

Safety/Operating Instructions

Bramley ProBender 35t Powered Bender

35 tonne force / 415V, 3PH



Bramley ProBender 35t Powered Bender

Introduction

The ProBender 35t Bending Machine is a hydraulically powered metal bender for thick material. It comes as supplied with:

- Base Machine
- Angle Folding Attachment - 100mm
- Mandrel for Bending
- Adjustable Back Gauge for positioning
- Storage Shelves
- Pressure Gauge
- Electric Starter with Emergency Stop

There are many bending tooling options available for the machine to provide a wide range of bending operations. Optional accessories such as Pipe Bending / Radius tools can further increase the versatility of the machine. This multi-function aspect allows the ProBender 35t Bending Machine to meet the diversified needs of the metal forming industry.

Each machine has been individually tested in the factory and undergone an extensive pre-delivery check to ensure that the machines meet the highest quality standard. The bending machine has been designed to be a reliable and dependable machine with excellent performance.

In order to have a good understanding of the operating procedures to obtain maximum benefits from the machine, and to minimize maintenance costs for the equipment, please have all operators and engineers read this Manual thoroughly and carefully before operating the machine.

Mild Steel Bending Capacity

- Flat Bar: 100mm x 10mm / 60mm x 12mm / 50mm x 16mm
- Square Bar: 25mm x 25mm
- Round Bar: Ø25mm

Pipe Bender Optional Accessory (Separate Supply)

The Bramley ProBender 35t can be supplied with Pipe Bender Frame and Formers for pipe bending from 1/2" to 2" N.B. Other accessories also available on request.



Safety Precautions

IMPORTANT: It is the duty of both employer and employees to acquaint themselves with the safe working practices contained in this manual and ensure that all operators adopt these practices.

This equipment, if not operated and maintained properly, has the potential to cause serious injury or death. A thorough knowledge of the machine and operating with care is the best protection against accidents.

The operator should be familiar with the control and function of the switches before performing any operation.

Warning labels are fixed on the machine. **NEVER REMOVE THESE LABELS.** Be sure to follow these warnings to avoid injury.

Please also pay attention to the following general rules:

1. Only one operator is allowed to operate the ProBender 35t bending machines. Before each operation, make sure no other person is near the machine.
2. Operator must wear Protective Glasses during operation to protect the eyes.
3. Use of optional attachments/tooling should have proper guards installed.
4. Any maintenance, repair of electrical/hydraulic circuit, machine setting changes or adjustment of tooling should be only done by trained personnel.
5. Always turn off power and disconnect electric supply before doing any tool change or maintenance work.
6. Keep hands clear of all moving parts at all times.
7. Do not bend, punch, or shear parts that are too small for safe operation.
8. If any problem or abnormal condition arises during operation, stop the machine immediately and report to a supervisor. Do not turn on the machine again until the problem is rectified by qualified personnel.
9. The machine should never be left under power when not in operation or unattended. After completion of work, always isolate the machine power supply after turning the power off.
10. After completion of operation, all slugs and waste materials must be cleaned away from the machine.
11. Regularly check tooling for defects and wear to ensure safety, and to maintain in good condition.
12. Use handling equipment when lifting heavy tooling and materials.
13. Never exceed the rated capacity of the machine (hydraulic pressure is set to 4,000psi/28MPa max.)

The manufacturer shall not be liable for any damages/body injuries or other consequences to machine, material, and persons caused by the non-compliance of the above safety precaution procedures, in particular for the following situations:

1. **Did not wear protective glasses for the eyes.**
2. **Did not interrupt the main electric power supply before any maintenance work.**
3. **Damage of electric parts due to incorrect electric power supply.**

DANGER

- KEEP HANDS CLEAR OF ALL MOVING PARTS.
- ALL GUARDS AND HOLD-DOWNS MUST BE IN POSITION BEFORE OPERATING THE MACHINE.
- ALL SAFETY PROTECTION MUST BE IN POSITION BEFORE OPERATING THE MACHINE.



KEEP HANDS CLEAR OF ALL MOVING PARTS WHILE OPERATING



• KEEP HANDS CLEAR OF ALL MOVING PARTS.
• ALL SAFETY PROTECTION MUST BE IN POSITION BEFORE OPERATING THE MACHINE.



• THOROUGHLY READ THE OPERATIONAL MANUAL BEFORE OPERATING THE MACHINE.
• TURN OFF POWER AND ISOLATE THE MACHINE WHEN CHANGING TOOLING OR DOING MAINTENANCE.
• ALL MAINTENANCE/REPAIR WORK MUST BE DONE BY QUALIFIED PERSONNEL.
• IF ANY PROBLEM OR ABNORMAL CONDITION OCCURS, STOP THE MACHINE IMMEDIATELY. DO NOT OPERATE THE MACHINE AGAIN UNTIL THE PROBLEM IS FIXED.

WARNING

THIS MACHINE HAS BEEN FACTORY SET TO 4000 PSI / 28 MPa AND TESTED. ANY TAMPERING OR ADJUSTMENTS MADE BY UNAUTHORISED PERSONNEL TO THE MACHINE WILL NEGATE ALL WARRANTIES AND ANY LIABILITY FOR SUBSEQUENT INJURIES SUFFERED.

Proper environmental conditions

Ambient temperature: 0 - 50 °C

Relative humidity: 20 - 85%

The required space around the machine is at least 1000 mm.

CAUTION

- THOROUGHLY READ THE OPERATION MANUAL BEFORE OPERATION.
- TURN OFF POWER AND ISOLATE THE MACHINE WHEN CHANGING TOOLING OR DOING MAINTENANCE.
- ALL MAINTENANCE/REPAIR WORK MUST BE DONE BY QUALIFIED PERSONNEL.
- IF ANY PROBLEM OR ABNORMAL CONDITION OCCURS, STOP THE MACHINE IMMEDIATELY. DO NOT OPERATE THE MACHINE AGAIN UNTIL THE PROBLEM IS FIXED.

Operators's working position

