# SHRINKER / STRETCHER

# Model: SG-18



OPERATION MANUAL

## ● STRUCTURE AND FUNCTION

This machine is composed of the body part and the jaws part. The body is high quality steel casting, with a high structural strength and good stability; The jaws are hardening treated chromium steel with very high hardness and toughness. The jaws including Shrinker and Stretcher, The Shrinker forms outside radius curves and the Stretcher forms inside radius curves. Compound curves can be made by working the piece on alternating sides, when both Shrinker and Stretcher, taking care to match work on both sides.

## ● GENERAL SPECIFICATION

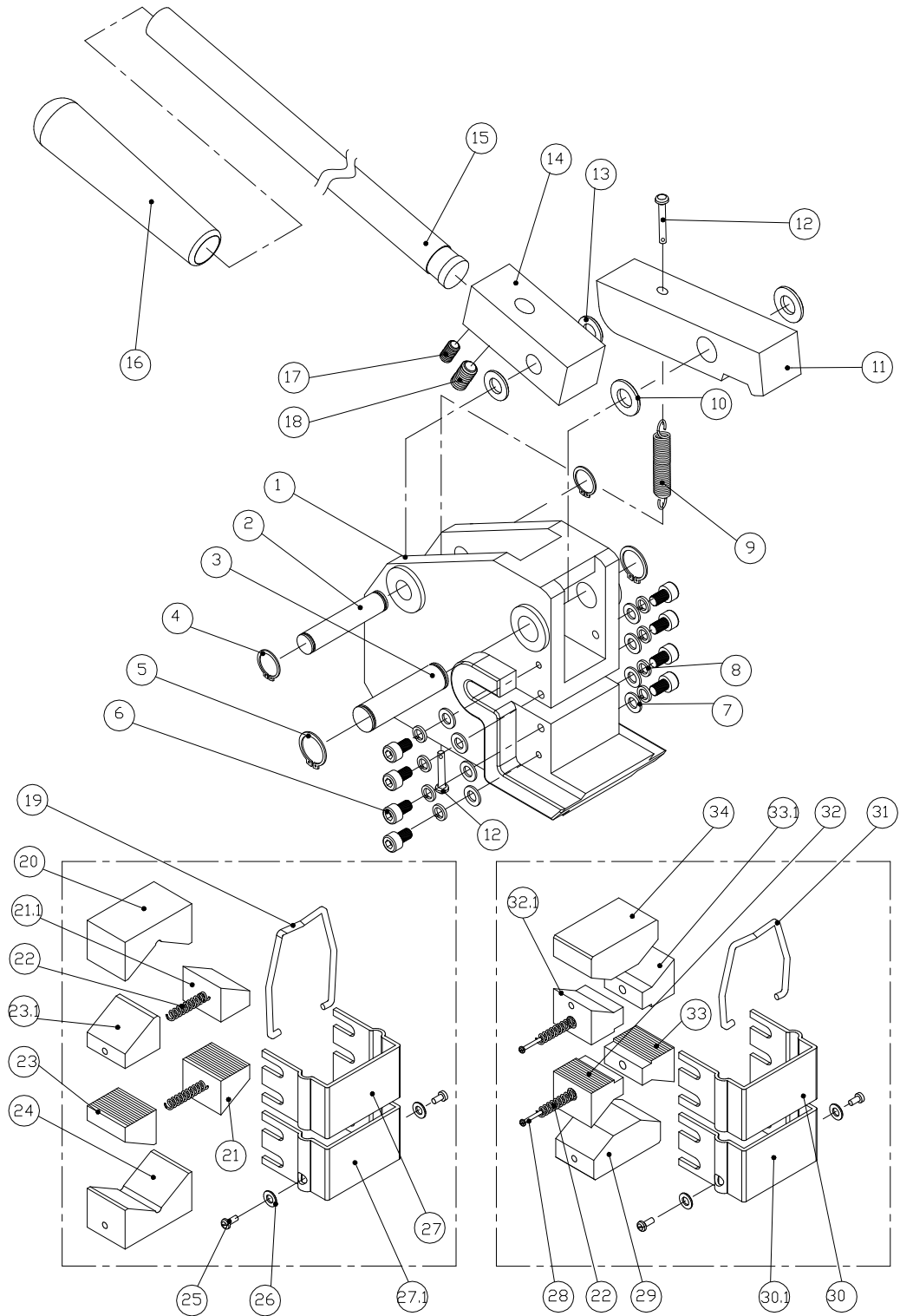| Max. Thickness (mm) | Packing Size (mm)(LxWxH) | N.W./G.W.(kg) |
|---|---|---|
| 1.5 | 46x21x13 | 5.4/6.2 |

## ● OPERATION AND ADJUSTMENT

Please make sure the jaws are fixed on the body securely and the body (#1) fixed on a suitable stand firmly before using this tool; The dies with teeth should maintain sharp, each die should be ensured can open or close when handle (#15) depressed, and can recover when handle lift up; Put the metal in the middle of jaw box, and press down the handle when you forming.

Notice: Any work should within it's max. capacity.

The bolt (#18) can be adjusted to control the handle height and open spaces between upper and lower dies according to different conditions.

# Exploded Figure

**PARTS LIST:**

| Part No. | Description/Specification | QTY. | Remark |
|---|---|---|---|
| 1 | Body | 1 | |
| 2 | Shaft I | 1 | |
| 3 | Shaft II | 1 | |
| 4 | Checking ring 10 | 2 | |
| 5 | Checking ring 13 | 2 | |
| 6 | Bolt | 8 | |
| 7 | Washer 5 | 8 | |
| 8 | Standard spring washer | 8 | |
| 9 | Tension spring | 1 | |
| 10 | Thin washer | 2 | |
| 11 | Moulding-die stick | 1 | |
| 12 | rivet | 2 | |
| 13 | Thin washer | 2 | |
| 14 | Seat for handle | 1 | |
| 15 | handle | 1 | |
| 16 | Cover for handle | 1 | |
| 17 | Set screw M6X10 | 1 | |
| 18 | Set screw M8X20 | 1 | |
| 19 | handle | 1 | |
| 20 | Die 1 | 1 | |
| 21 | Die 2 | 1 | |
| 21.1 | Die 2 | 1 | With hole |
| 22 | Compress spring | 4 | |
| 23 | Die 3 | 1 | |
| 23.1 | Die 3 | 1 | With hole |
| 24 | Die 4 | 1 | |
| 25 | Bolt M4X10 | 4 | |
| 26 | Washer 4 | 4 | |
| 27 | Cover for Shrinker | 1 | |
| 27.1 | Cover for Shrinker | 1 | With hole |
| 28 | Bolt M4X25 | 2 | |
| 29 | Die 4 | 1 | |
| 30 | Cover for Stretcher | 1 | |
| 30.1 | Cover for Stretcher | 1 | With hole |
| 31 | Handle | 1 | |
| 32 | Die 3 | 2 | |
| 33 | Die 2 | 2 | |
| 34 | Die 1 | 1 | |