



Sahinler
METAL MAKINE EN

S644

26/11/04

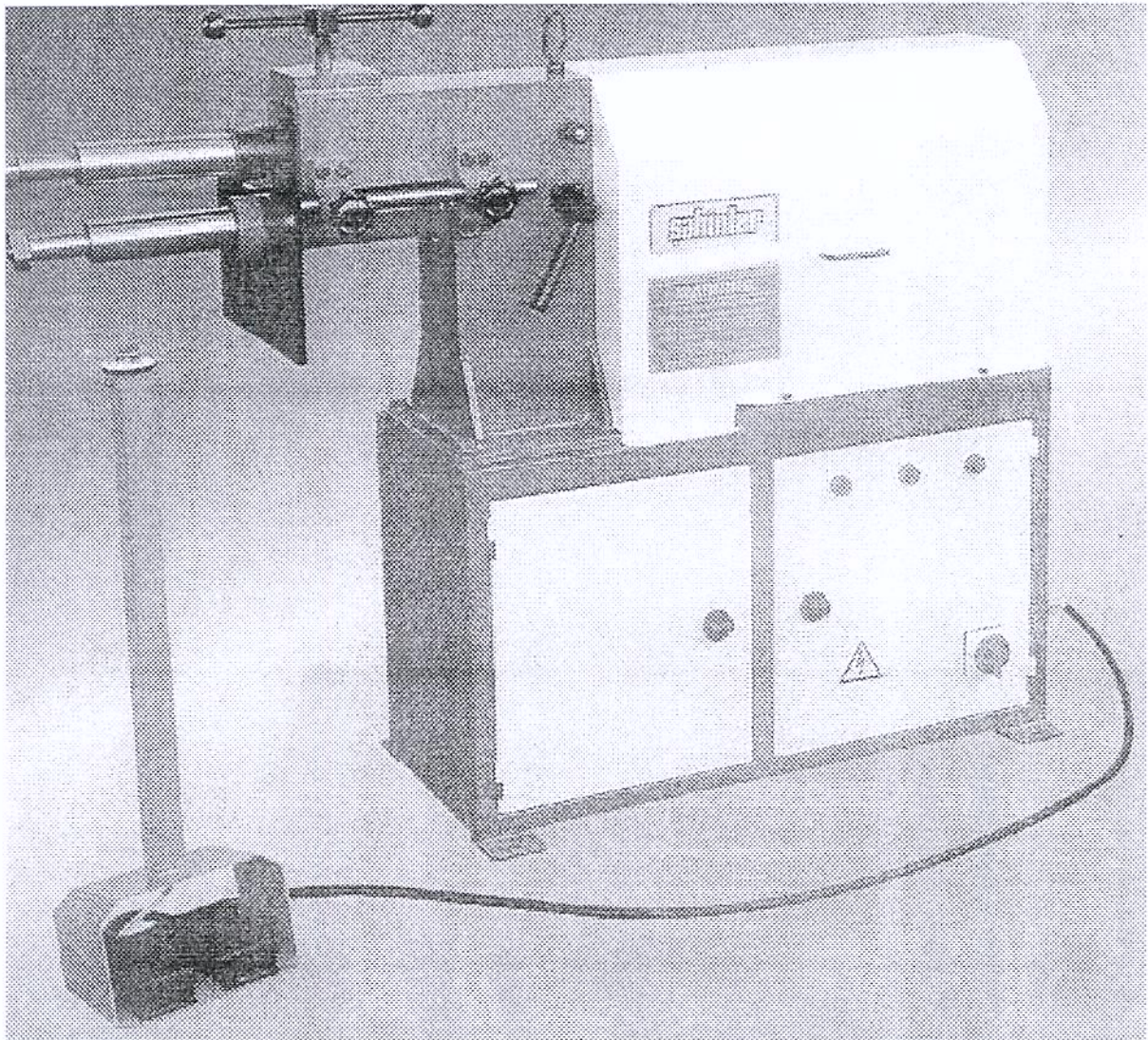
IBKS2.5 SWAGING MACHINE

IBKS-4,0

IBKS-2,5

MOTORISED SWAGING MACHINE

USER'S MANUAL





ŞAHİNLER

METAL MAKİNA ENDÜSTRİ A.Ş.

CE-Declaration

We as

ŞAHİNLER METAL MAKİNE END.A.Ş.
İzmir Yolu 22.km
Mümin Gençoğlu Cad.
Bursa Türkiye

confirm that the machine

IBKS-25
Motorised Swaging Machine

Serial Nr:

Production Year:

160252
2004

complies with

EC Machines Directive 89/392/EWG/CEE
replaced with EC-Directives 91/368/EWG and 93/44/EWG
and 93/68/CEE
EC-Low Voltage 73/23/EWG
EC-Noise Level Directives 86/188/EWG
EC-Directives EMV 89/336/EWG

and the machine also harmonised with the standards

DIN EN 60204 Part 1

ŞAHİNLER

Metal Makina Endüstri A.Ş.
İrk: Havaalanı Yolu No. 45 - 16180 BURSA
Fab.: İzmir Yolu 22. Km. Mümin Gençoğlu Cd
Tel.: 470 01 58-68 Fax: 470 07 70-BURSA
Çekirge V.D. - 798 000 4677

Name : Orhan Şahin
Position : Director
Place and Date : Bursa, on *15 EYLÜL 2004*

Signature



ŞAHİNLER

METAL MAKİNA ENDÜSTRİ A.Ş.

İzmir Yolu 22.km.
Mümin Gençođlu Cad.
Bursa/TÜRKİYE
Tel:+90-224-4700158(5 Lines) Fax:+90-224-4700770

LIMITED WARRANTY FOR ALL ŞAHİNLER PRODUCTS

We as Şahinler manufacture and control our machines with utmost care and in total good intention and try to avoid any exposed areas on the machine that can injure the user. Our CE-Mark is a product of this intention and all guards and protective measures have been placed on the machine with this intention.

We Şahinler Metal Makine End.A.Ş. as the manufacturer of the described machine herewith guarantee our machines for a period of 12 months from the date of purchase against manufacture defects and manufacture defect based failures. However this warranty is limited to the following cases and in no event shall Şahinler or its suppliers be liable for any special, incidental, indirect, or consequential damages whatsoever(including without limitation ,damages for personal injury , loss of business, loss of business profits, business interruption and any other related/non-related loss) arising out of the use or inability to use the machine. Furthermore Şahinler is only responsible for the parts manufactured by Şahinler and any other brand of components on the machine is subject to warranty conditions of their own manufacturer.

Limits of Warranty:

- Machine failures in normal operation
- Defect components
- Manufacture defect based problems

In any case Şahinler 's responsibility does not exceed supply and/or replacement of spare parts. If a Şahinler technician is needed for the replacement and/or repair , depending on the situation this can be charged to the customer in terms of travel and accommodation cost and labor cost on a per hour basis.

Cases where warranty is not applied

- All wearing parts during the normal operation of the machine are excluded from the warranty.
- Failure to report any damage to the Şahinler distributor or Şahinler directly.
- Any transport damages.
- Any misuse, abuse and use in contradiction to the User's Manual.
- Any electric connection based faults.
- Any user mistakes.
- Any modification and/or repair carried out by any other person/company without written consent of Şahinler A.Ş.
- Any damage caused by inevitable events as burglary, natural catastrophes, fire, terror and war activity etc.

The application of warranty is not limited to the clauses above and Şahinler reserves the right to make any changes to the applicable items above.

Şahinler A.Ş. advises the end-users to make Product Liability Insurance.For further information on this matter please contact local insurance companies.

For any legal purposes regarding this warranty Bursa(TÜRKİYE) courts and laws will be applied.

ŞAHİNLER METAL MAKİNE ENDÜSTRİ ANONİM ŞİRKETİ
Bursa
Türkiye



Şahinler

METAL MAKİNA ENDÜSTRİ A.Ş.

İzmir Yolu 22.km.
Mümin Gençođlu Cad.
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Tel:+90-224-4700158(5 Lines) Fax:+90-224-4700770

1.GENERAL NOTES

1.1 INTRODUCTION

Thank you for choosing a Şahinler 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'll be able to run your machine smoothly and safely.Keep in mind that the machine is firstly designed for maximum safety and secondly for efficient working.

Before connecting the machine double-check electrical connections read the instructions carefully.Almost a 65 % of the failure reports we receive is based on either wrong electric connection or use in contradiction to the User's Manual.

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

In case of any failure please first refer trouble-shooting guide then if a solution can not 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.

Our Technical Staff will make their best to help you in the most convenient way.

1.2 TRANSPORT

As soon as you receive the machine check for any visible transport damages.If there are any visible damages immediately report it to the transporter company and of course Şahinler or your supplier.

Remove any protective crates around the machine and read the instructions on section 2 carefully to set up the machine.If the machine is damaged while transport ,immediately take some photographs for insurance and future reference purposes.Failure to do so may result in the termination of your guarantee and insurance claims.

Take precautions while loading/unloading or moving the machine to avoid any injuries.Refer to Section 2 for the best way to handle the machine.

1.3 ELECTRICAL INFORMATION

All necessary connection procedure can be found on Section 2 and the necessary drawings are on Section 8.Do not try to connect the machine before reading these procedures and fully understanding the drawings.For any unclear points immediately contact Şahinler Distributor or Şahinler.Have the machine connected by a qualified electric technician.Just to remind you ,any electrical connection mistake is not covered by your guarantee.Always turn off power before making any connections or disconnecting the machine.

1.4 MAINTENANCE

Your machine is designed and produced to work effciently 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 unauthorised modifications.

1.5 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 safety instructions on Section 6.

TECHNICAL DATA

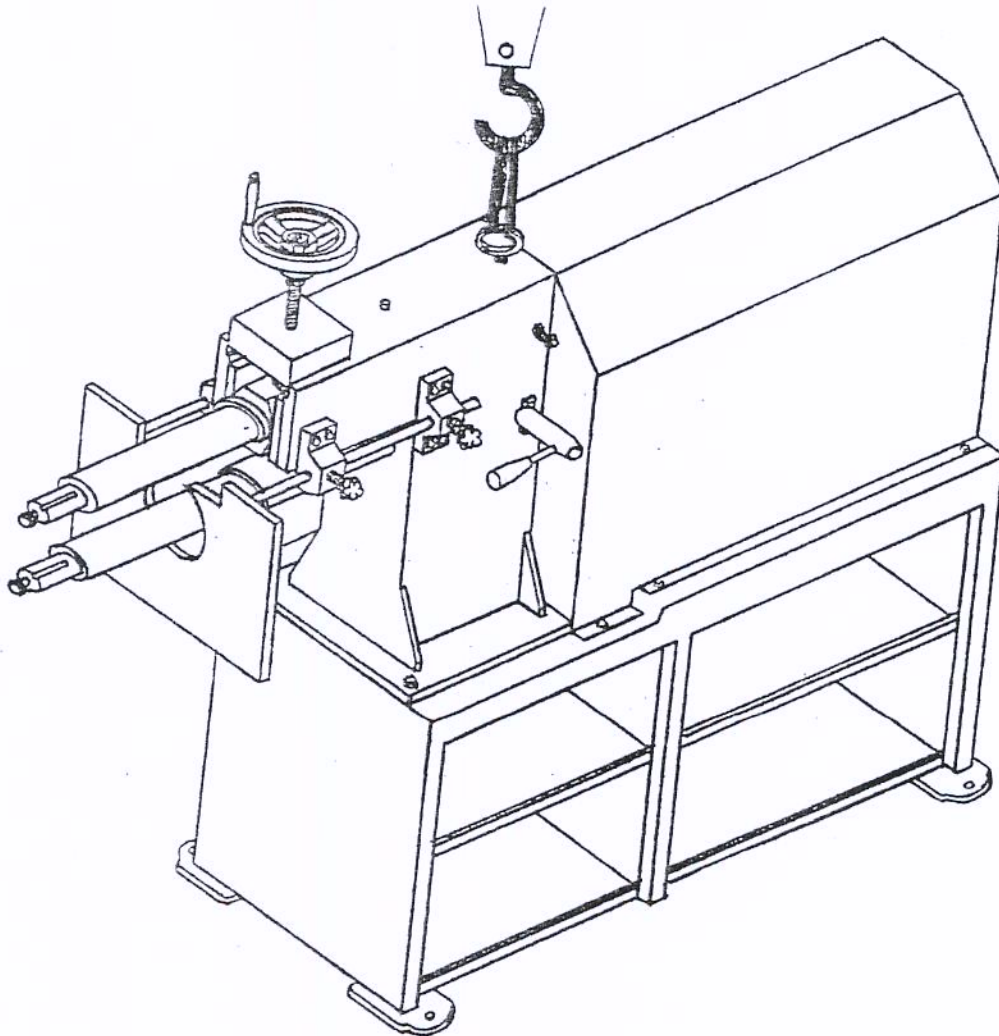
Bilgi / Data / Datai	IBKS-2,5	IBKS-4,0
Kapasite/Capacity/Blechstärke	Mm 2,5	Mm 4,0
Ana Mil / Shaft / Welle Ø	Mm 90	Mm 130
Motor	Kw 1.5	Kw 2.2
Uzunluk / Length / Länge	Mm 1450	Mm 1550
Genişlik / Width / Breite	Mm 400	Mm 500
Yükseklik / Height / Höhe	Mm 1150	Mm 1250
Ağırlık / Weight / Gewicht	kg 380	kg 500

This User's Manual is intended for both IBKS-2,5 and IBKS-4,0 Machines. Although the models are identical there are slight differences in size and weight etc.

Please find the correct measurements for your models while checking this manual.

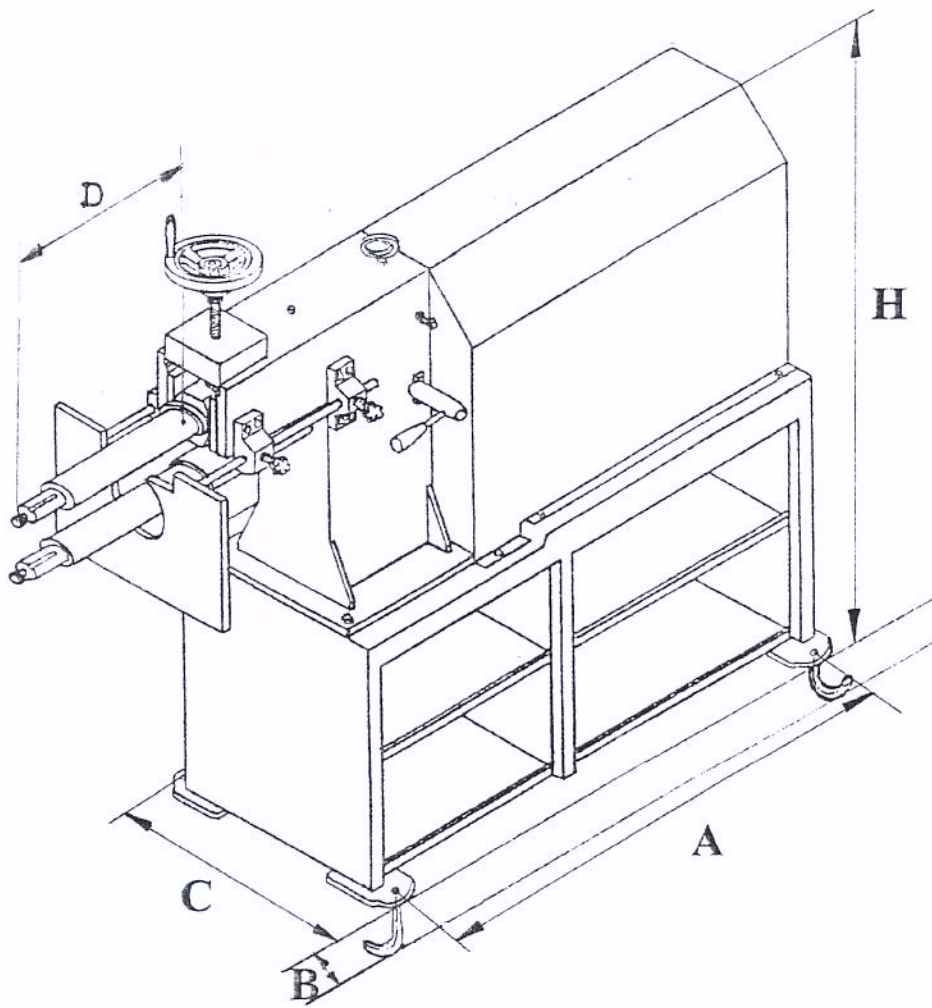
SETTING UP AND TRANSPORT

IBKS-2,5W= 380 kgs
IBKS-4,0W= 500 kgs



The machine must be carried carefully with the help of a crane as shown above. Do NOT lift from anywhere else other than the lifting ring.

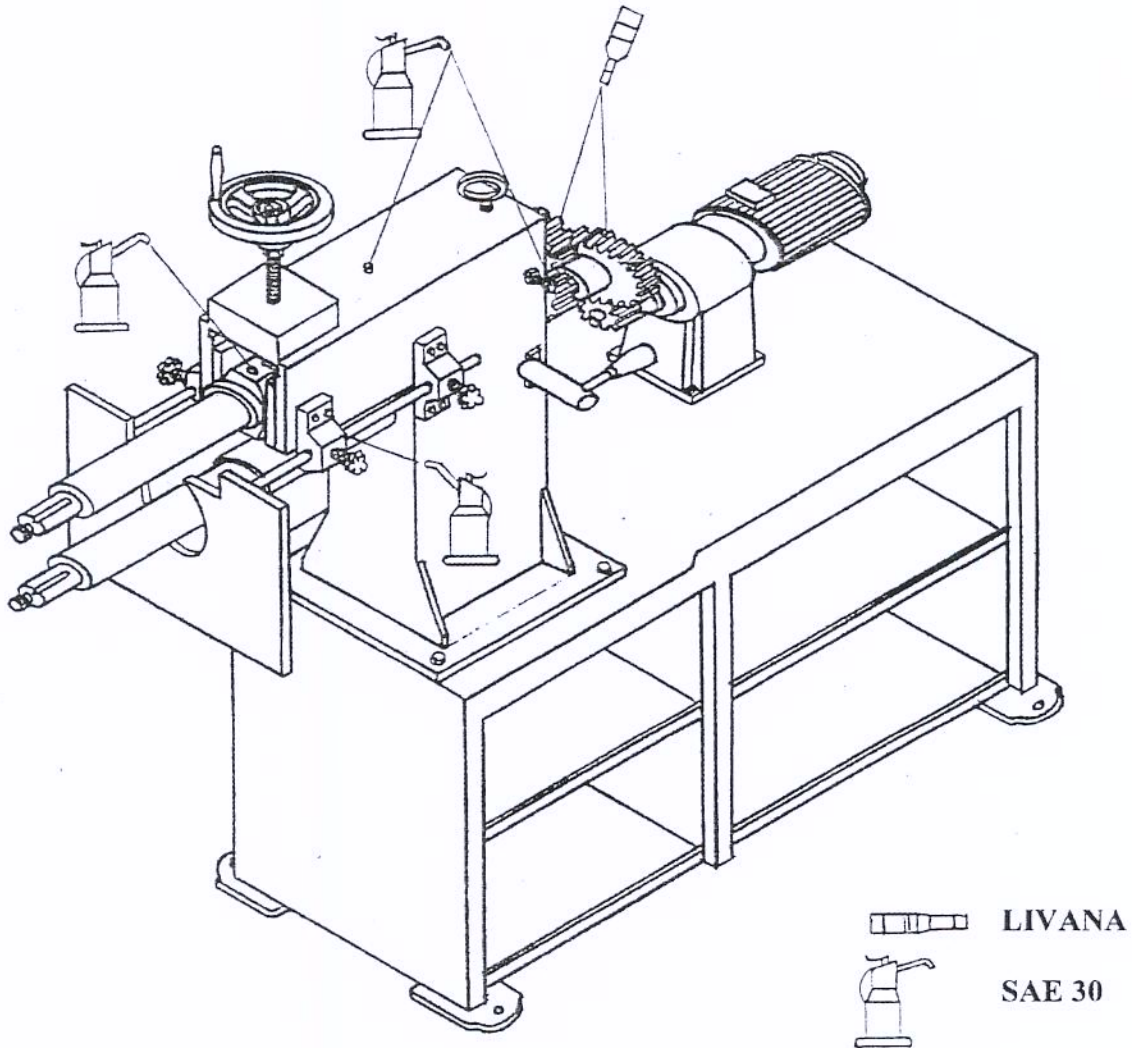
FOUNDATION PLAN



Here are some general foundation dimensions of the IBKS machine. Please also be careful to leave enough working space around the machine.

Letter	IBKS-2,5	IBKS-4,0
A	780 mm	900 mm
B	400 mm	500 mm
C	50 mm	50 mm
H	1150 mm	1250 mm
D	400mm	500mm

LUBRICATION PLAN AND LUBRICATION



The machine needs to be thoroughly lubricated. Lubrication once a week to moving parts in full working conditions will be satisfactory.

If the machine has not been used for a long period of time an inspection and lubrication of moving parts can be needed.

GENERAL BENDING INSTRUCTIONS

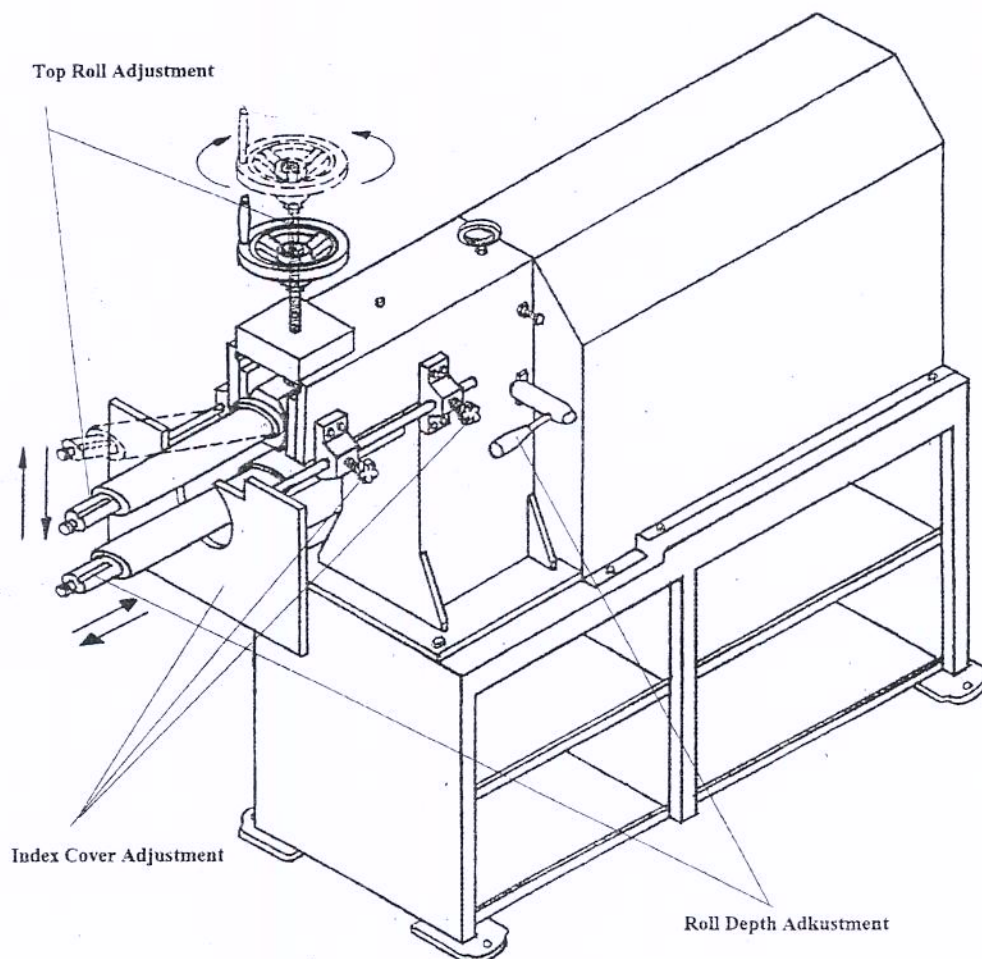
The Motorised Swage Machines are easy to operate machines and very safe to use. However caution must be taken to avoid long hair ,long working clothes etc. not to get stuck within moving rolls.

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 bottom roll shaft length is 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 position of bottom roll.

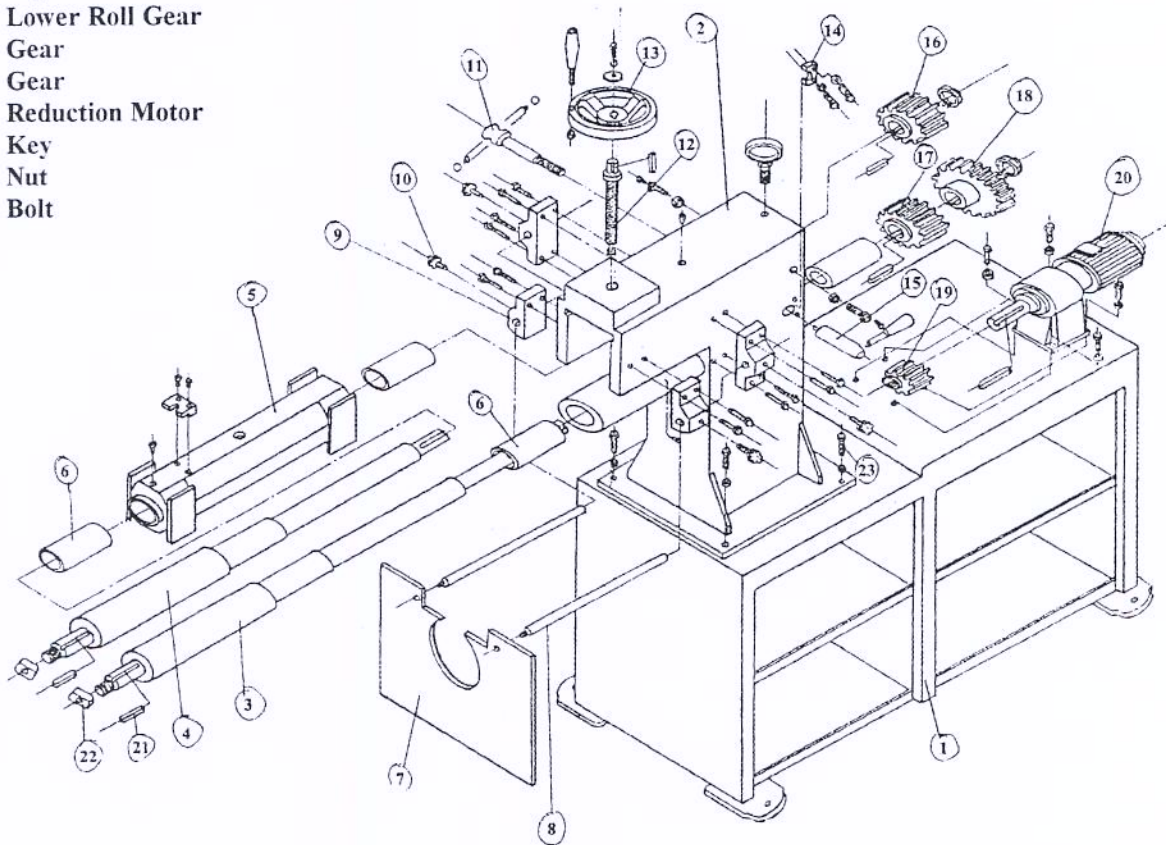
By using small levers on the top of the machine you can adjust the index cover position according to the material position.

You can now insert the material lead between the rolls and stuck the material between the rolls by moving the top roll to position with the hand wheel. 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 the material should be touching the index. Now you can bend the material by using the foot pedal and moving the material front and back.

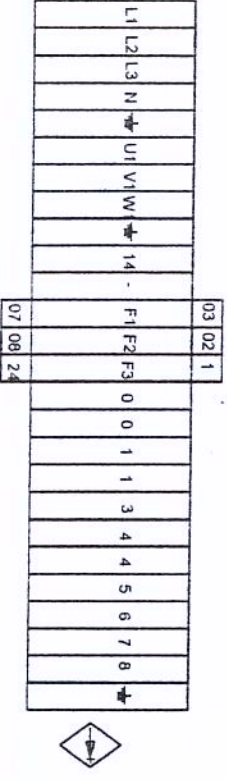
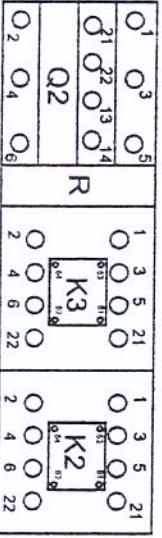


MAIN PARTS

- 1- Main Frame
- 2- Cast Body
- 3- Lower Shaft
- 4- Upper Shaft
- 5- Upper Shaft Bushing
- 6- Bronze Bushing
- 7- Index Cover
- 8- Index Cover Shaft
- 9- Bushing
- 10- Bolt
- 11- Bolt
- 12- Top Roll Adjustment Shaft
- 13- Hand wheel
- 14- Lower Roll Movement Wedge
- 15- Lower Shaft Movement Lever
- 16- Top Roll Gear
- 17- Lower Roll Gear
- 18- Gear
- 19- Gear
- 20- Reduction Motor
- 21- Key
- 22- Nut
- 23- Bolt



0	220	400	440	0	24
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Sayfa No

01

İKMP-İBKS

**PANO DIZAYNI VE
PANO KAPAĞI**

Tarih

19/06/2001

Plan No

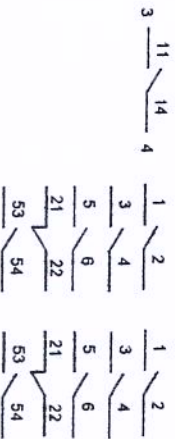
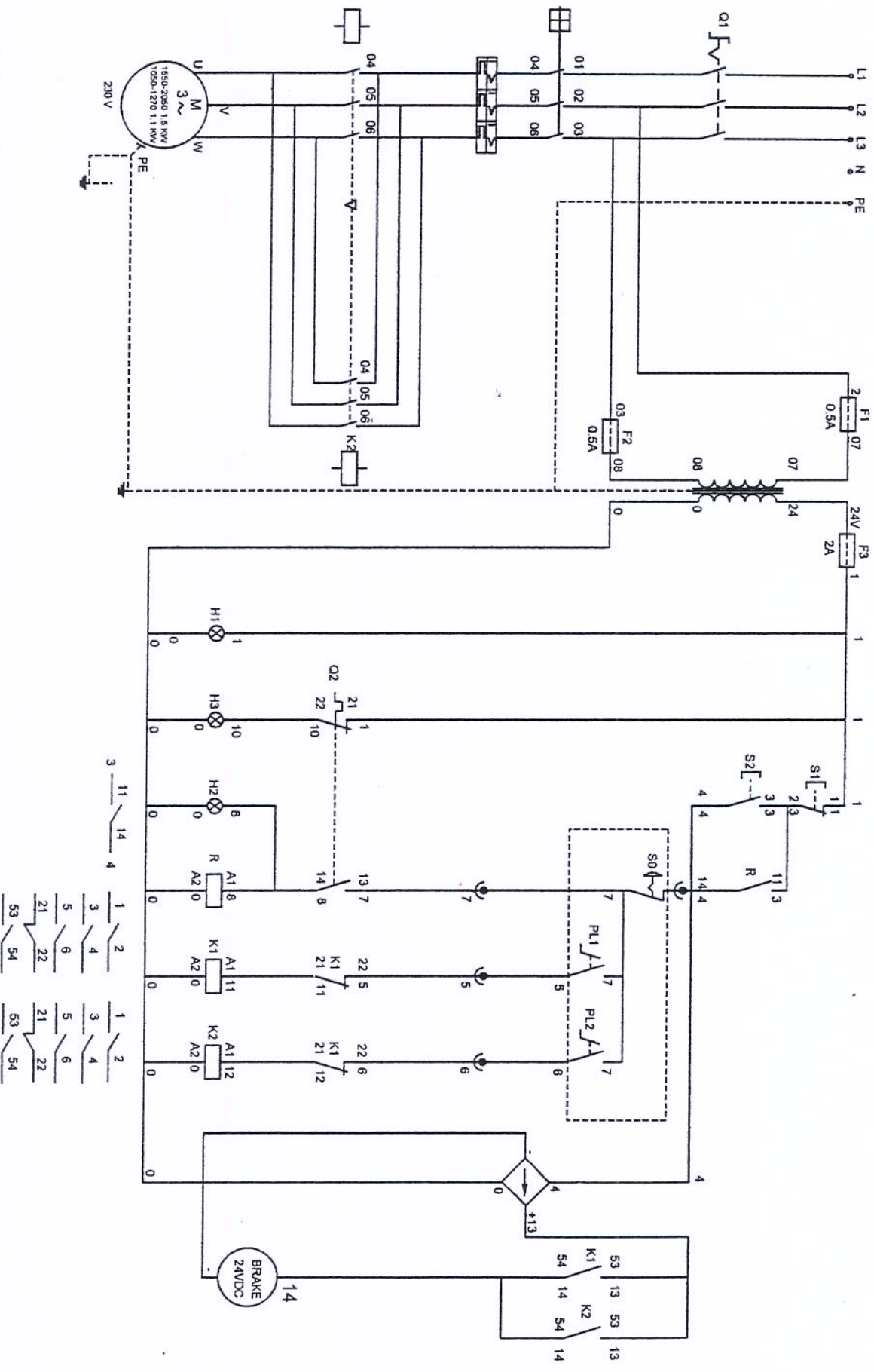
Dosya Adı

İKMP-İBKS

ŞAHİNLER

METAL MAKİNA
ENDÜSTRİ A.Ş.

01/220/4001/440/0/24 V 100 VA
 01/575/0/24 V 100 VA



Sayfa No	01	IKMP-IBKS	MOTOR GROUP	Tarih	08/06/2001	Plan No	Dosya Adı	IKMP-IBKS	ISITAN MAKINA SANAYI TIC.LTD.STI
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