

Operating:

1.to clamp the workpiece with the dies, to make the edge of the sliding block #3 close to the workpiece by turning the handle #23.to turn the rotary block #10 by the handle #9 to bend the workpiece as you like.

2.to turn the eccentric shaft #14 and loose the block #1, the workpiece can be taken out.

Lubricating:

1.there are enough lubrication oil between the rotary block #10 and the base #12 when assembly in our factory.Don't open them,thus can cause the fixed shaft #11 lossen and result in the machine can not use.

2.the lubricating of the sliding block:(every half year to one year):loose the screw #4,take out the press plate #6,turn the handle#23,screw out the scre shaft #19 from the sliding block#3,add the lubrication oil to the shaft and sliding body holes, add the lubrication oil into the slot after take out the sliding body.After finished the lubricating ,please screw the shaft into the slide body counterclockwise and then fixed the press plate #6,it's ok for starring work.

PARTS LIST

Part#	Description	Qty	Part#	Description	Qty
1	Block	1	13	squaare nut	1
2	Die Plate	1	14	Eccentric shaft	1
3	Sliding block	1	15	shaft	1
4	Screw M3 x 20	2	16	Handle nut M8X15	1
5	stopped shaft	1	17	Gauge Clamp	1
6	Press Plate	1	18	Gauge Shaft	1
7	Bolt M10X25	2	19	Screw shaft	1
8	Washer 10	2	20	Cover Plate	1
9	Handle	1	21	Spring pin 5X30	1
10	Rotary block	1	22	Screw M8x16	4
11	Fixed shaft	1	23	Handle	1
12	base	1	24		

it has been found that to ensure a better bend and put less load on the operator and machine
That after winding in the bending jaw # 30 (knob 23) it needs to be wound out one to three turns depending on the
thickness of material.
Thicker the material the more it should be wound out

