

INSTRUCTION MANUAL

NSW Schools / TAFE - SJ-2 Swage, Jenny 1.6mm



K8341

R.R. BRAMLEY & CO. LTD.

ESTABLISHED 1921

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OPERATING INSTRUCTIONS & PARTS LIST

SJ2 SWAGING & JENNYING MACHINE



AUSTRALIAN OFFICE

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Thank you for purchasing this High Quality, Industrial Duty, Swaging Machine.

This Machine has been constructed from High Grade Grey Iron, which combines good strength whilst also providing very good running surfaces for the Rotating Shafts and Slider Blocks.

All machining has been carried out on the latest computer controlled machinery to exacting standards. Drive Gears have been Precision Machined to provide very smooth operation and long life.

With care and regular lubrication your new machine will provide years of efficient service.

BEFORE USE:

The machine has had rust preventative applied to all exposed parts. This should be thoroughly cleaned and replaced, as required, with a thin smear of light machine oil. Securely fasten to a stable work bench.

LUBRICATION:

Apply grease regularly (fortnightly) to all nipples provided. A few drops of oil onto the Slider Bearing (12) and the Gears is also recommended.

OPERATION:

The Bottom Shaft slides forwards and backwards to allow easy centralising the Top and Bottom Wheels. This can be done by first loosening the Clamp Knob (29) and then using the Adjustable Knob (27) on the other side of the machine to slide the Shaft to the desired position.

The Guide Plate can be positioned where required to operate as a depth stop with a range up to 240mm.

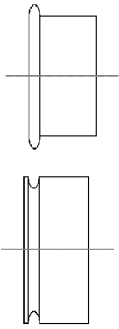
The Top shaft pivots up and down and is lowered during operation by means of the Top Handle (11). This Handle is slowly screwed down while rotating the Shafts back and forth. Slowly forming the bend in this manner will help to overcome possible cutting or splitting of Sheet Metal.

Once the desired form has been achieved the two wheels can be separated by unscrewing the Top Handle. The spring loaded Top Shaft will be raised automatically as this Handle is unscrewed.

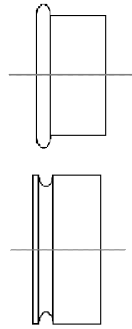
SWAGE & JENNY 2 MACHINE

PART	DESCRIPTION	QTY
7701	BODY – MAIN CASTING	1
7702	CASTING – COVER TOP	1
7703	LEVER CASTING	1
7704	BLOCK – SHAFT BEARING - FRONT	1
7705	BLOCK – SHAFT BEARING - REAR	1
7706	GUIDE BRACKET	1
7707	GUIDE PLATE	1
7708	PUR GEAR - TOP	1
7709	SPUR GEAR - BOTTOM	1
7710	FINGER – LINEAR ADJUSTMENT	1
7711	SCREW - PRESSURE	1
7712	BUSH – SLIDING	1
7713	SHAFT - LINEAR LOCK	1
7714	SHAFT – GUIDE BRACKET	2
7715	SPIGOT – SPRING LOCATION	1
7716	SPRING – SHAFT RELEASE	1
7717	SPANNER	1
7718	SHAFT – TOP	1
7719	SHAFT - BOTTOM	1
7720	RETAINING COLLAR – TOP SHAFT	1
7721	PUSHER PIN – LINEAR ADJUSTMENT	1
7722	SPINDLE – LINEAR ADJUSTMENT	1
7723	SHAFT – HANDLE LEVER	1
7724	HANDLE LEVER	1
7725	LOCKING NUTS	2
7726	SPACE COLLARS	2
7727	HAND KNOB – LINEAR ADJUSTMENT	1
7728	HAND KNOB – SHAFT GUIDE BRACKET	2
7729	HAND KNOB – LOCK LINEAR ADJUSTMENT	1
7730	KEY	1
7731	2mm WIRING / JENNYING / ROLLER - TOP	1
7732	2mm WIRING ROLLER - BOTTOM	1
7733	4mm WIRING ROLLER - TOP	1
7734	4mm WIRING ROLLER - BOTTOM	1
7735	7mm WIRING ROLLER - TOP	1
7736	7mm WIRING ROLLER - BOTTOM	1
7737	PIVOT SCREW – BEARING BLOCK	2
7738	JENNY ROLLER – BOTTOM	1
7739	FLAT ROLLER - TOP	1
7740	CRIMPING ROLLERS	2

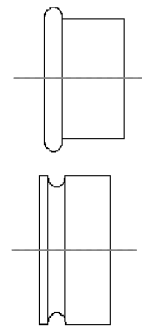
STANDARD ACCESSORIES



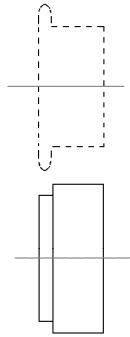
**2mm SWAGE
OR WIRING**



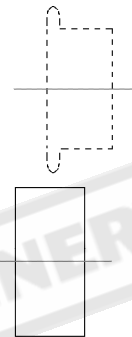
**4mm SWAGE
OR WIRING**



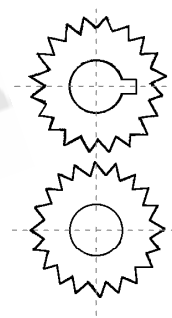
**7mm SWAGE
OR WIRING**



JENNYING

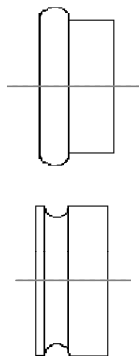


CLOSING

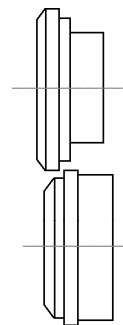


CRIMPING

OPTIONAL ACCESSORIES



**10mm SWAGE
OR WIRING**



NECKING

OPTIONAL ACCESSORIES

PART	DESCRIPTION	QTY
A2	10mm WIRING ROLLER – TOP	1
A3	10mm WIRING ROLLER – BOTTOM	1
A4	NECKING ROLLER – TOP	1
A5	NECKING ROLLER – BOTTOM	1

PURCHASED ITEMS

PART	DESCRIPTION	QTY
C1	M8 x 45 CAP SCREW	6
C2	M8 x 25 CAP SCREW	2
C3	M8 x 20 COUNTERSINK SCREW	2
C4	M6 x 25 SET SCREW	1
C5	M6 x 45 ROLLING PIN	4
C6	M4 x 25 ROLLING PIN	2
C7	M12 NUT	1
C8	M10 FLAT WASHER	1
C9	M10 STARLOCK DOME	1
C10	M10 NUT	1
C11	1/8" BSP GREASE NIPPLE	4