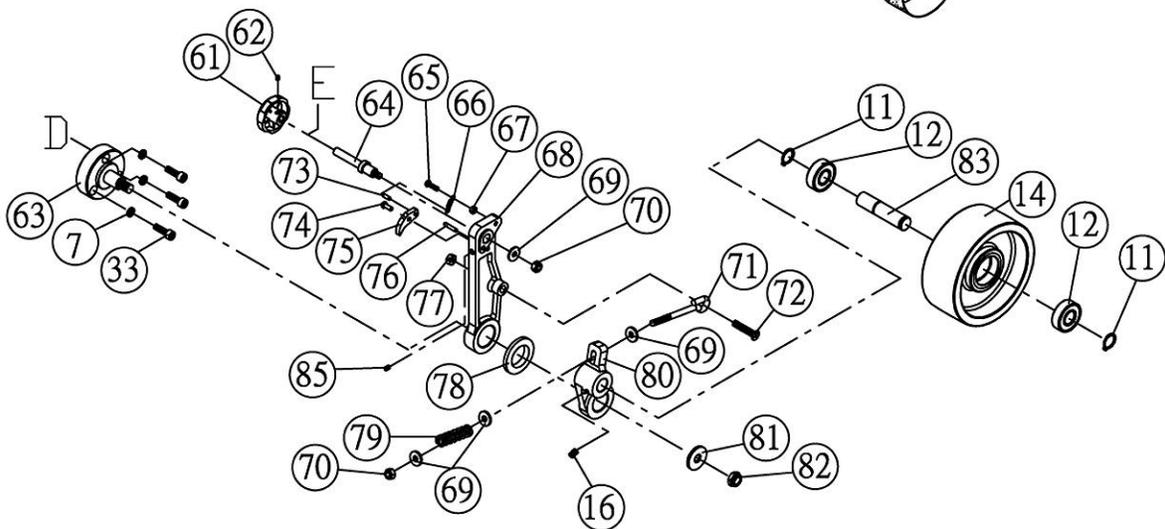
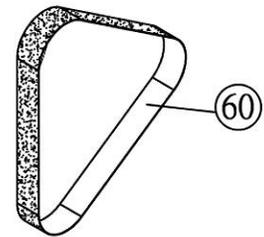
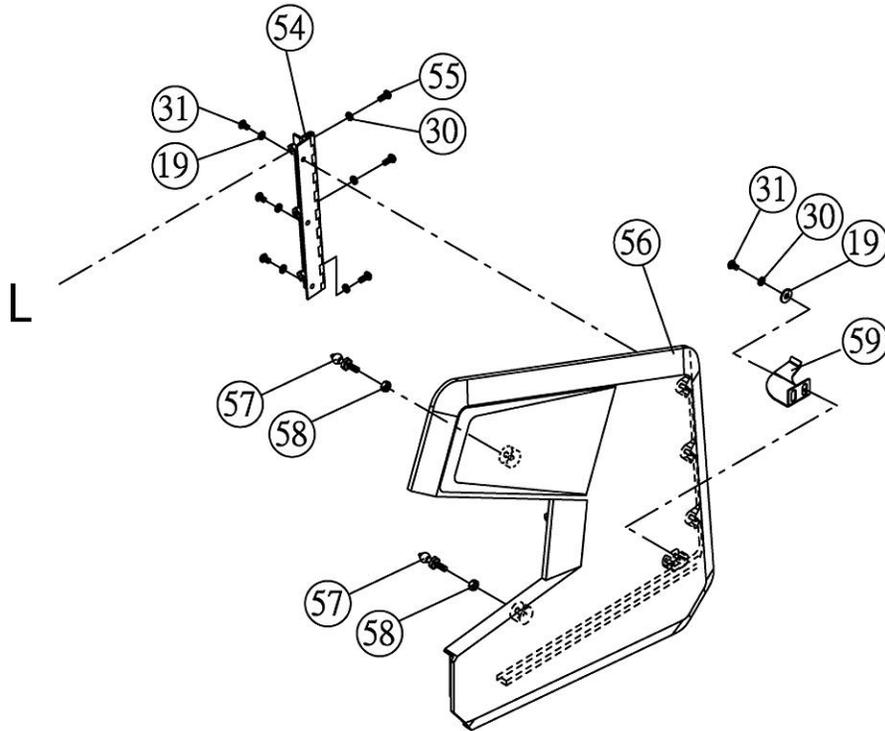


Item	Part No	Description	Size	Qty.
69	TS-1550041	Flat Washer	6.4 x 16 x 1.6T mm	4
70	TS-1541021	Hex Nut, Nylon Lock	M6-1.0P	2
71	BGB248-271	Spring Tension Adj. Rod		1
72	TS-134608	Phillips Flat Hd Machine Screw	1/4"-20UNC x 1-1/4"L	1
73	F012091	Roll Pin	3 x 10L mm	1
74	BGB248-274	Rivet		1
75	BGB248-275	Pawl		1
76	F012092	Roll Pin	3 x 18L mm	1
77	TS-0570011	Hex Nut	1/4"-20UNC	1
78	BGB248-278	Oilite Washer		1
79	BGB248-279	Compression Spring		1
80	BGB248-280	Tension Wheel Hub		1
81	TS-1550071	Flat Washer	10.2 x 30 x 3T mm	1
82	TS-0640091	Hex Nut, Nylon Lock	3/8"-16UNC	1
83	BB-6202ZZ	Ball Bearing	6202 ZZ	2
84	50102008	Socket Head Cap Screw	M8-1.25P x 25L	5
85	50103040	Socket Head Set Screw	M4-0.7P x 6L	1
	LM000251	Warning Label (not shown)	2-1/2" x 5-1/4"	1
	LM000252	Belt Tracking Label (not shown)		1
	LM000253	Belt Tension Label (not shown)		1
	LM000254	Control Panel Label (not shown)		1
	81010310	ID Label, BG-142S (not shown)		1
	81010311	Motor Label, BG-142S (not shown)		1



# BELT AND HOUSING ASSEMBLY – EXPLODED VIEW – BG-248S







**Belt and Housing Assembly – Parts List – BG-248S**

Item	Part No	Description	Size	Qty.
1	BGB248-201	Compression Spring		1
2	TS-1502031	Socket Head Cap Screw	M5-0.8P x 12L	4
3	BGB248-203	Supporting Plate		1
4	TS-1541031	Hex Nut, Nylon Lock	M8-1.25P	1
5	TS-1550061	Flat Washer	8.5 x 19 x 2T	2
6	BGB248-206	Fixed Bracket		1
7	TS-2361061	Lock Washer	M6	12
8	50102026	Socket Head Cap Screw	M6-0.8P x 30L	2
9	BGB248-209	Pivoting Shaft		1
10	BGB248-210	Tracking Wheel Hub		1
11	6292752	Ext. Retaining Ring	STW-15	6
12	BB-6202ZZ	Ball Bearing	6202 ZZ	6
13	BGB248-213	Tracking Wheel Axle		2
14	BGB248-214	Tracking Wheel		2
15	5509829	Roll Pin	6 x 36L mm	1
16	50124003	Set Screw w/ thread lock	M6-1.0P x 8L	3
17	81011042	Pulley Cover		1
18	81011042	Pulley Cover Rear Plate		1
19	TS-1550031	Flat Washer	5.1 x 12 x 1T	7
20	TS-1533032	Phillips Pan Hd Machine Screw	M5-0.8P x 10L	2
21	BGB248-221	Poly V-Belt		1
22	50111027	Knob		1
23	F010433	Socket Head Set Screw	M8-1.25P x 40L	1
24	81021001	Housing		1
25	TS-1541031	Hex Nut	M8-1.25P	1
26	BGB248-226	Spindle Pulley		1
27	BGB248-227	Knob Screw		1
28	81031003	Dust Cover		1
29	BGB248-229	Hinge		1
30	TS-2361051	Lock Washer	M5	9
31	TS-2245102	Socket Head Button Screw	M5-0.8P x 10L	9
32	BGB248-232	Ratchet		1
33	TS-1503041	Socket Head Cap Screw	M6-1.0P x 16L	5



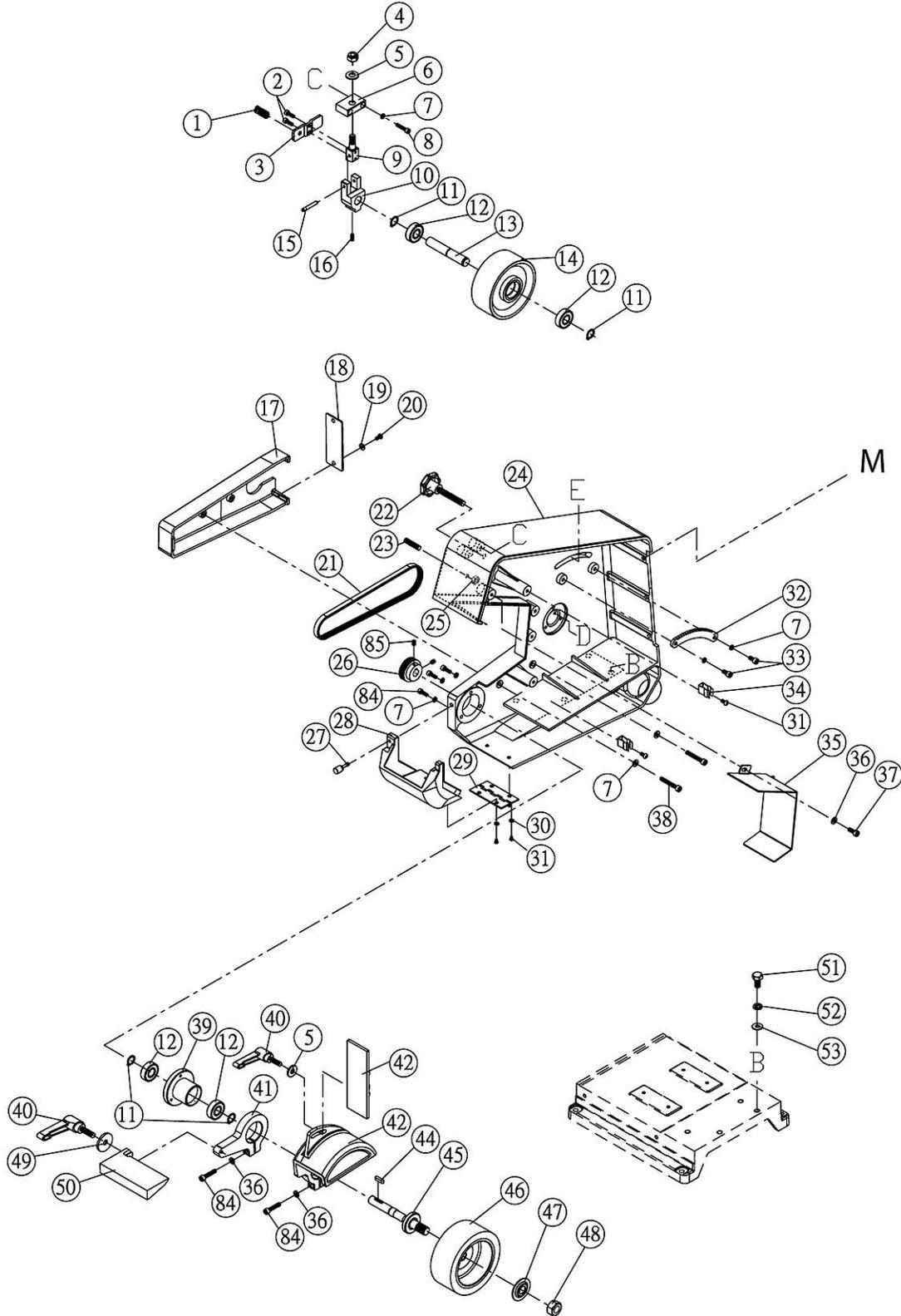
Item	Part No	Description	Size	Qty.
34	BGB248-234	Clip		2
35	BGB248-235	Spine Central Guard		1
36	TS-1550041	Flat Washer	6 x 12 x 1T mm	5
37	TS-1503021	Socket Head Cap Screw	M6-1.0P x 10L	3
38	TS-1503131	Socket Head Cap Screw	M6-1.0P x 60L	2
39	BGB248-239	Bearing Housing		1
40	BGB248-240	Universal Handle		2
41	81031007	Table Support Arm		1
42	81021005	Platen		1
43	81021004	Contact Wheel Cover		1
44	6296048	Key, Double Rd Head	5 x 5 x 25L mm	1
45	BGB248-245	Contact Wheel Spindle		1
46	BGB248-246	Contact Wheel		1
47	BGB248-247	Flange Washer		1
48	TS-0561071	Hex Nut	5/8"-11UNC	1
49	TS-1550061	Flat Washer	8 x 30 x 3T mm	1
50	BGB248-250	Work Rest		1
51	TS-1492011	Hex Cap Screw	M12-1.75P x 25L	4
52	TS-2361121	Lock Washer	M12	4
53	TS-155009	Flat Washer	13.5 x 28 x 3T mm	4
54	BGB248-254	Continuous Hinge		1
55	F009887	Socket Head Button Screw	M5-0.8P x 16L	3
56	BGB248-256	Side Cover		1
57	BGB248-257	Peg		2
58	TS-1540041	Hex Nut	M6-1.0P	2
59	BGB248-259	Door Latch		1
60	BGB248-260	Abrasive Belt	2"Wx48"L 120G	1
61	50204010	Knob		1
62	F010391	Socket Head Set Screw	M5 x 0.8P x 5L	1
63	BGB248-263	Hub Supporting Shaft		1
64	BGB248-264	Rod		1
65	TS-1532052	Phillips Pan Hd Machine Screw	M4 x 0.7P x 16L	1
66	BGB248-266	Tension Spring		1
67	TS-1540021	Hex Nut	M4-0.7P	1
68	BGB248-268	Tension Wheel Arm		1

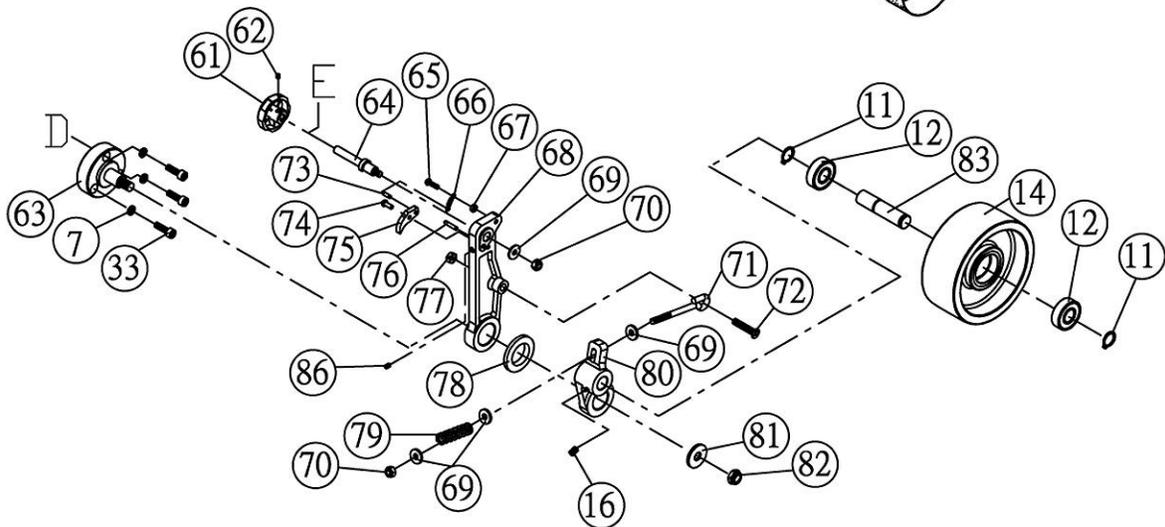
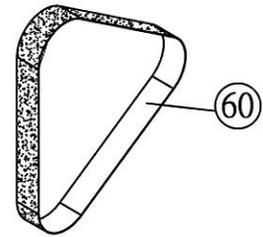
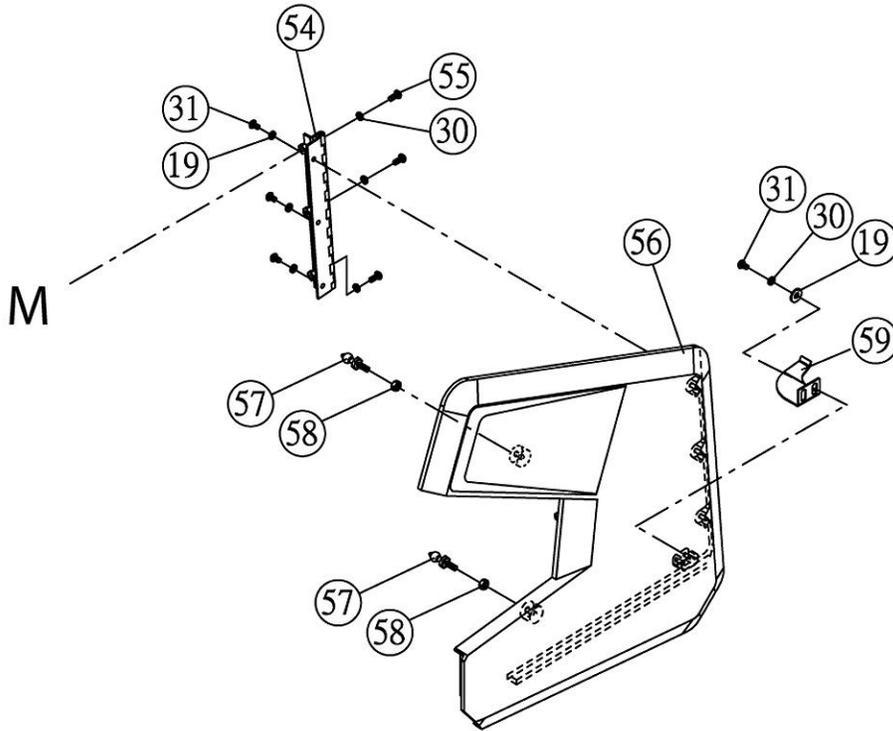


Item	Part No	Description	Size	Qty.
69	TS-1550041	Flat Washer	6.4 x 16 x 1.6T mm	4
70	TS-1541021	Hex Nut, Nylon Lock	M6-1.0P	2
71	BGB248-271	Spring Tension Adj. Rod		1
72	TS-134608	Phillips Flat Hd Machine Screw	1/4"-20UNC x 1-1/4"L	1
73	F012091	Roll Pin	3 x 10L mm	1
74	BGB248-274	Rivet		1
75	BGB248-275	Pawl		1
76	F012092	Roll Pin	3 x 18L mm	1
77	TS-0570011	Hex Nut	1/4"-20UNC	1
78	BGB248-278	Oilite Washer		1
79	BGB248-279	Compression Spring		1
80	BGB248-280	Tension Wheel Hub		1
81	TS-1550071	Flat Washer	10.2 x 30 x 3T mm	1
82	TS-0640091	Hex Nut, Nylon Lock	3/8"-16UNC	1
83	BGB248-283	Tracking Wheel Axle		1
84	50102008	Socket Head Cap Screw	M8-1.25P x 25L	5
85	50103040	Socket Head Set Screw	M4-0.7P x 6L	1
	LM000251	Warning Label (not shown)	2-1/2" x 5-1/4"	1
	LM000252	Belt Tracking Label (not shown)		1
	LM000253	Belt Tension Label (not shown)		1
	LM000254	Control Panel Label (not shown)		1
	81020304	ID Label, BG-248S (not shown)		1
	81020305	Motor Label, BG-248S (not shown)		1



# BELT AND HOUSING ASSEMBLY – EXPLODED VIEW – BG-260S







**Belt and Housing Assembly – Parts List – BG-260S**

Item	Part No	Description	Size	Qty.
1	BGB248-201	Compression Spring		1
2	TS-1502031	Socket Head Cap Screw	M5-0.8P x 12L	4
3	BGB248-203	Supporting Plate		1
4	TS-1541031	Hex Nut, Nylon Lock	M8-1.25P	1
5	TS-1550061	Flat Washer	8.5 x 19 x 2T	2
6	BGB248-206	Fixed Bracket		1
7	TS-2361061	Lock Washer	M6	12
8	50102026	Socket Head Cap Screw	M6-0.8P x 30L	2
9	BGB248-209	Pivoting Shaft		1
10	BGB248-210	Tracking Wheel Hub		1
11	6292752	Ext. Retaining Ring	STW-15	6
12	BB-6202ZZ	Ball Bearing	6202 ZZ	6
13	BGB248-213	Tracking Wheel Axle		2
14	BGB260-1-214	Tracking Wheel	7"	2
15	5509829	Roll Pin	6 x 36L mm	1
16	50124003	Set Screw w/ thread lock	M6-1.0P x 8L	3
17	81031004	Pulley Cover		1
18	81011042	Pulley Cover Rear Plate		1
19	TS-1550031	Flat Washer	5.1 x 12 x 1T	7
20	TS-1533032	Phillips Pan Hd Machine Screw	M5-0.8P x 10L	2
21	BGB260-1-221	Poly V-Belt		1
22	50111027	Knob		1
23	F010433	Socket Head Set Screw	M8-1.25P x 40L	1
24	81031001	Housing		1
25	TS-1541031	Hex Nut	M8-1.25P	1
26	BGB260-1-226	Spindle Pulley		1
27	BGB248-227	Knob Screw		1
28	81031003	Dust Cover		1
29	BGB248-229	Hinge		1
30	TS-2361051	Lock Washer	M5	9
31	TS-2245102	Socket Head Button Screw	M5-0.8P x 10L	9
32	BGB248-232	Ratchet		1
33	TS-1503041	Socket Head Cap Screw	M6-1.0P x 16L	5



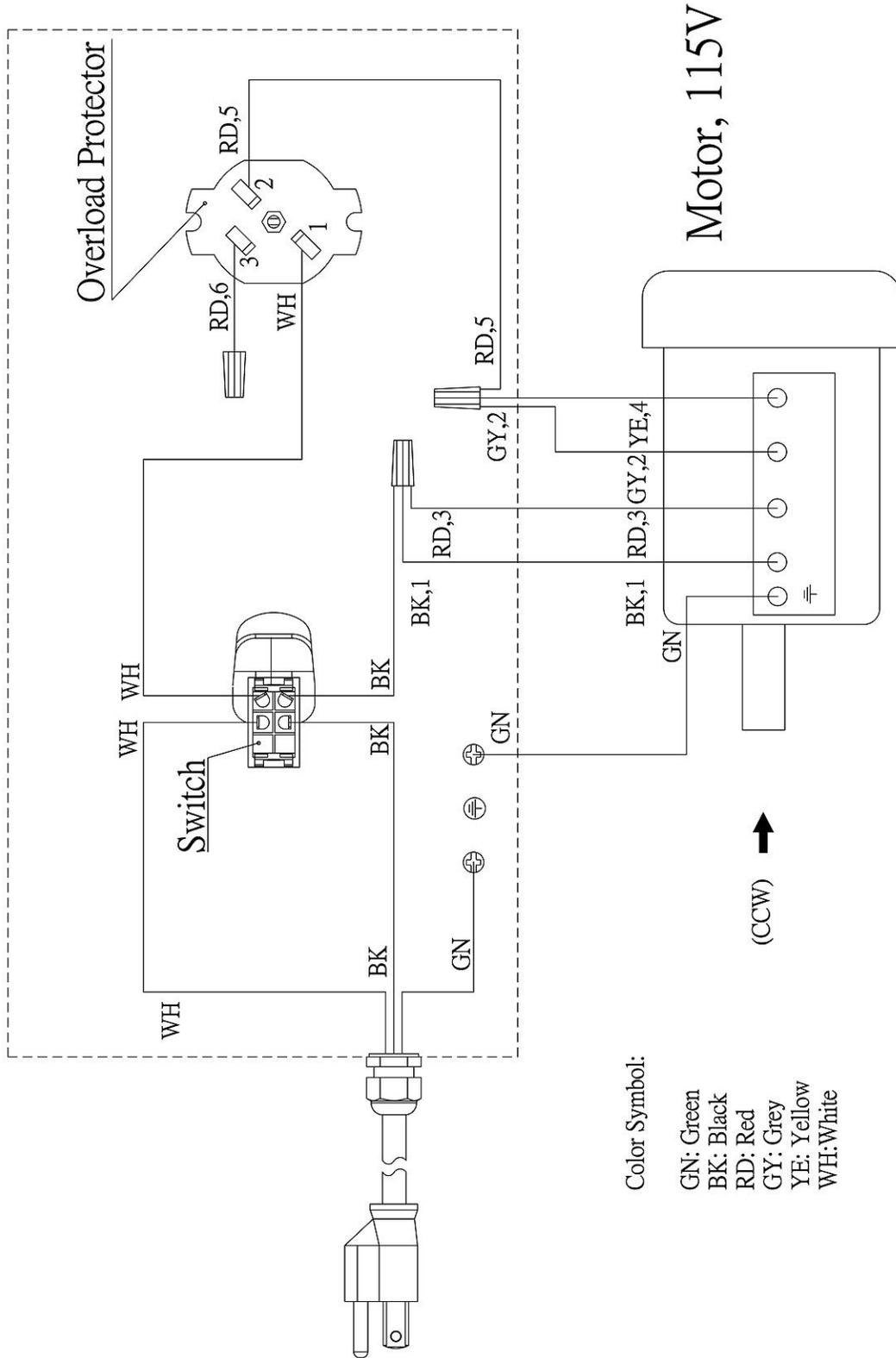
Item	Part No	Description	Size	Qty.
34	BGB248-234	Clip		2
35	BGB260-1-235	Spine Central Guard		1
36	TS-1550041	Flat Washer	6 x 12 x 1T mm	5
37	TS-1503021	Socket Head Cap Screw	M6-1.0P x 10L	3
38	TS-1503131	Socket Head Cap Screw	M6-1.0P x 60L	2
39	BGB248-239	Bearing Housing		1
40	BGB248-240	Universal Handle		2
41	81031007	Table Support Arm		1
42	81011012	Platen		1
43	81031005	Contact Wheel Cover		1
44	6296048	Key, Double Rd Head	5 x 5 x 25L mm	1
45	BGB248-245	Contact Wheel Spindle		1
46	BGB260-1-246	Contact Wheel	7"	1
47	BGB248-247	Flange Washer		1
48	TS-0561071	Hex Nut	5/8"-11UNC	1
49	TS-1550061	Flat Washer	8 x 30 x 3T mm	1
50	BGB248-250	Work Rest		1
51	TS-1492011	Hex Cap Screw	M12-1.75P x 25L	4
52	TS-2361121	Lock Washer	M12	4
53	TS-155009	Flat Washer	13.5 x 28 x 3T mm	4
54	BGB248-254	Continuous Hinge		1
55	F009887	Socket Head Button Screw	M5-0.8P x 16L	3
56	BGB260-1-256	Side Cover		1
57	BGB248-257	Peg		2
58	TS-1540041	Hex Nut	M6-1.0P	2
59	BGB248-259	Door Latch		1
60	BGB260-1-260	Abrasive Belt	2" W x 60" L 120G	1
61	50204010	Knob		1
62	F010391	Socket Head Set Screw	M5 x 0.8P x 5L	1
63	BGB248-263	Hub Supporting Shaft		1
64	BGB248-264	Rod		1
65	TS-1532052	Phillips Pan Hd Machine Screw	M4 x 0.7P x 16L	1
66	BGB248-266	Tension Spring		1
67	TS-1540021	Hex Nut	M4-0.7P	1
68	BGB248-268	Tension Wheel Arm		1



Item	Part No	Description	Size	Qty.
69	TS-1550041	Flat Washer	6.4 x 16 x 1.6T mm	4
70	TS-1541021	Hex Nut, Nylon Lock	M6-1.0P	2
71	BGB248-271	Spring Tension Adj. Rod		1
72	TS-134608	Phillips Flat Hd Machine Screw	1/4"-20UNC x 1-1/4"L	1
73	F012091	Roll Pin	3 x 10L mm	1
74	BGB248-274	Rivet		1
75	BGB248-275	Pawl		1
76	F012092	Roll Pin	3 x 18L mm	1
77	TS-0570011	Hex Nut	1/4"-20UNC	1
78	BGB248-278	Oilite Washer		1
79	BGB248-279	Compression Spring		1
80	BGB248-280	Tension Wheel Hub		1
81	TS-1550071	Flat Washer	10.2 x 30 x 3T mm	1
82	TS-0640091	Hex Nut, Nylon Lock	3/8"-16UNC	1
83	BGB248-283	Tracking Wheel Axle		1
84	50102008	Socket Head Cap Screw	M8-1.25P x 25L	5
85	50124006	Set Screw w/ thread lock	M5-0.8P x 8L	2
86	50103040	Socket Head Set Screw	M4-0.7P x 6L	1
	LM000251	Warning Label (not shown)	2-1/2" x 5-1/4"	1
	LM000252	Belt Tracking Label (not shown)		1
	LM000253	Belt Tension Label (not shown)		1
	LM000254	Control Panel Label (not shown)		1
	81030310	ID Label, BG-260S (not shown)		1
	81030311	Motor Label, BG-260S (not shown)		1



**WIRING DIAGRAM – 115V (BG-141S/248S/260S)**





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