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PLEASE FILL OUT AND RETURN IN SELF ADDRESSED ENVELOPE.

COMPANY NAME: _____
ADDRESS: _____

TELEPHONE: _____
CONTACT NAME: _____

MACHINE SERIAL NUMBER: _____

A COPY OF THE INSTRUCTION MANUAL AND WARRANTY HAS BEEN
RECEIVED BY: _____

Signature

_____ Date

INDEXING TABLE
MANUAL



1) Introduction

- a) You have made a practical choice in purchasing an RMD, INC. IDX-10 Positioning/Index Table. It has been carefully built of high quality materials and designed to give many years of efficient service. The simplicity of design and minimum effort required to operate this attachment contributes towards meeting schedules and producing greater profits.
- b) The IDX-10 Indexing table was designed to allow you to accurately and repeatedly position distances between bends, by using the adjustable stops. Also the IDX-10 can be used to hold the material being bent perfectly level while bending, or altering the angles between bends.

2) Unpacking

- a) After receiving the attachment, visually inspect for damage. Any damage should be reported immediately to Baileigh Industrial.

3) Connection to your machine

- a) Remove the shaft mounting bracket [#2] (angle iron) leaving the slide shaft [#16] in place.
- b) Slide the front of the main track tube [#1] onto the slide shaft [#16].
- c) Reattach the shaft mounting bracket [#2] and tighten bolts.
- d) With the front of the main track tube attached, lift up the rear and support it with a sturdy saw horse or equal.
- e) Attach the rear leg adjuster [#13] using the supplied 3/8 X 1" bolts.
- f) Align the keyways with the slide bolt and slip the caster mount [#12] onto the leg adjuster [#13].

4) Height Adjustment and Leveling

- a) Level your machine on a flat hard surface. (The index table must be allowed to pivot and rotate with the casters.)
- b) With the machine level, choose the desired die set.
- c) The thickness of the die determines the height of the index table. Using the chart shown below find the correct number of turns required for your die.
- d) Rotate the height adjustment screw [#21] clockwise until it stops. This is the lowest the table will go. (EXAMPLE 1-1/2 die)
- e) Rotate the adjustment screw [#21] counter clockwise the exact number of turns that were chosen from the chart.
- f) Using a 2 ft level placed on the main track tube, rotate the large nut [#35] until the main track tube is level.
- g) Position the front of the main track tube so the center line of the track tube matches the center (radius) line of the die.



5) **Material layout**

- a) Before you can use the IDX table, your first piece of material needs to be laid out. Using Diagram1 and Table1 you can determine all of the bend start points, these points should be transferred to the material using a fine point sharpie marker. This diagram is a generic two bend scenario, for more complex parts the steps are generally the same.

6) **Operation**

- a) After the connection to your machine is complete, and the height and center line positions are verified, the IDX-10 can be used.
- b) Your first part should now be clearly marked. These marks will be used to position the tubing perfectly with the “0” mark on the die, and to set your IDX stops. Only your fist part needs to be marked, after that the IDX stops will be used.
- c) Insert a piece of material through the hook arm of the die being used and insert through the chuck. (note: If multiple parts are being produced, the material should be marked so the chuck position can be repeated) position the material so the start of bend mark lines up with the “0” mark on the die, now set your first stop on the index table and produce the first bend. **NOTE:** The complete table will swing, be sure not to interfere with the motion.
- d) After the bend is complete, the die must return to home **CAUTION! Make sure the hook arm of the die does not catch the tubing when returning.** Once the die is home, the material can be advanced and rotated (if required) to the next “0” mark. The next stop can now be set. Repeat as required, your IDX table comes standard with (4) stops.
- e) The previous steps are just examples how to set stops and produce various bends, it is up to the user to define exactly how his/her IDX will be set up. Baileigh Industrial will be glad to offer any suggestions for your application.

HEIGHT ADJUSTMENT	
CCW TO RAISE	
TURNS CCW	DIE THICKNESS
0.0=	1.50
2.5=	2.00
5.0=	2.50
7.5=	3.00
10.0=	3.50

WARRANTY & Other Legal Information

Inspection & Acceptance. Buyer shall inspect all Goods within a reasonable period of time after delivery, not to exceed ten (10) days. If Buyer rejects any Goods, Buyer must first obtain a Return Authorization Number (“RAN”) before returning any goods to Seller. Goods returned without a RAN 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 RAN. 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 unsaleable 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 RAN 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 RAN. 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. 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, lightning, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

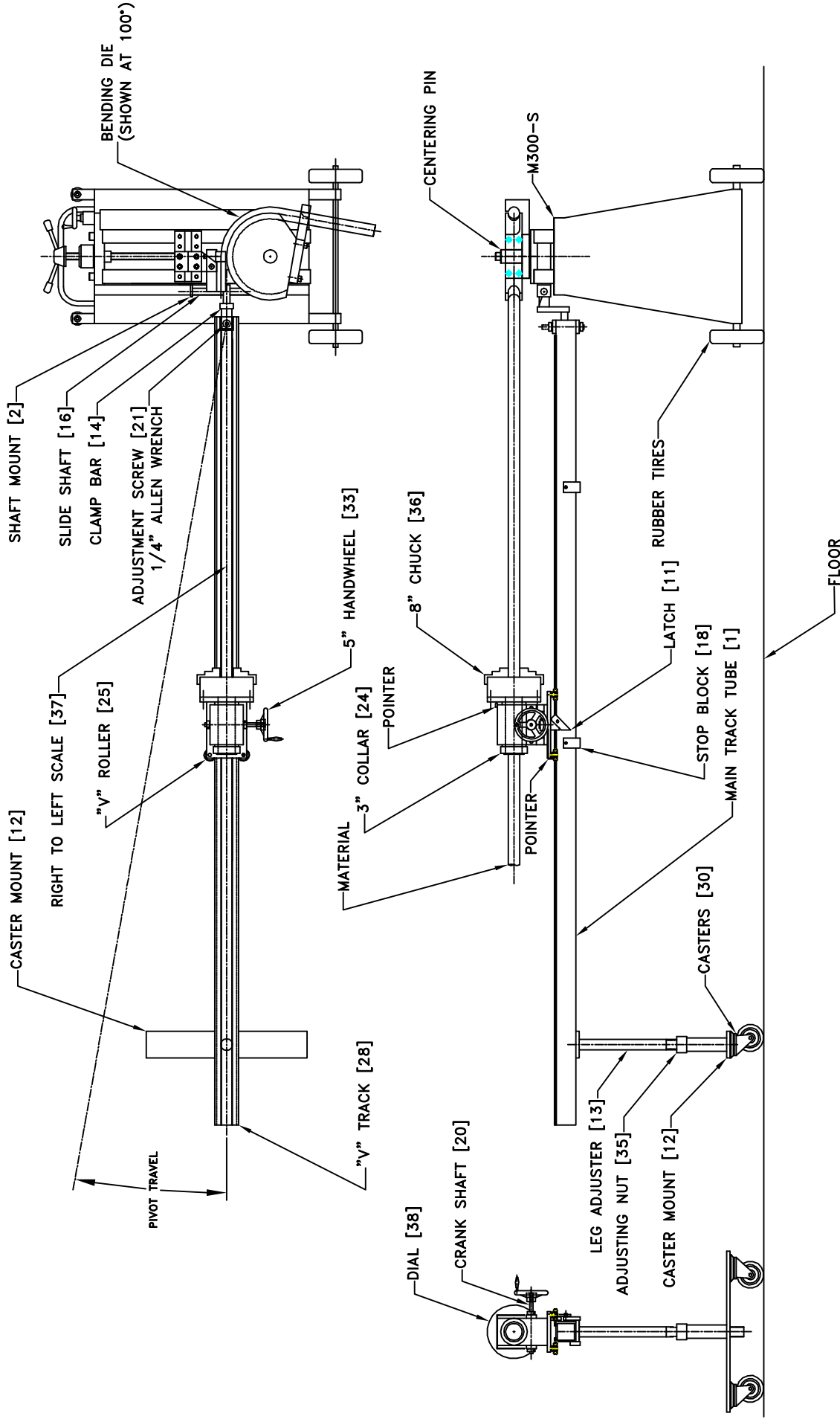
Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all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

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing, and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator's manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorneys' fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. EACH PARTY WAIVES TO THE FULLEST EXTENT PERMITTED BY APPLICABLE LAW THE RIGHT TO A TRIAL BY JURY.



Rusch Machine & Design, Inc.
Two Rivers Wisconsin

TITLE M300-S FLOOR PLAN WITH INDEX TABLE

DRAWN BY: C. RUSCH

DATE 24-JUL-00

DRAWING NUMBER FP-0006

TABLE 1

ARC LENGTH TABLE

EXAMPLE: ARC LENGTH = CONSTANT X BEND RADIUS

EXAMPLE: 90DEG BEND WITH 6" CLR

EXAMPLE: 1.575 (FROM TABLE) X 6" (CLR) =9.45" (ARC LENGTH)

FOR BENDS MORE THAN 90 DEG, CONSTANTS CAN BE ADDED TOGETHER

DEGREES	CONSTANT	DEGREES	CONSTANT	DEGREES	CONSTANT
1	0.0175	31	0.5410	61	1.0645
2	0.0349	32	0.5584	62	1.0819
3	0.0524	33	0.5759	63	1.0994
4	0.0698	34	0.5933	64	1.1168
5	0.0873	35	0.6108	65	1.1343
6	0.1047	36	0.6282	66	1.1517
7	0.1222	37	0.6457	67	1.1692
8	0.1396	38	0.6631	68	1.1866
9	0.1571	39	0.6806	69	1.2041
10	0.1745	40	0.6980	70	1.2215
11	0.1920	41	0.7155	71	1.2390
12	0.2094	42	0.7329	72	1.2564
13	0.2269	43	0.7504	73	1.2739
14	0.2443	44	0.7678	74	1.2913
15	0.2618	45	0.7853	75	1.3088
16	0.2792	46	0.8027	76	1.3262
17	0.2967	47	0.8202	77	1.3437
18	0.3141	48	0.8376	78	1.3611
19	0.3316	49	0.8551	79	1.3786
20	0.3490	50	0.8725	80	1.3960
21	0.3665	51	0.8900	81	1.4135
22	0.3839	52	0.9074	82	1.4309
23	0.4014	53	0.9249	83	1.4484
24	0.4188	54	0.9423	84	1.4658
25	0.4363	55	0.9598	85	1.4833
26	0.4537	56	0.9772	86	1.5007
27	0.4712	57	0.9947	87	1.5182
28	0.4886	58	1.0121	88	1.5356
29	0.5061	59	1.0296	89	1.5531
30	0.5235	60	1.0470	90	1.5705

EXAMPLE

$C1 = D2$
 $C2 = D2 + A1 + D4$
 $CUT\ LENGTH = D2 + A1 + D4 + A2 + D2$
 $C1 = 24"$
 $C2 = 79.45"$
 $CL = 112.9"$
 $(C2 = 24" + 9.45" + 46")$
 $(CUT\ LENGTH = 24" + 9.45" + 46" + 9.45" + 24")$

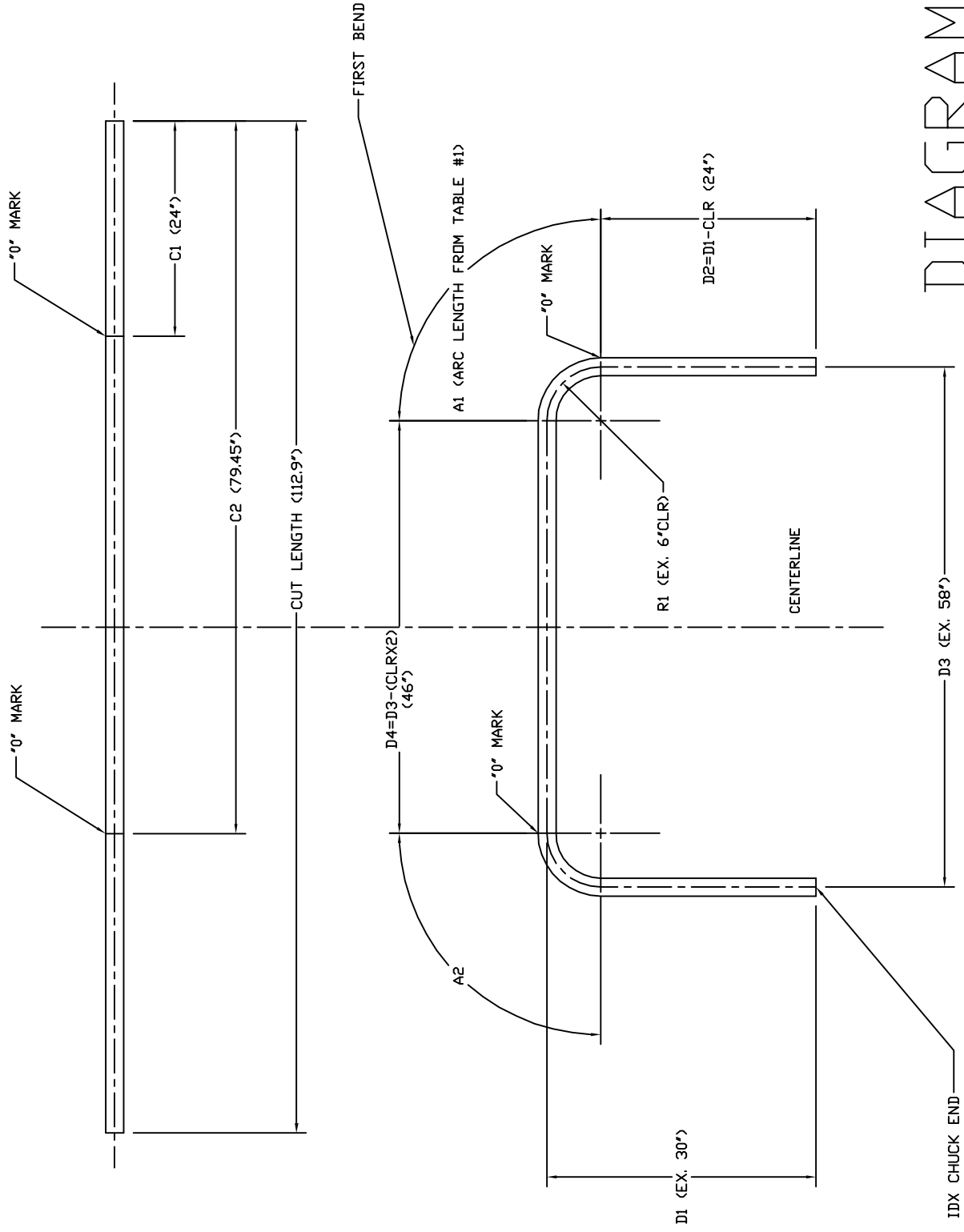


DIAGRAM 1