

FOLDING MACHINE
Model PBB-4014/3SH
PBB-5016/3SH



Operation manual

Specification:

Model	Working length	Sheet thickness	Max. clamping bar lift	Folding angle Deg.
PBB-4014/3SH	1020mm	2mm	45mm	150
PBB-5016/3SH	1270mm	1.5mm	45mm	150

Assembly and installation

The machine is delivered on a wooden pallet. Lift up the machine from the wooden pallet by means of straps and crane. The support legs of the machine (back of the machine) are enclosed. These must be mounted on the machine in order to keep the machine stand on the floor. To make use of the good quality and the precision of the machine, it must be mounted on an even and stable floor, where it can be bolted to the floor through the boltholes in the legs. After unpacking, all rust protected parts must be cleaned with paraffin and lubricated with acid-free oil.

Operation

Before use, folding stop no. 7 must be loosened. The clamping pressure is from the factory adjusted to zero in sheet thickness. The required clamping pressure can be adjusted by using the adjusting screws no. 6 until the foot pedal no. 1 can be locked at the locking pedal. The folding beam no. 4 can be adjusted to the required sheet thickness by using the handles no. 8. Lower the folding beam to minimum sheet thickness. Check the distance between sharp nose blade / segments by placing the folding beam in 90°. If bend above 90° is required the folding beam must be lowered 25% additionally. Crowning of the folding beam is carried out by means of the two bolts at the adjusting bolt no. 5.

Angle adjustment

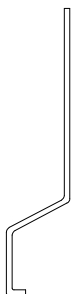
Folding stop no. 7 can be adjusted for the required angle. Make a folding test and adjust the folding stop.

Maintenance

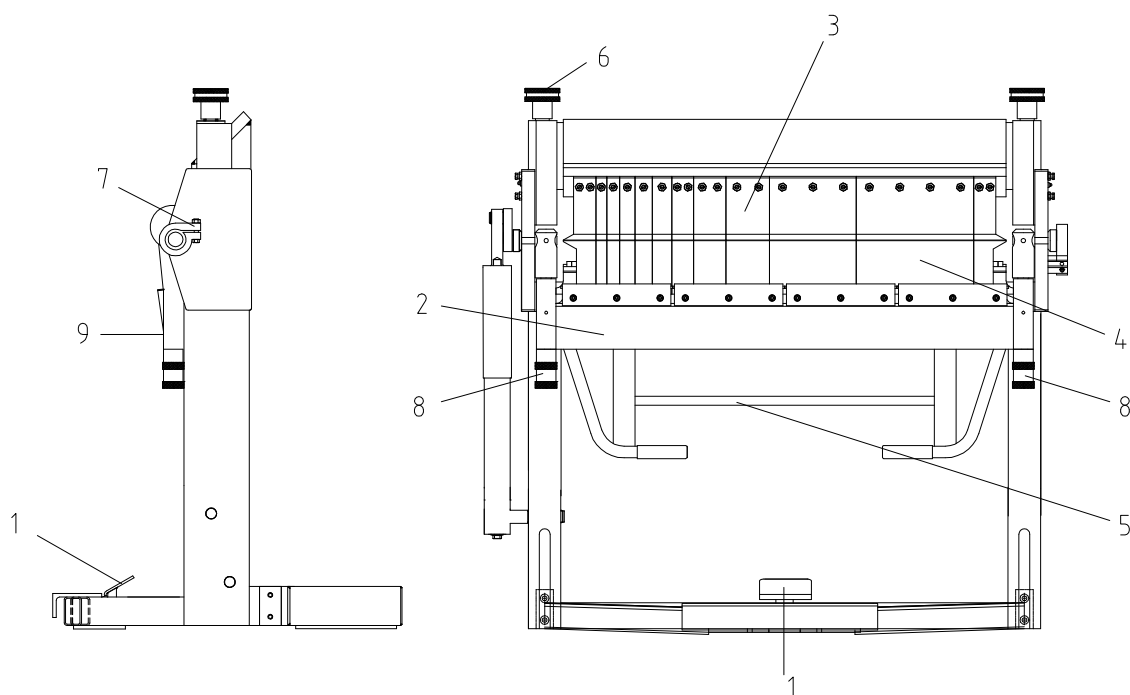
Daily cleaning, and every one hundred working hours all blades and guide ways must be cleaned and suitably lubricated.

Accessories

Tool for dismiss blades Quantity: 1 pieces

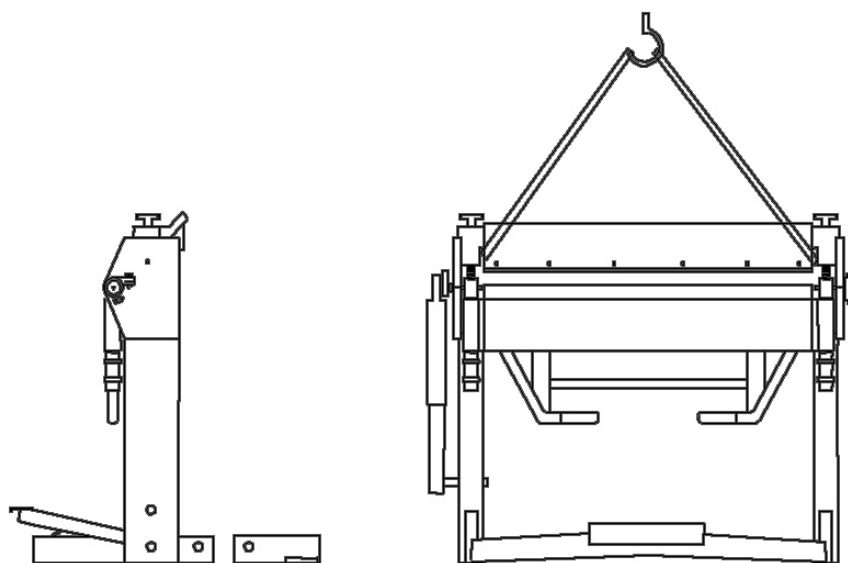


1. Foot pedal with locking device
2. Folding beam
3. Segments for clamping beam
4. Segments for folding beam
5. Crowning adjustment on the folding beam
6. Adjusting nut for clamping beam pressure
7. Bending stop
8. Handle for adjustment of the folding beam to the correct sheet thickness
9. Counter balance arm



Warning

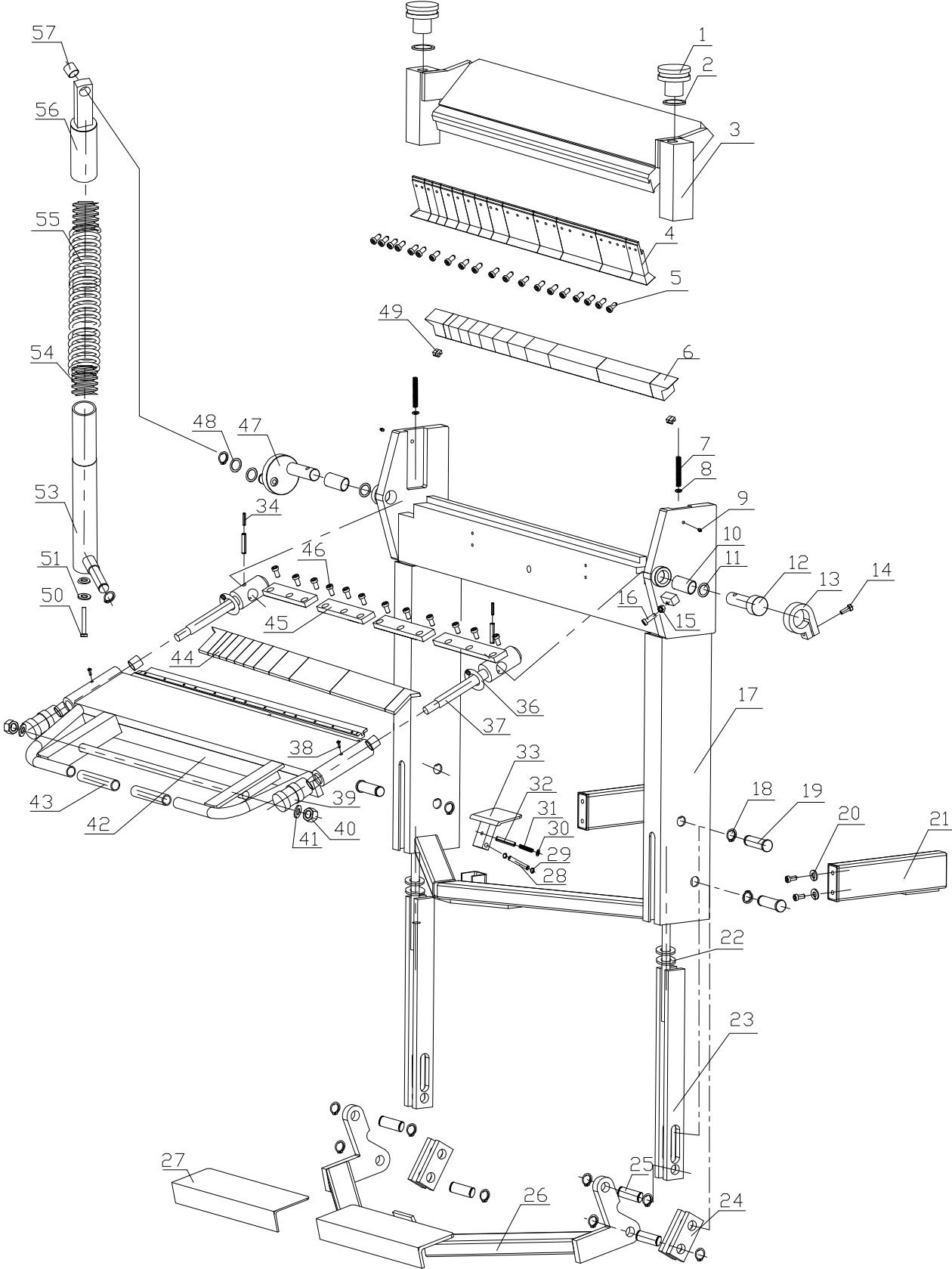
You have to hold the top of the machine while mounting the support legs.



Parts List

Part #	Description	Q'ty	Part #	Description	Q'ty
1	ADJUSTING NUT	2PCS	29	EXT RETAINING RING 10MM	1PC
2	FLAT WASHER 20mm	2PCS	30	FLAT WASHER	1PC
3	CLAMPING BEAM	1PC	31	SPRING	1PC
4	UPPER BLADE	1STCK	32	PIN	1PC
5	BOLTS M10X19	22PCS	33	FOOT PEDAL	1PC
6	SUPPORT BLADE	1STCK	34	PIN	1PC
7	COMPACT SPRING	2PCS	36	O-RING	2PCS
8	FLAT WASHER 20mm	6PCS	37	SWIVEL BODY	1PC
9	GREASE FITTING M8X1	2PCS	38	BOLT M8X16	2PCS
10	BUSHING	2PCS	39	ADJUSTING NUT	2PCS
11	FLAT WASHER	2PCS	40	NUT M20	2PCS
12	FOLDING LEAF PIN	1PC	41	FLAT WASHER	2PCS
13	LIMITED BLOCK	1PC	42	FOLDING BEAM	1PC
14	BOLT M10X35	1PC	43	HANDLE SLEEVE	2PCS
15	NUT M10	1PC	44	LOWER BLADE	1STCK
16	BOLT M10X40	1PC	45	STOP BLOCK	4PCS
17	LEG	1PC	46	BOLT M10X20	12PCS
18	EXT RETAINING RING	13PCS	47	ECCENTRIC BLOCK	1PC
19	LEG PIN	3PCS	48	WASHER	2PCS
20	WASHER	4PCS	49	NUT	4PCS
21	EXTENSION BRACKET	2PCS	50	BOLT M12X150	1PC
22	DISC SPRING	4PCS	51	LOCKING WASHER	1PC
23	ROD	2PCS	53	BOTTOM ROD	1PC
24	FOOT PEDAL LEVER	4PCS	54	SPIRAL BLOCK	2PCS
25	LEVER PIN	4PCS	55	SPRING	1PC
26	FOOT PEDAL	1PC	56	UPPER ROD	1PC
27	TREAD PLATE RUBBER	1PC	57	BUSHING	5PCS
28	ROLL PIN	2PCS			

EXPLODED FIGURE



Note: This manual is only for your reference. Owing to the continuous improvement of the machine, changes may be made at any time without obligation on notice.