

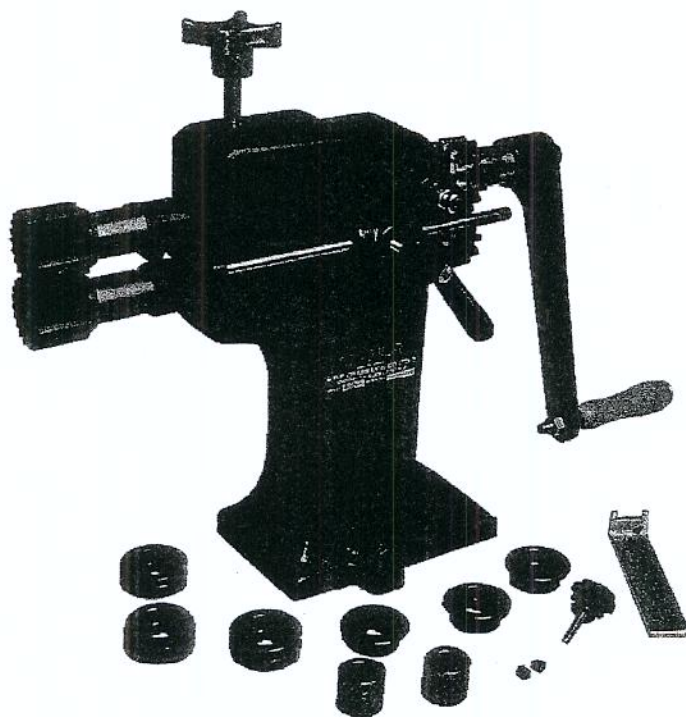
R.R. BRAMLEY & CO. LTD.

ESTABLISHED 1921

S520

OPERATING INSTRUCTIONS & PARTS LIST

SJ1 SWAGING & JENNYING MACHINE



AUSTRALIAN OFFICE

**TELEPHONE: 2-9534-1244 FACSIMILE: 2-9534-6932 EMAIL: ghpl@ozemail.com.au
60 BARRY AVENUE, MORTDALE, NSW 2223, AUSTRALIA.
P.O. BOX 151, MORTDALE, NSW 2223, AUSTRALIA**

Thank you for purchasing this High Quality, Universal Swaging & Jennying 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 Square Block.

All machining has been carried out on the latest computer controlled machinery to exact 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 general purpose oil, regularly (fortnightly) to all Lubrication Points.

OPERATION:

The Bottom Shaft slides forwards and backwards to allow easy centralizing of the Top and Bottom Wheels. This can be done by first loosening the Set Screw (C7) and then using the Adjusting Lever – Bottom Shaft (5).

The Guide Plate (12) can be positioned where required to operate as a depth stop with a range up to 100mm.

The Top Shaft pivots up and down and is lowered during operation by means of Knob (11). Slowly forming the bend in this manner will help to overcome possible cutting or splitting of the Sheet Metal. Once the desired form has been achieved the two wheels can be separated by unscrewing the Top Knob. The Top Shaft on this model is not spring assisted and can be lifted manually once the Top Knob (11) is unscrewed.

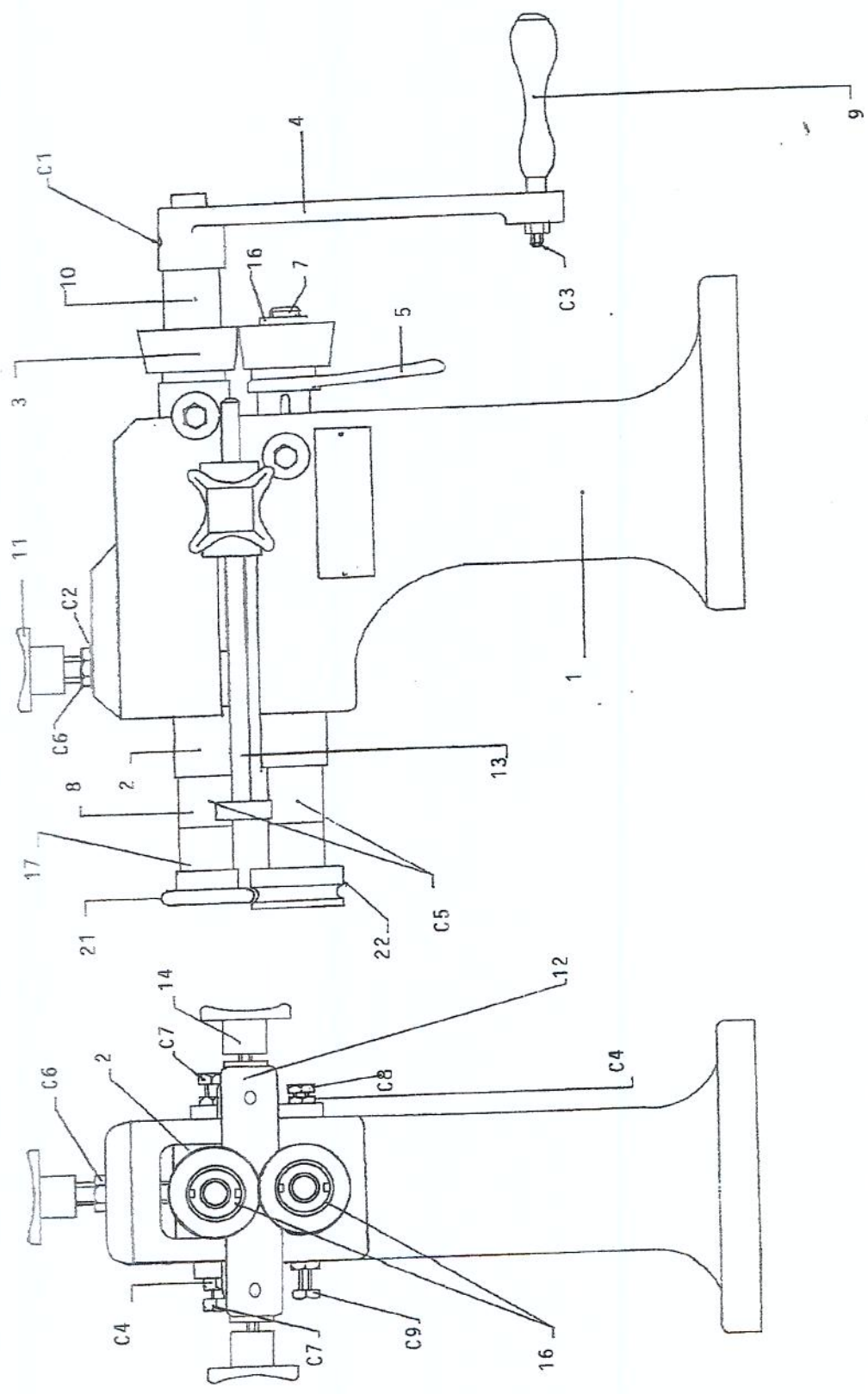
Wheels can be changed by using the Spanner provided to release the specially slotted Nuts (16). Crimping Wheels are supplied standard with this Model. When they are able to be assembled to the Machine it should be noted that only one "Keyed" Crimping Wheel is required. This is assembled onto the Top Shaft (6) using the Key supplied.

SWAGE & JENNY 1 MACHINE

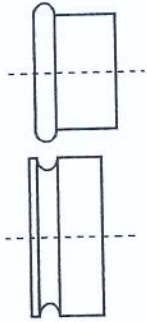
PART	DESCRIPTION	QTY
7601	BODY	1
7602	SQUARE BLOCK – TOP SHAFT	1
7603	GEARS	2
7604	HANDLE ARM	1
7605	ADJUSTING LEVER – BOTTOM SHAFT	1
7606	TOP SHAFT	1
7607	BOTTOM SHAFT	1
7608	COLLAR – SHAFT	2
7609	HANDLE	1
7610	COLLAR – GEAR	1
7611	ADJUSTABLE HANDLE – TOP SHAFT	1
7612	GUIDE PLATE	1
7613	GUIDE	2
7614	KNOB – GUIDE	2
7616	NUT	2
7617	COLLAR ROLLER	2
7618	CRIMPING ROLLER	2
7619	SMALL SWAGE ROLLER – TOP	1
7620	SMALL SWAGE ROLLER – BOTTOM	1
7621	LARGE SWAGE ROLLER – TOP	1
7622	LARGE SWAGE ROLLER – BOTTOM	1
7623	JENNY ROLLER – TOP	1
7624	JENNY ROLLER – BOTTOM	1
7625	SPANNER	1
7626	KEY SET	1

PURCHASED ITEMS

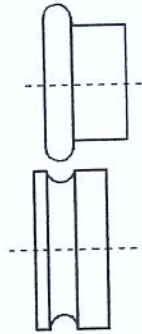
PART	DESCRIPTION	QTY
C1	M8 x 8 GRUB SCREW	1
C2	12mm FLAT WASHER	1
C3	M10 x 130 COACH BOLT	1
C4	M8 NUT	4
C5	1/8" x 1 1/4" TENSION PIN	2
C6	M12 NUT	1
C7	M8 x 40 SET SCREW	2
C8	M8 x 50 SET SCREW	1
C9	M8 x 35 SET SCREW	1



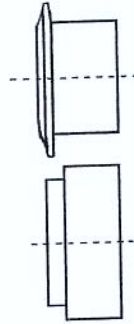
STANDARD ACCESSORIES



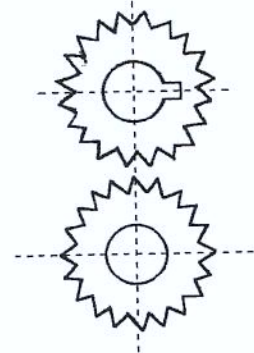
5mm SWAGE
OR WIRING



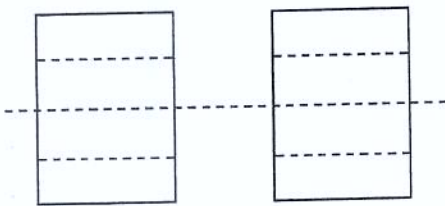
8mm SWAGE
OR WIRING



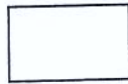
JENNYING



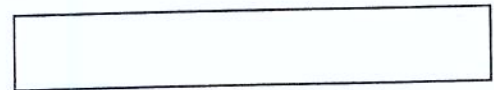
CRIMPING



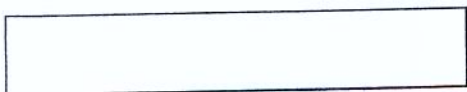
SPACING COLLARS



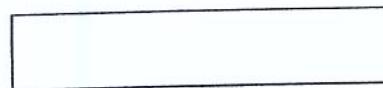
ROLLER KEY x 2



HANDLE ARM KEY x 1



CRIMPING ROLLER KEY x 1



GEARS KEY x 2