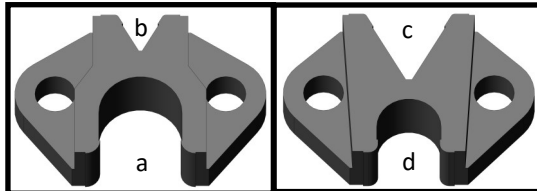



Due to our policy of continual development and improvement the company reserves the right to modify Metalcraft tools without prior notification.

1/8" = 3mm 9/16" = 15mm
 3/16" = 5mm 3/4" = 20mm
 1/4" = 6mm



Max flat bar 	3/4" x 1/8" 9/16" x 1/8" (reverse bend only)	3/4" x 1/8" 9/16" x 1/8" (reverse bend only)
"U" formed die Round/Square bar *	a ● 1/4" ■ 1/4"	d ● 3/16" ■ 3/16"
"V" Formed Die Round/Square bar **	b ● 3/16" ■ 3/16"	c ● 1/4" ■ 1/4" WHEN USED WITH MC1781

* NOTE: Depending on the thickness of the bar a full 180° may be achieved with a secondary manual operation.

** NOTE: For a 60° bend use MC302– Large angle forming head, see exploded view on page 1.

Important Notes:

- 1) Sizes listed are for Hot Rolled Mild Steel and Annealed bright mild steel
- 2) Ensure all moving parts are regularly lubricated and all bolts kept tightened
- 3) Working beyond the capacities stated above or materials with greater strength or hardness will reduce the operational life of the machine
- 4) Please save these instructions in a safe place for any future reference to the parts diagrams

Reverse Bend is where the 2nd bend is bringing the steel away from the original bend (zig zag effect)
 Reason lighter gauge material can be done on a reverse bend is because when reverse bending the steel needs to sit on the recessed part of the die (if the reverse bend is tight) which is only half the width so the bent steel does not have the full support of the die.



www.pinterest.com/metalcraftusa



www.youtube.com/scrollbender

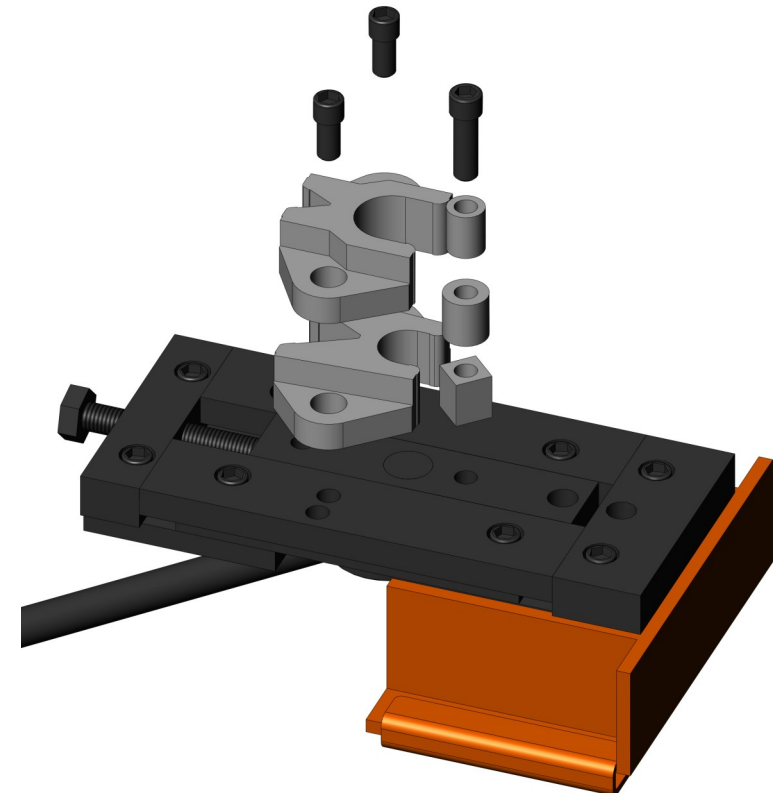


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OPERATING INSTRUCTIONS



MICRO BENDING KIT for Master RBR



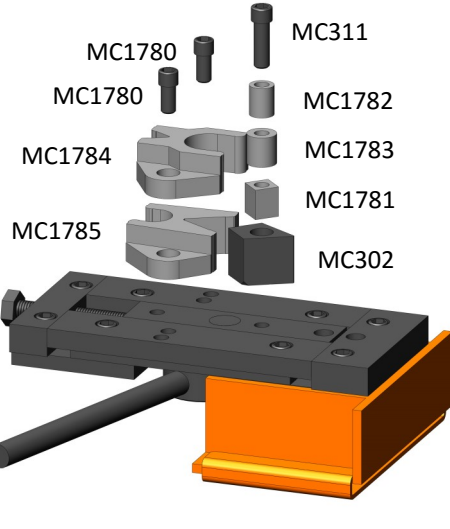
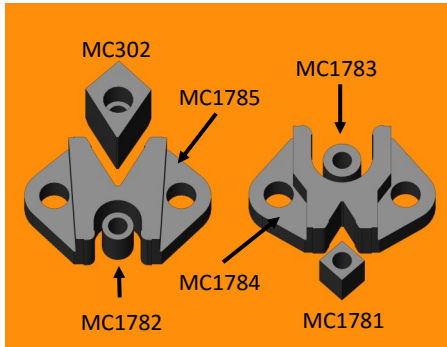
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MASTER RBR MICRO BENDING

1 SET UP (Micro Dies /Formers are shown light grey for illustrative purposes only)

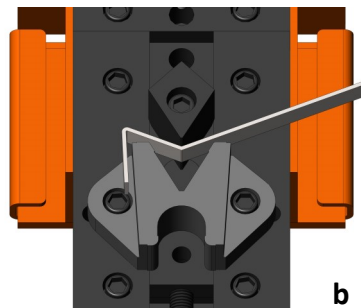
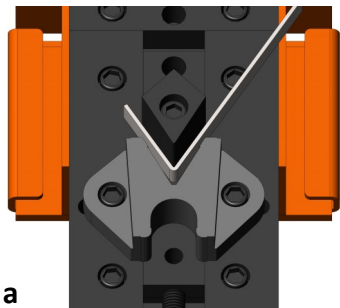
(a) First take the rollers (MC335) off the M.R.B.R body by undoing both shoulder bolts (MC306). Replace these with supplied bolts (MC780) in the inner holes **making sure they are tight**. The angle forming bolt (MC311) can be used for all the forming heads.

(b) The two dies can now be easily moved on or off or rotated in seconds. The correct forming head can now be matched with the correct die.



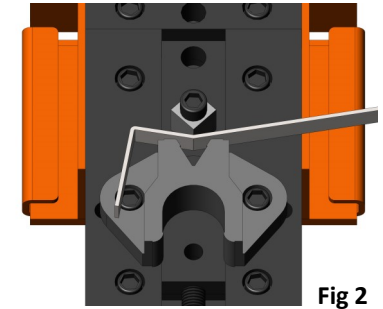
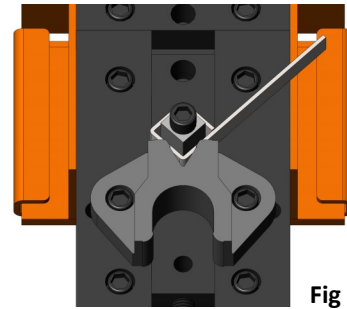
2 LARGE ANGLED DIE MC1785

Two forming heads can be used for this die, for any angle over 90° and up to 60° use the existing angle former MC302. Simply move the handle lever to open the gap between the forming head and die and then pull the handle lever in the opposite direction using the stop bolt to set any bend. For a closed bend (a) steel of 3/4" w x 1/8" can be used. For "S" (reverse bend) (b) the steel strip will sit on the recessed part of the die, the maximum steel used is 9/16" w x 1/8" thickness.



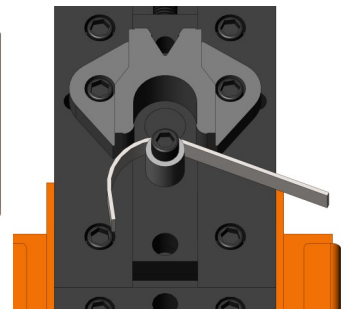
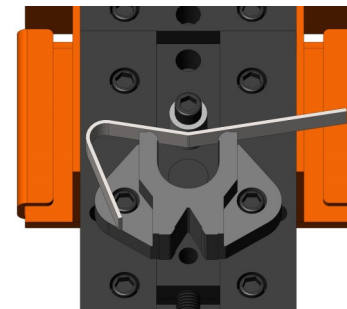
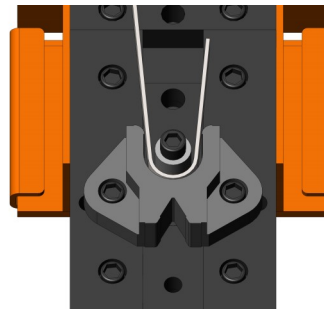
3 SMALL ANGLED DIE MC1784

A series of tight 90° bends can now be created using the new MC1781 angle former with steel strips up to 3/4" w x 1/8". See Fig 1. Tight "S" bends (using the upper half of the small angled die) of up to 90° can be achieved with steel strip up to 9/16" w x 1/8", see Fig 2.



4 LARGE RADIUS MC1784

Used with the larger radius former MC1783 is used to make larger radius bends using the same principles as the large angled die. It can create rounded "U" bends of almost 180° depending on the type of steel used. It can also be used for progressive bending. To progressive bend set the back stop so that only a small amount of bend is achieved pass the bar through the large radius head and the die moving it only a small amount to achieve a curve. By loosening the nut fully you can create a more free form design.



5 SMALL RADIUS DIE MC1785

Used in the same way as the larger radius die but can only be used with the small radius former MC1782. Depending on the type of steel used, it can create tight "U" bends (max 3/4" w x 1/8") and "S" bends (9/16" w x 1/8") but can also be used for small and more intricate progressive bending work.

