



ISITAN

USER MANUAL

MODEL

IK – 1,2

HAND OPERATED SWAGER



Order Code S642

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GENERAL NOTES

1. Introduction

Thank you for choosing a Isitan Sheet Metal Working Machine. We are proud to have you in our long list of satisfied customers all over the world.

This User's Manual is absolutely for your safety and is essential for the machine to have a long production life. As long as you keep up with our Manual you will be able to run your machine smoothly and safely. Keep in mind that the machine is designed absolutely to perform maximum safety and for efficient working.

In this manual you can find instructions and information about::

Simple safety regulations

Maintenance instructions

Machine Operation in

Simple rolls draw

Therefore, as far as the user's safety is concerned, in this handbook the possible risks connected with machine operation are pointed out as follows:

On all steps of installation, operation and maintenance safety must be your first concern for the protection of yourself, other users and the service of the machine.

In case of any failure please first refer to this manual and then if a solution cannot be found contact first of all the distributor where you purchased our product. Do not forget to refer to the drawings and the numbers for any spare part needed or to define any problem. Make sure you have the serial number and production year of the machine.

Our technical staff will make their best effort to help you in the most convenient way.

2. Maintenance

Your machine is designed and produced to work efficiently and smoothly. To achieve this you should also take care while operating the machine. Regard Maintenance sections to have the longest life from your machine. Try and use original spare parts where necessary and most importantly do not overload the machine or do not make any unauthorized modifications.

3. Safety

Take all precautions possible to avoid any personal injury while using the machine. Keep in mind to protect the third party people around the machine. Refer to safety instructions.

TECHNICAL PROPERTIES

As a superior model in their own class the IK – 1,2 is a multi purpose trimming machines. Technical informations of IK-1,2 is given below

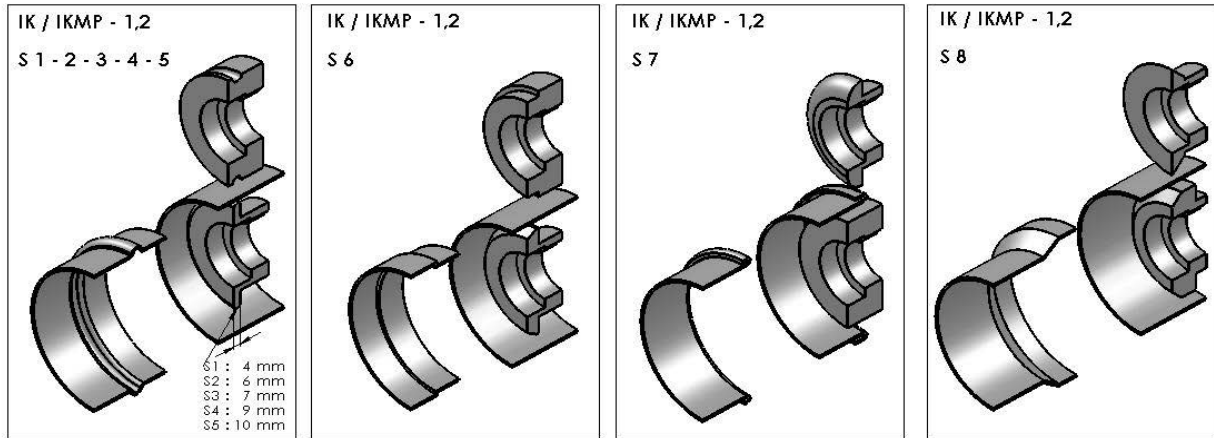
MODEL	Shaft length	Bordering Capacity	Roll diameter	Throat Depth	Length	Width	Heigth	Weight
	mm	mm	mm	mm	mm	mm	mm	Kg
IK 1,2	140	1,2	62	100	560	220	500	50



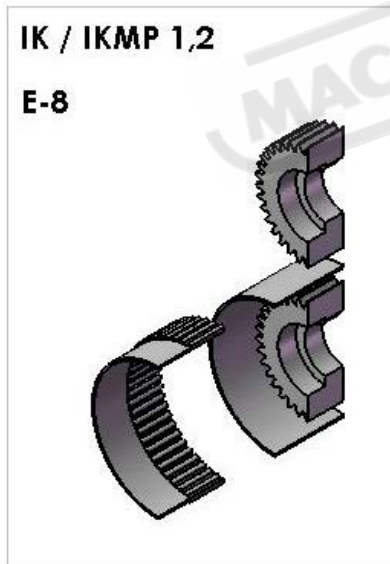
IK - 1,2

It is equipped 8 sets of rolls in standard.

Standard Roll Sets for IK – 1,2



Extra Roll Set for IK – 1,2



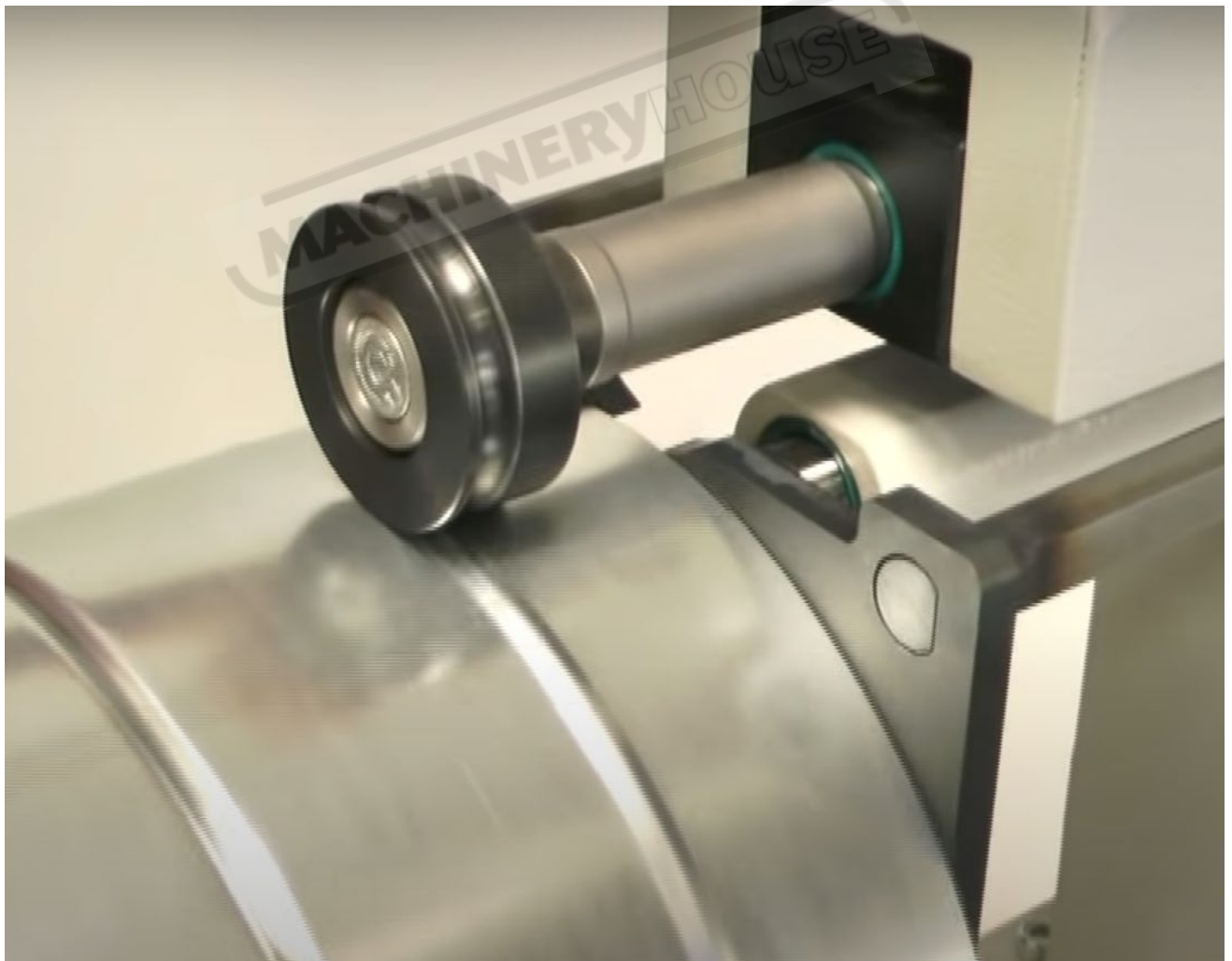
General Bending Instructions

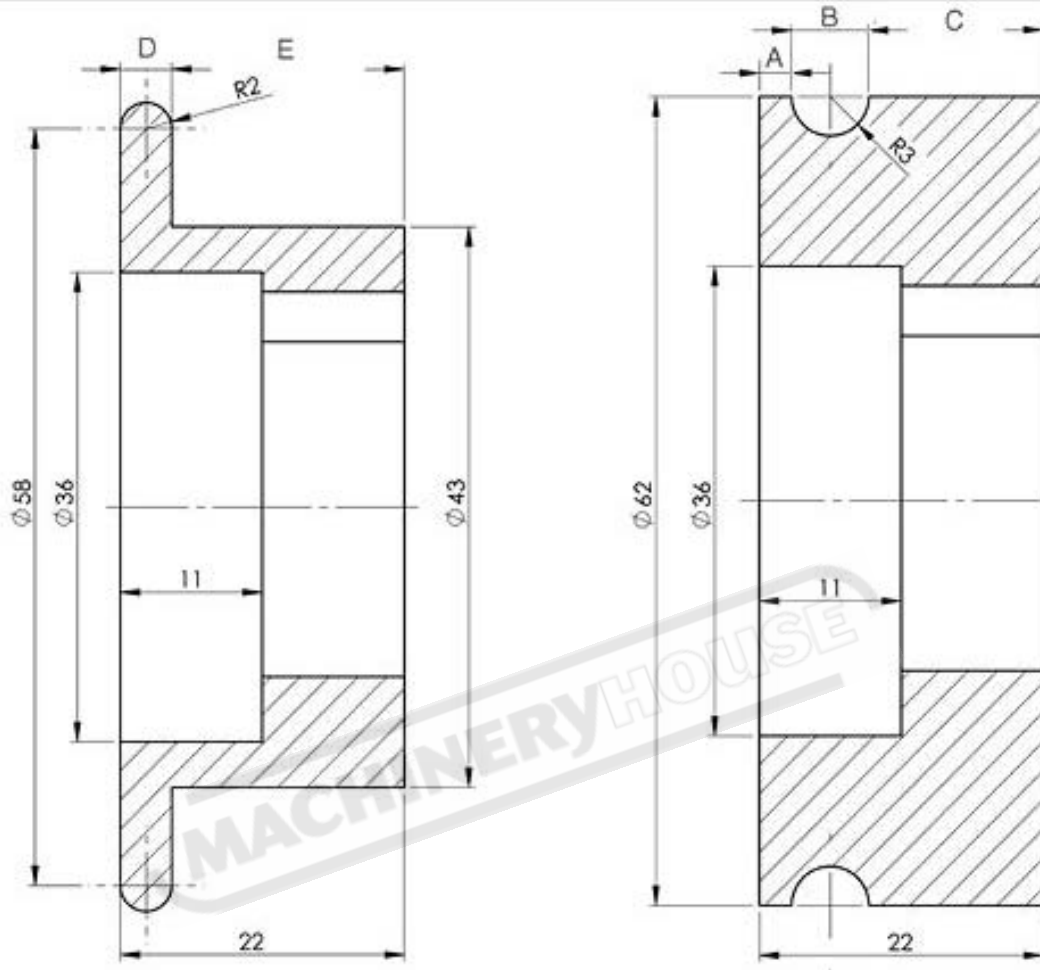
First of all the necessary type of rolls must be mounted to the machine. The top roll has right thread and bottom roll has left thread. These nuts must be tightened securely when setting up the rolls.

By using the lever on left side for bottom roll shaft, length can be adjusted to work parallel with the top roll. When you are satisfied with the parallelism you can tighten the bolt of bottom roll on right hand side of the machine and fix the positions of bottom roll.

By using small levers on the two sides of the machine, you can adjust the index cover's position according to the material position.

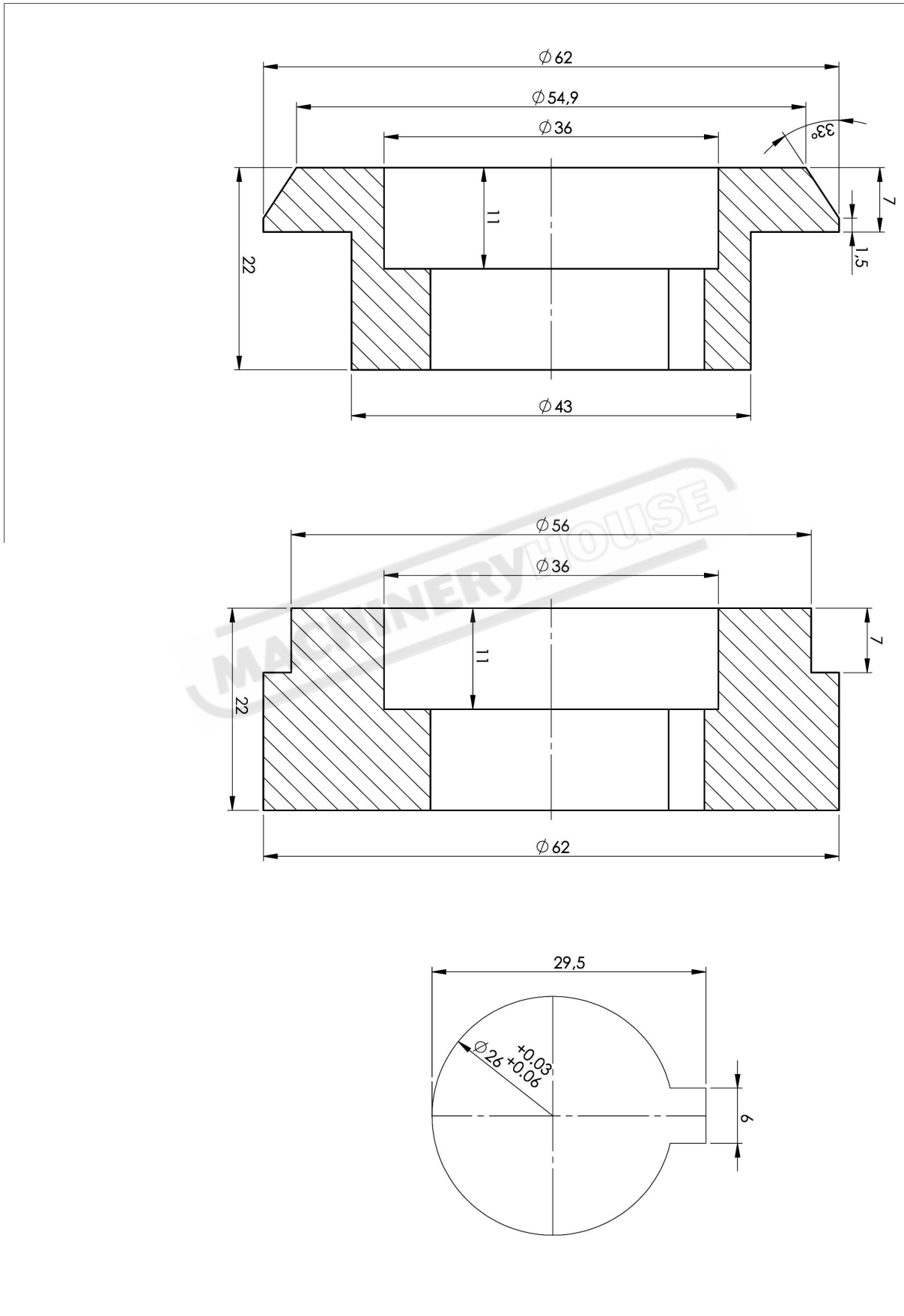
You can now insert the material lead between the rolls and pinch the material by moving the top roll to position with the lever. Also the index cover should be used to achieve accuracy. This cover can be used as a gauge for the material lead and throughout the entire operation material should be touching to the cover. Now you can bend the material by using hand lever and moving the material front and back

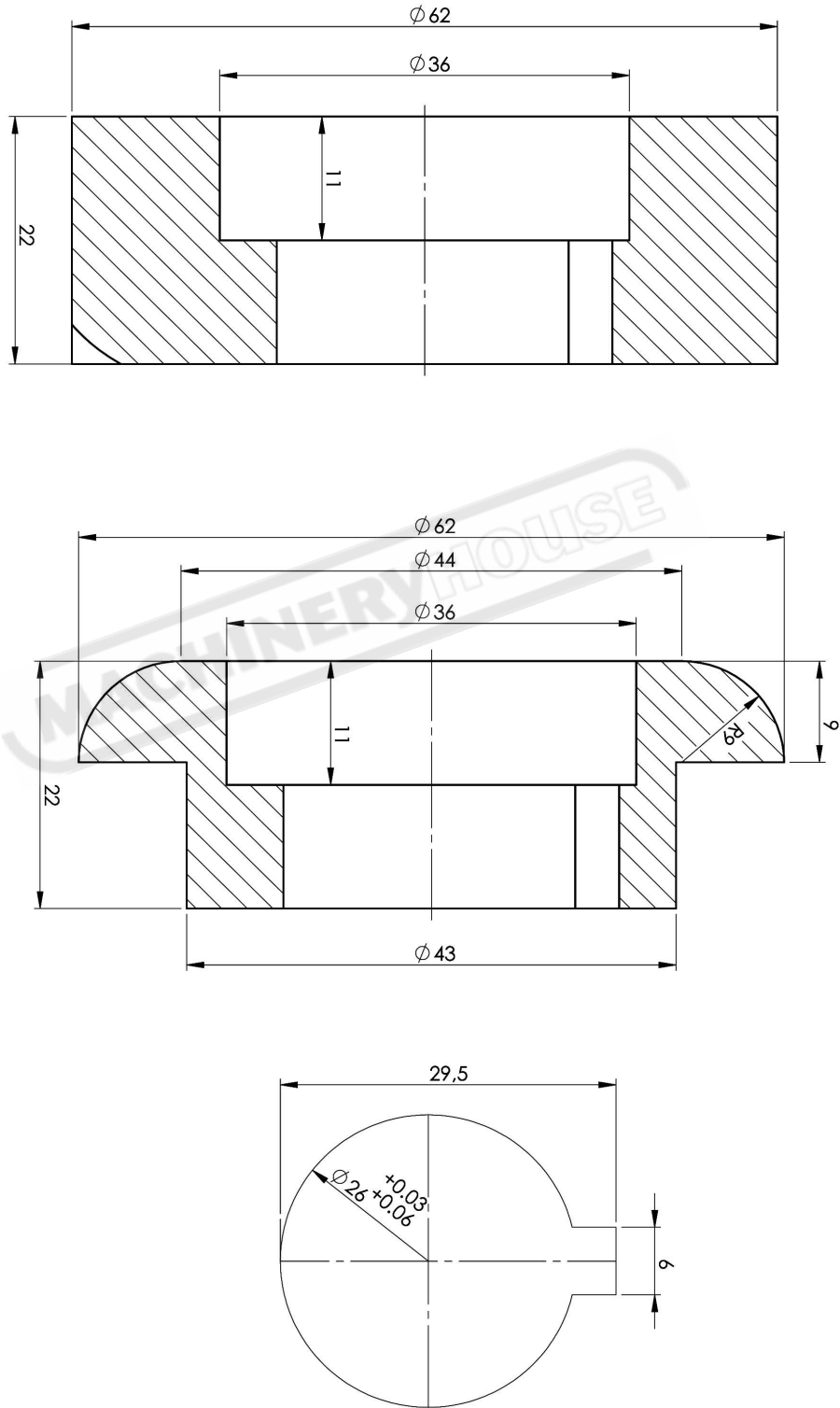


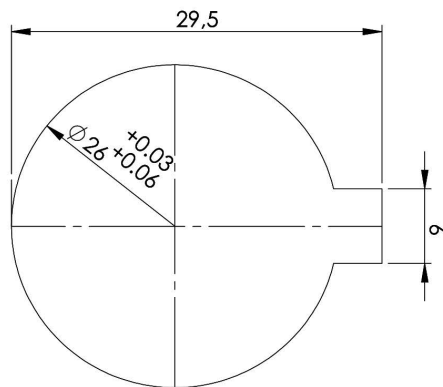
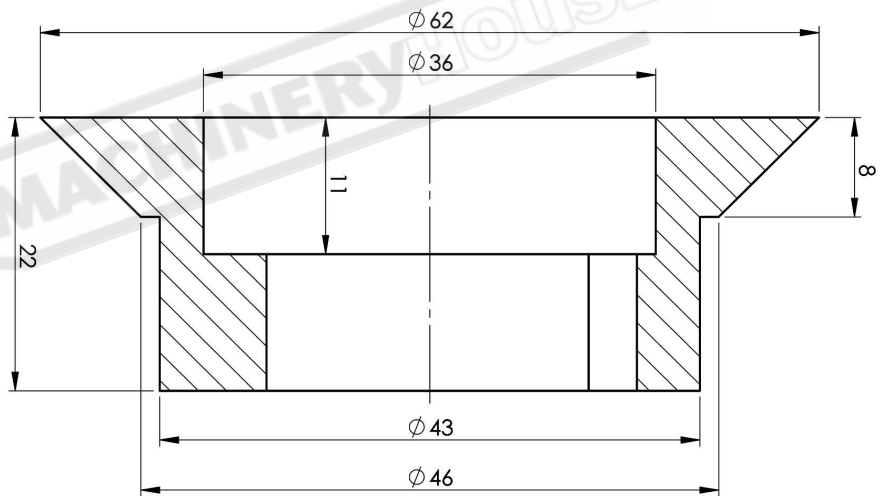
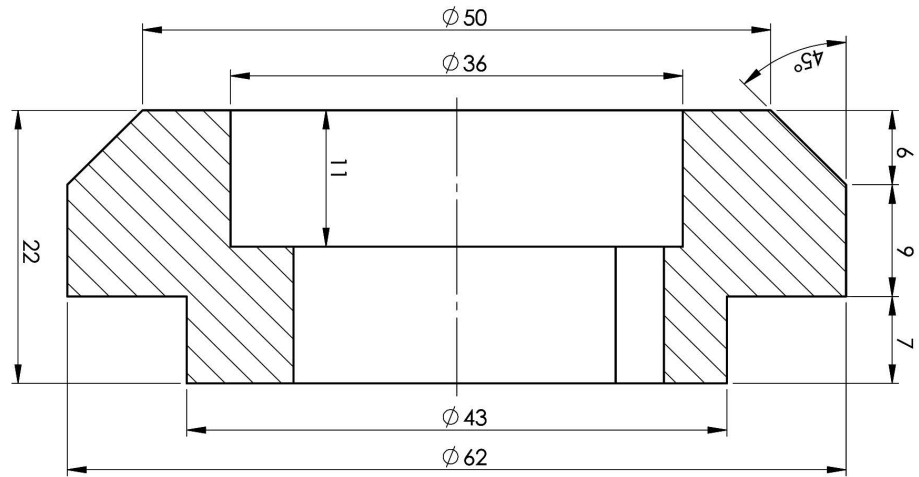
Standard Roll Set Drawings - Rolls S1 - S5


Description		S1	S2	S3	S4	S5
A	mm	3	3.5	4	4	4
B	mm	6.4	8.4	9.4	11.4	12.4
C	mm	12.6	10.1	8.6	6.6	5.6
D	mm	4	6	7	9	10
E	mm	18	16	15	13	12

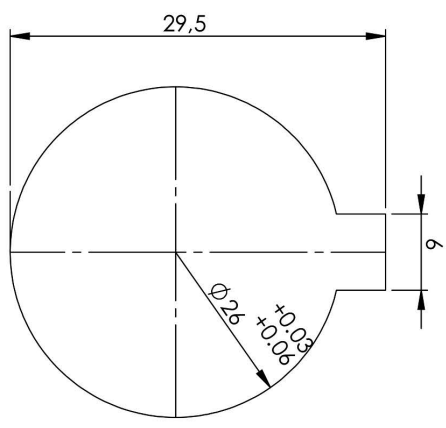
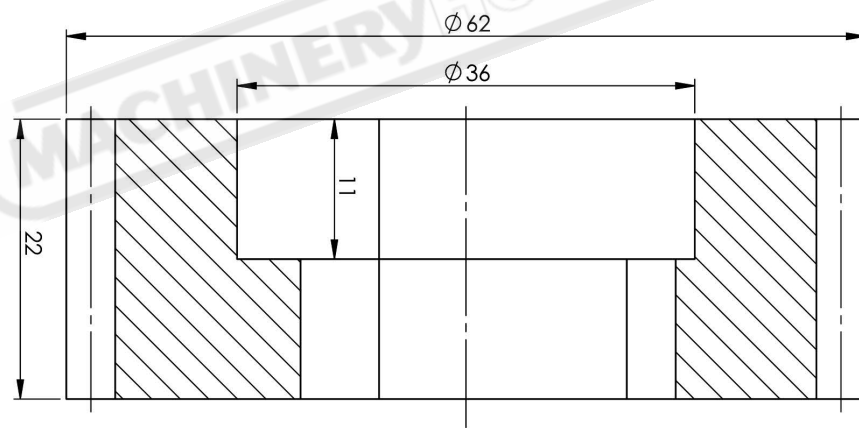
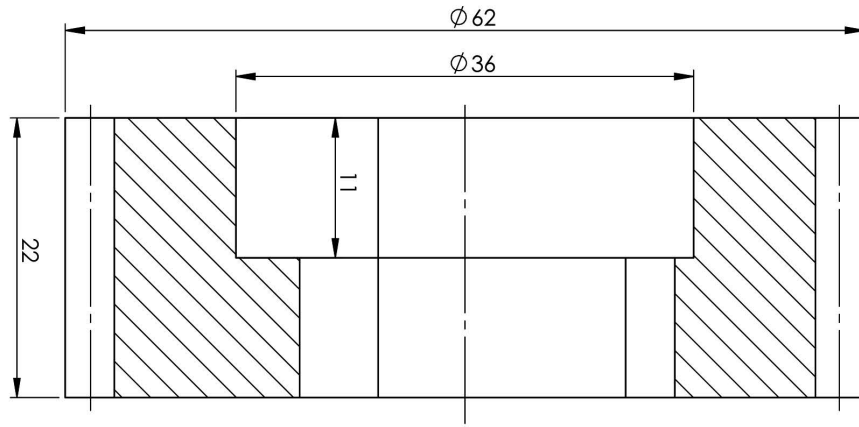
Standard Roll Set Drawings - Rolls S



Standard Roll Set Drawings - Rolls S7

Standard Roll Set Drawings - Rolls S8


Extra Roll Set Drawings - Rolls E8



MAINTENANCE

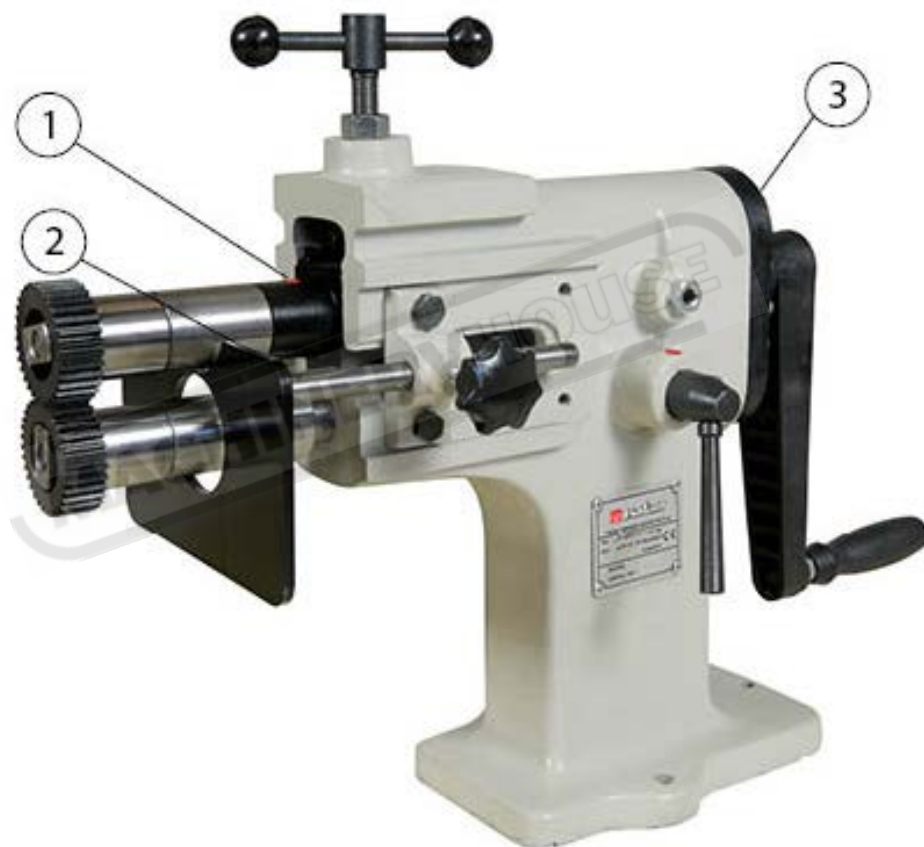
A suitable maintenance is also compulsory to get a maximum machine life and optimal working conditions for machine's efficiency.

LUBRICATION SCHEDULE

General Maintenance

The machine needs to be lubricated periodically for efficient working and lo life. You can see the points of lubrication list below and a lubrication chart for periodic maintenance.

Lubricate chart



Number	Period	Action
1. Grease channel on upper shaft	Once a week	Grease
2. Grease channel on Lower shaft	Once a week	Grease
3. Gearbox	Once a month	Grease

The rolls of the machine must NEVER be greased or lubricated, Because, then the rolls will slip the material and will not bend. Always keep the rolls clean and free from grease or any lubricant. Also make sure that the material is free from grease and dirt.

Above shown points that must be greased periodically as explained above or more if daily usage ex-ceeds 8 hours a day. Note that some of these points are actually inside the machine cover and the back cover must be removed in order to reach them. Any standard commercial grease can be used for lubrication.

MONTAGE PARTS OF IK 1.2

