

ALUMINUM BENDER

Model: ALB 2600

ALB 3200



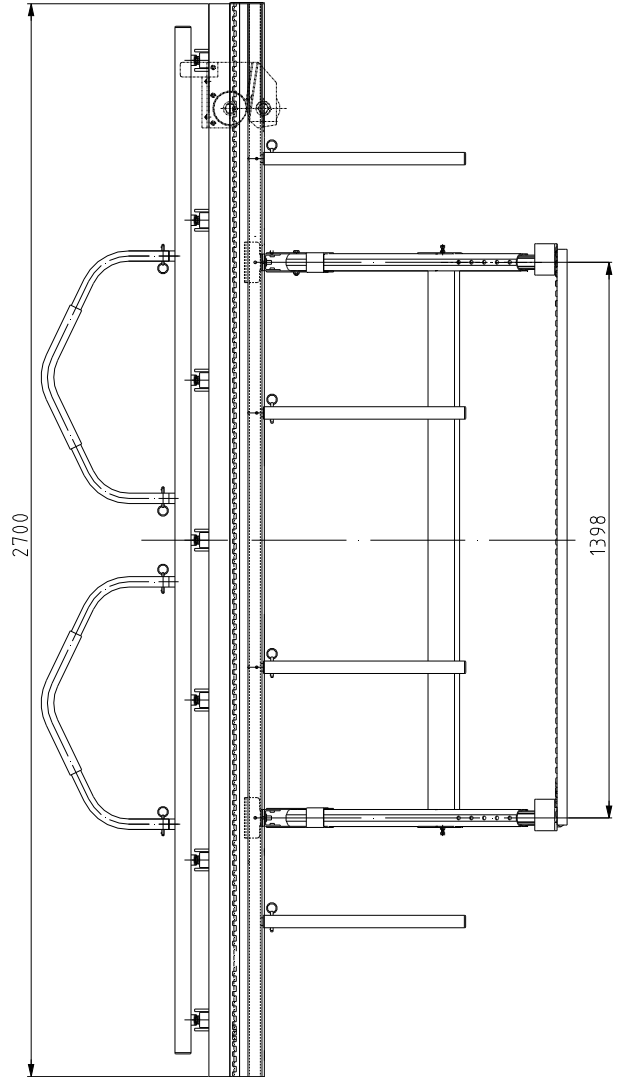
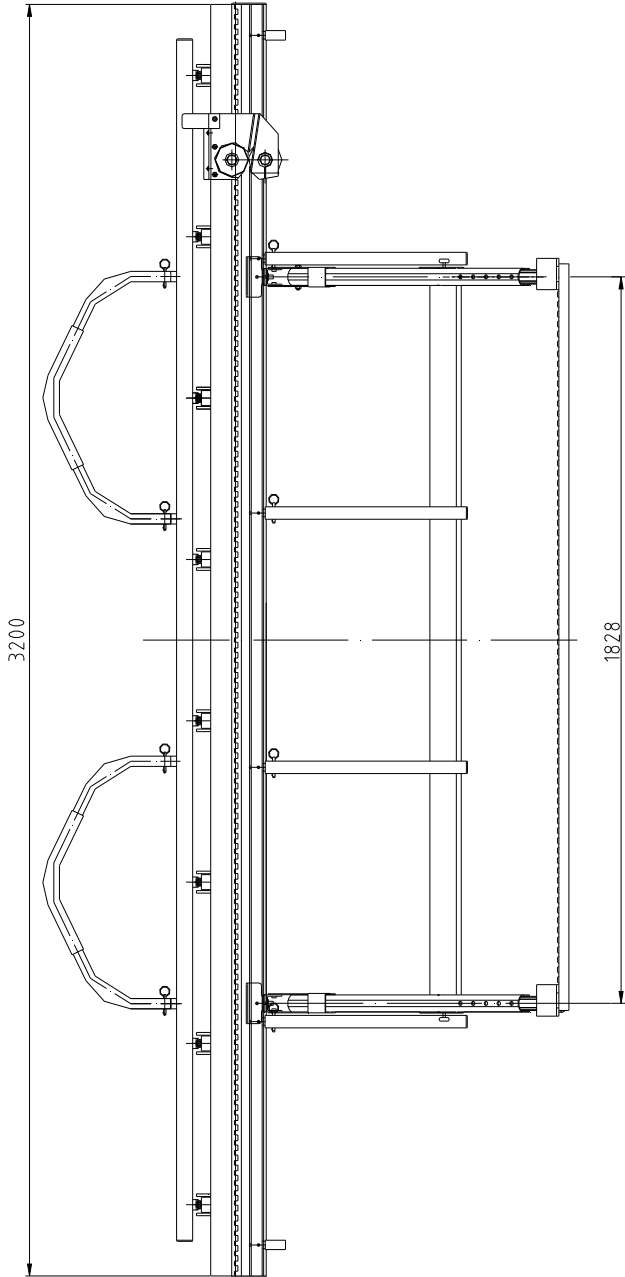
OPERATION MANUAL

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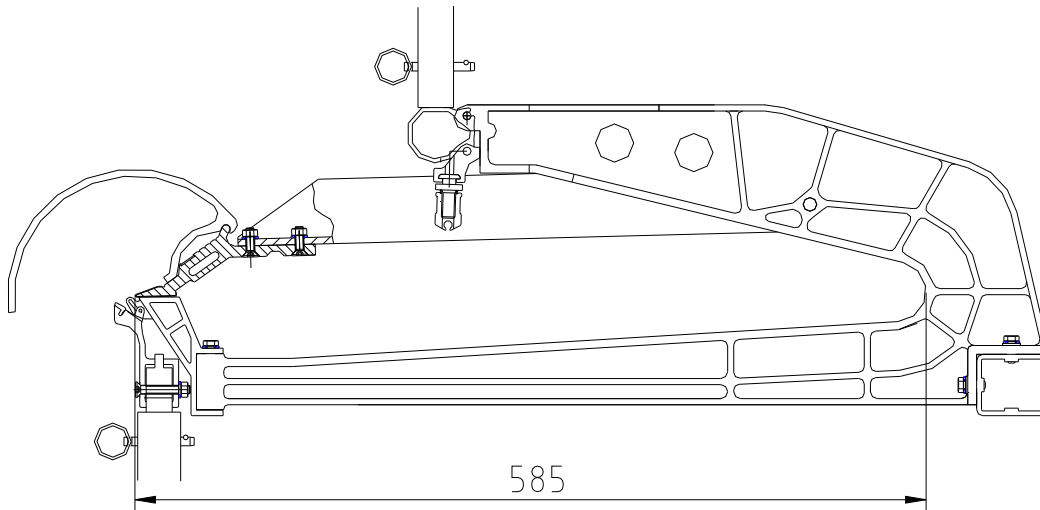
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I.Main specification

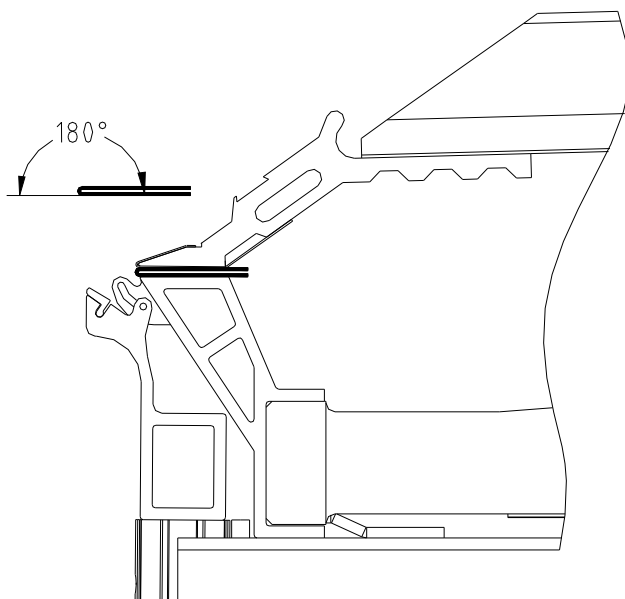
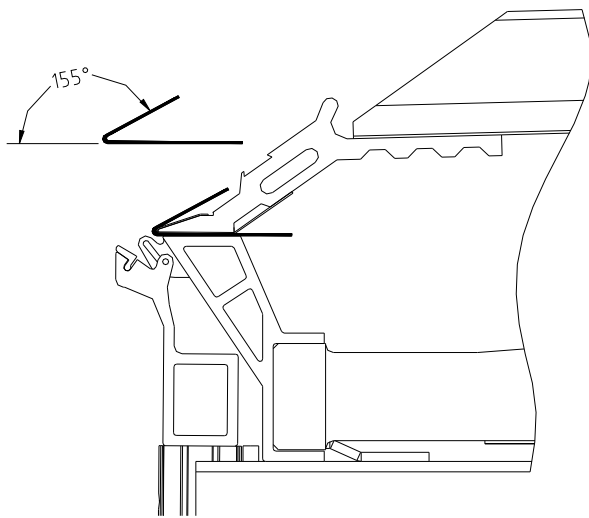
1 OUTLINE SIZE



2. INFEEED DEPTH

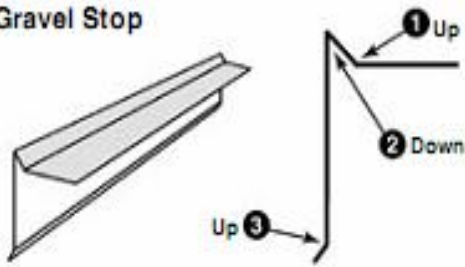


3 .BENDING LENGTH 3200mm (ALB 3200),BENDING LENGTH 2600mm(ALB 2600)

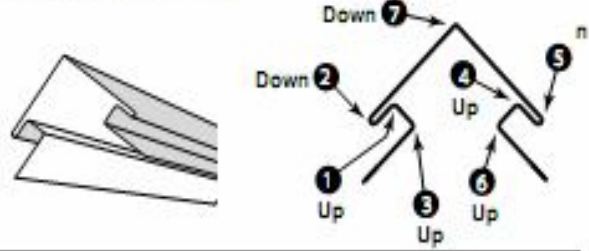


II. Workpiece shape

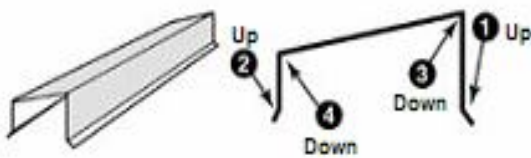
1. Gravel Stop



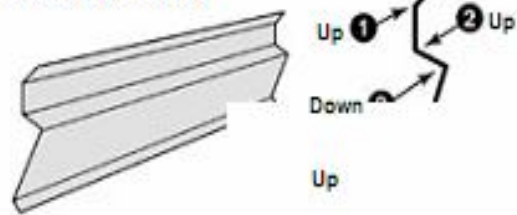
6. Outside Corner



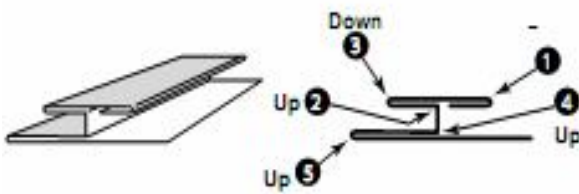
2. Coping Cover



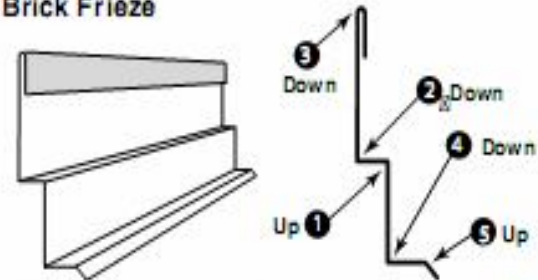
7. Counter Flashing



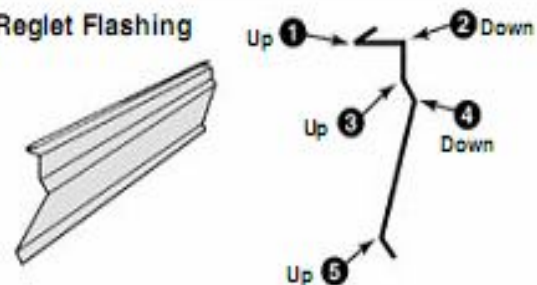
3. One Piece Soffit Mitre



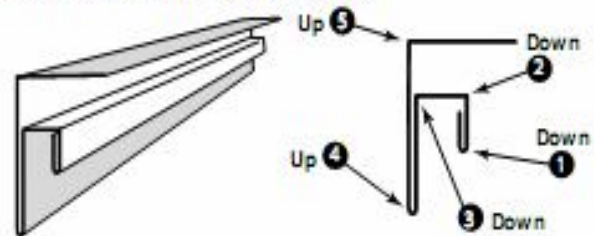
8. Brick Frieze



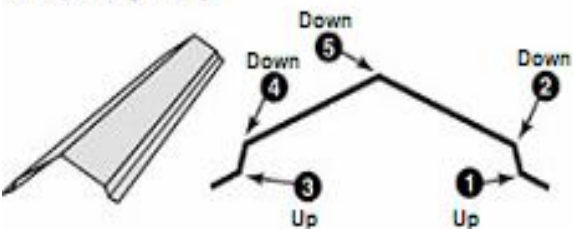
4. Reglet Flashing



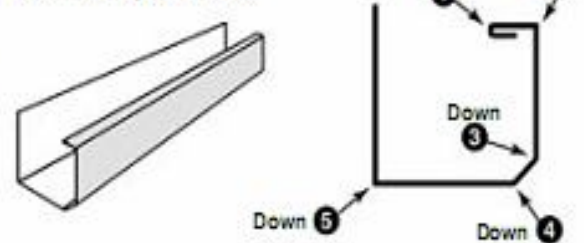
9. "F" Channel/Inside Corner



5. Hip/Ridge Cap



10. "D" Style Gutter

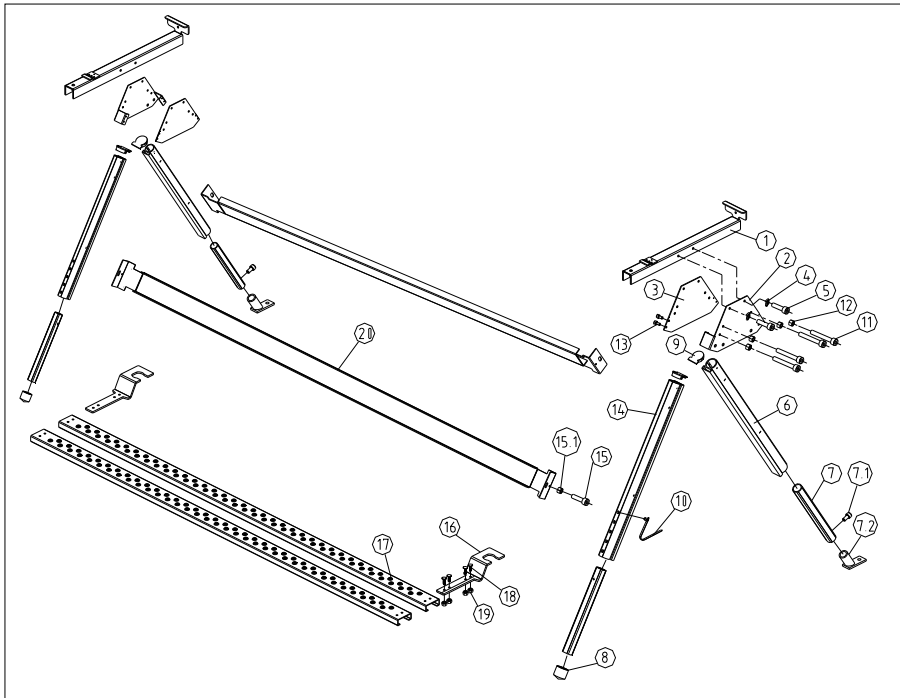


2 Main Specification

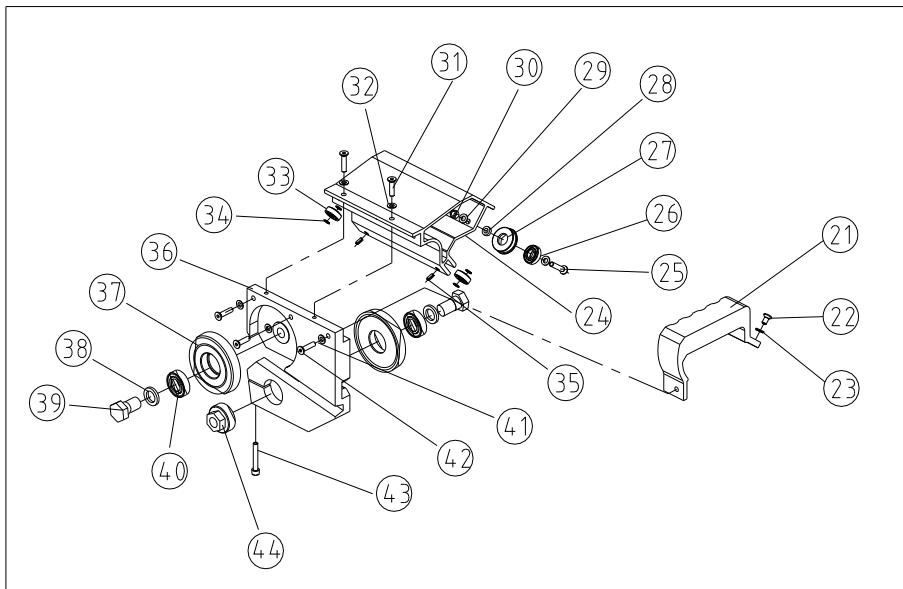
| Model | ABL 2600 | ABL 3200 |
|------------------------------|----------|----------|
| Bending length (mm) | 2600 | 3200 |
| Thickness of mild steel (mm) | 0.7 | 0.7 |
| Aluminum (mm) | 0.8 | 0.8 |
| Max.bending angle | 180° | 180° |
| Infeed depth(mm) | 580 | 580 |

III.Explosion diagram and part number

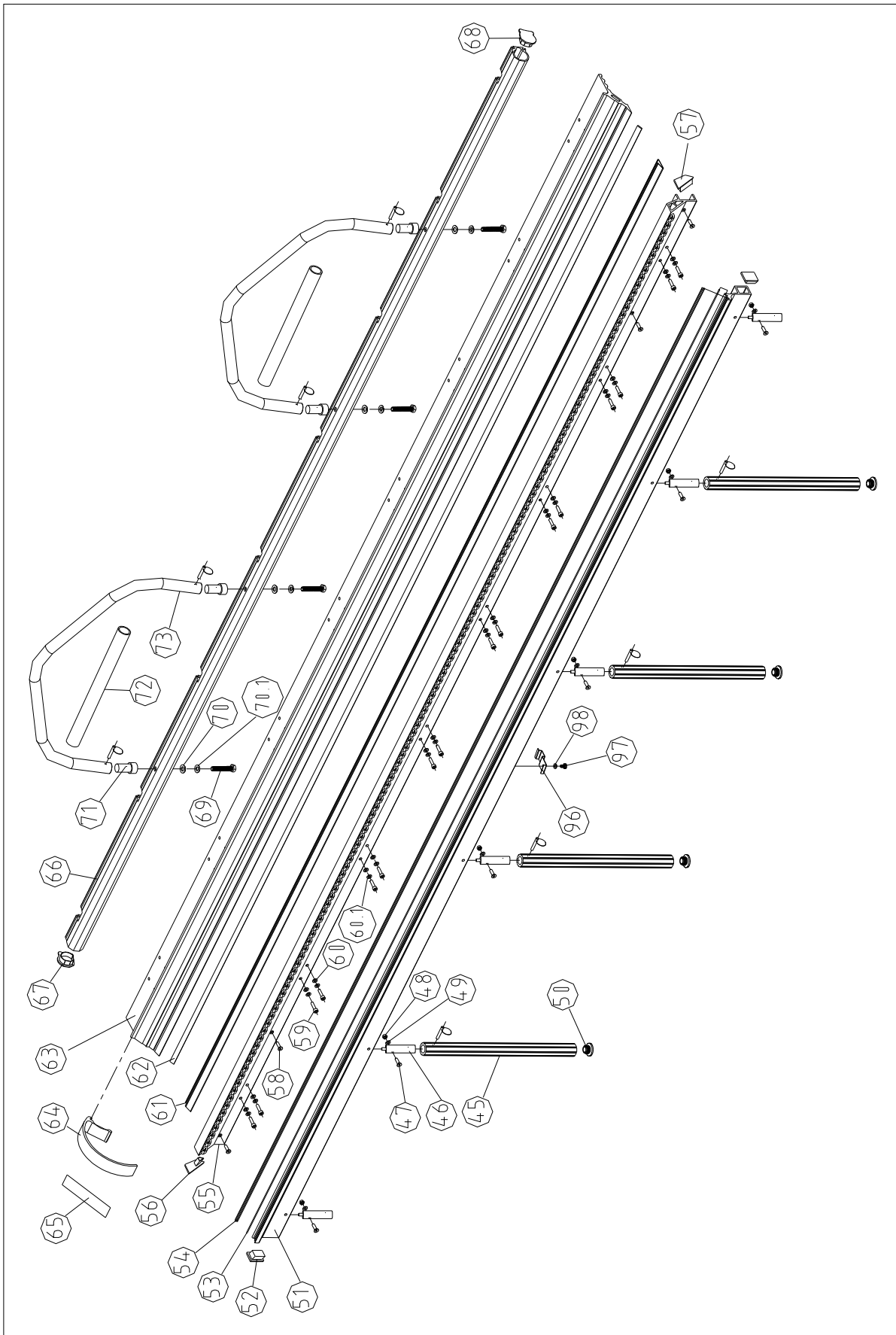
1 Stand

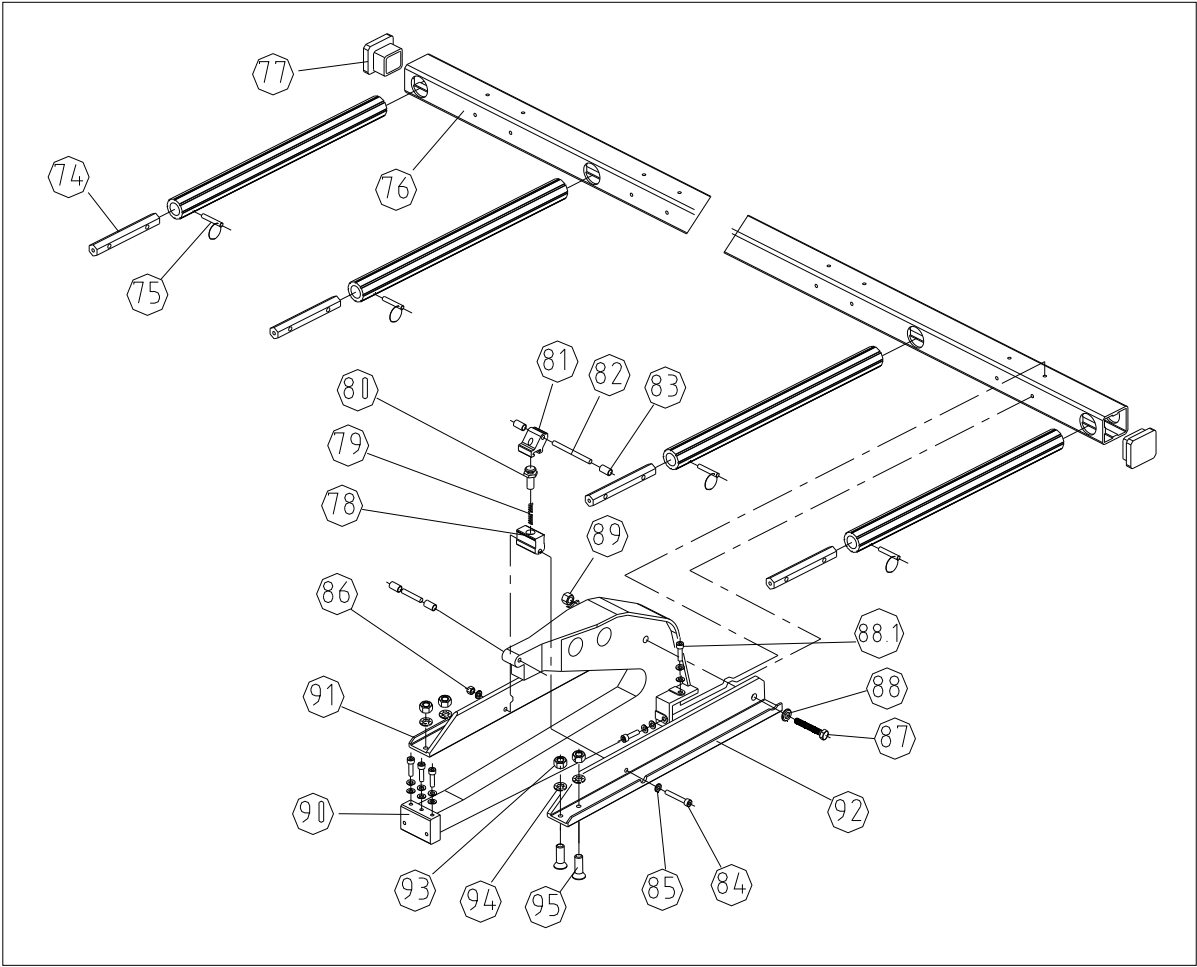


2 Shearing part



3 Body part





| Serial No. | Desc. | Size | Q'ty (ALB 3200) | Q'ty (ALB 2600) |
|------------|----------------------------------|---------|-----------------|-----------------|
| 1 | leg upper frame | | 2 | 2 |
| 2 | leg out connecting plate | | 2 | 2 |
| 3 | leg inner connecting plate | | 2 | 2 |
| 4 | Spring washer | 6 | 8 | 8 |
| 5 | Hex cylinder head screw | M6X16 | 8 | 8 |
| 6 | leg sleeve | | 2 | 2 |
| 7 | leg inner sleeve | | 4 | 4 |
| 7.1 | Hex cylinder head screw | M6X16 | 2 | 2 |
| 7.2 | plate | | 2 | 2 |
| 8 | leg inner casing sleeve | | 4 | 2 |
| 9 | Leg sleeve cover | | 4 | 4 |
| 10 | Spring pin | | 12 | 12 |
| 11 | Hex cylinder head screw | M6X60 | 8 | 8 |
| 12 | screw | M6 | 4 | 8 |
| 13 | Hex cylinder head screw | M6X12 | 4 | 4 |
| 14 | Leg sleeve | | 2 | 2 |
| 15 | Hex cylinder head screw | M6X16 | 2 | 2 |
| 15.1 | screw | M6 | 2 | 2 |
| 16 | Pedal connecting plate | | 2 | 2 |
| 17 | pedal | | 2 | 2 |
| 18 | screw | M6X16 | 8 | 8 |
| 19 | screw | M6 | 8 | 8 |
| 20 | Stand connecting plate | | 2 | 2 |
| 21 | grip | | 1 | 1 |
| 22 | inner six angle flat head screws | M6X16 | 1 | 1 |
| 23 | Flat washer | 6 | 1 | 1 |
| 24 | seat | | 1 | 1 |
| 25 | inner six angle flat head screws | M6X25 | 2 | 2 |
| 26 | Bearing | 6206-2Z | 2 | 2 |
| 27 | wheel | | 2 | 2 |
| 28 | cushion | | 2 | 2 |
| 29 | Flat washer | 6 | 4 | 4 |
| 30 | screw | M6 | 2 | 2 |
| 31 | inner six angle flat head screws | M6X16 | 4 | 4 |
| 32 | Flat washer | 6 | 4 | 4 |
| 33 | bearing | 6008-2Z | 2 | 2 |

| Serial No. | Desc. | Size | Q'ty (ALB 3200) | Q'ty (ALB 2600) |
|------------|----------------------------------|---------|-----------------|-----------------|
| 34 | cushion | | 4 | 4 |
| 35 | Spring pin | 8X20 | 2 | 2 |
| 36 | Blade frame | | 1 | 1 |
| 37 | Round knife | | 2 | 2 |
| 38 | cushion | | 2 | 2 |
| 39 | screw | | 2 | 2 |
| 40 | bearing | 6003-2Z | 2 | 2 |
| 41 | Flat washer | 6 | 1 | 1 |
| 42 | inner six angle flat head screws | M6X30 | 1 | 1 |
| 43 | inner six angle flat head screws | M6X40 | 1 | 1 |
| 44 | Adjust handle | | 1 | 1 |
| 45 | Bending handle | | 4 | 4 |
| 46 | Connecting shaft | | 6 | 6 |
| 47 | Six countersunk head screws | M6X40 | 6 | 6 |
| 48 | screw | M6 | 6 | 6 |
| 49 | Flat washer | 6 | 6 | 6 |
| 50 | Bending handle cover | | 4 | 4 |
| 51 | Bending body | | 1 | 1 |
| 52 | Bending body cover | | 2 | 2 |
| 53 | Long pin | | 1 | 1 |
| 54 | Rubber strip | | 1 | 1 |
| 55 | Support body | | 1 | 1 |
| 56 | Support body I | | 1 | 1 |
| 57 | Support body II | | 1 | 1 |
| 58 | Six countersunk head screws | M6X16 | 4 | 4 |
| 59 | Hex cylinder head screw | M6X16 | 40 | 36 |
| 60 | Flat washer | 6 | 72 | 63 |
| 60.1 | Spring washer | 6 | 72 | 63 |
| 61 | End bar | | 1 | 1 |
| 62 | scale | | 1 | 1 |
| 63 | Upper press frame | | 1 | 1 |
| 64 | Angle plate | | 1 | 1 |
| 65 | Angle scale | | 1 | 1 |
| 66 | Upper connecting pipe | | 1 | 1 |

| Serial No. | Desc. | Size | Q'ty (ALB 3200) | Q'ty (ALB 2600) |
|------------|-----------------------------------|--------|-----------------|-----------------|
| 67 | Connecting pipe cover I | | 1 | 1 |
| 68 | Connecting pipe cover II | | 1 | 1 |
| 69 | screw | M10X60 | 4 | 4 |
| 70 | Flat washer | 10 | 4 | 4 |
| 70.1 | Spring washer | 10 | 4 | 4 |
| 71 | Upper press handle connecting pin | | 4 | 4 |
| 72 | Upper press handle set | | 2 | 2 |
| 73 | Upper press handle | | 2 | 2 |
| 74 | Six arrises shaft | | 4 | 2 |
| 75 | Connecting pin | | 8 | 8 |
| 76 | Back connecting pipe | | 1 | 1 |
| 77 | Back connecting pipe cover | | 2 | 2 |
| 78 | Down connecting plate | | 8 | 7 |
| 79 | spring | | 8 | 7 |
| 80 | Special shape nut | | 8 | 7 |
| 81 | Upper connecting plate | | 8 | 7 |
| 82 | pin | | 8 | 14 |
| 83 | Rubber tube | | 16 | 28 |
| 84 | Hex cylinder head screw | M6X65 | 8 | 7 |
| 85 | Flat washer | 6 | 32 | 28 |
| 86 | locknut | M6 | 8 | 7 |
| 87 | hexagon bolt | M10X75 | 8 | 7 |
| 88 | Flat washer | 10 | 32 | 28 |
| 88.1 | Hex cylinder head screw | M6x20 | 32 | 28 |
| 89 | locknut | M10 | 8 | 7 |
| 90 | body | | 8 | 7 |
| 91 | Connecting arm | | 8 | 7 |
| 92 | Connecting arm | | 8 | 7 |
| 93 | Six countersunk head screws | M6X20 | 32 | 28 |
| 94 | Lock washer | 6 | 32 | 28 |
| 95 | screw | M6 | 32 | 28 |
| 96 | Connecting plate | | 1 | 1 |
| 97 | Cross pan head screw | M6X10 | 1 | 1 |
| 98 | Flat washer | 6 | 1 | 1 |

IV. Installation and test



Pic. 001



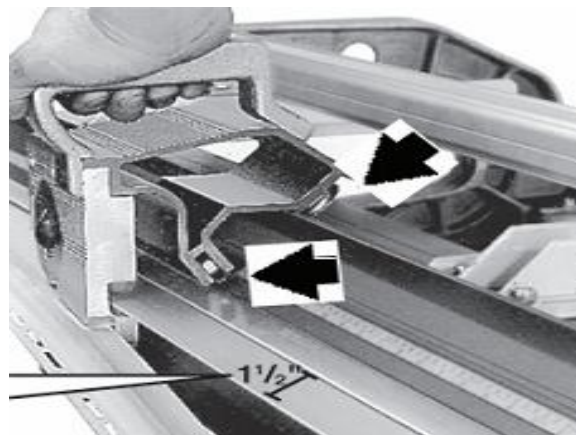
Pic. 002

To open each Leg Set, push in the snap button and move each leg outward to the working position. Figure 001 above shows the leg set as shipped while Figure 002 shows the leg set open (working position). Make sure that the snap button pops up to lock each leg.



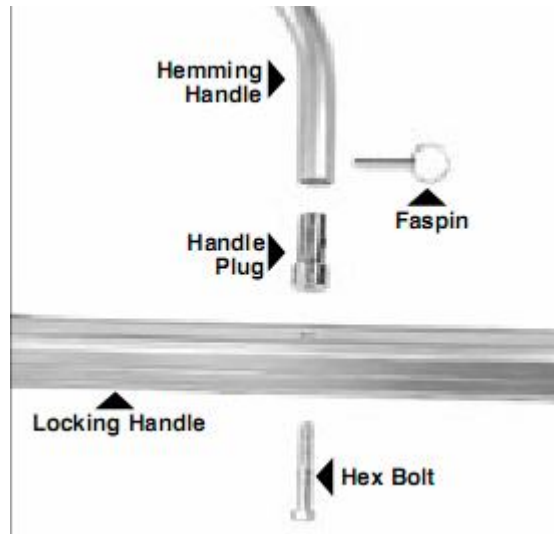
Pic. 003

Note: Be sure the C-shape of the Cross Brace is mating the leg as shown in Figure 003.



Pic. 004:

Figure 004: Engage Guide Rollers correctly. Make sure both front and back rollers are seated in their tracks. (Note large arrows in illustration above.)



Pic. 005

Figure 005: The Hemming Handle Assembly includes: (1) Hemming Handle, (2) Handle Plugs, (2) Faspins, (2) Hex Bolts.

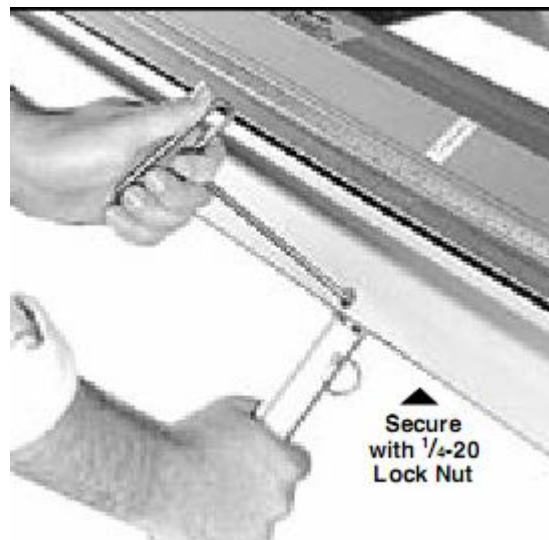


Pic. 006

Figure 006: The Hinge Clip keeps the Moving Hinge in position for ease of aligning material. It can also prevent rippling of the coil during cut off operations.

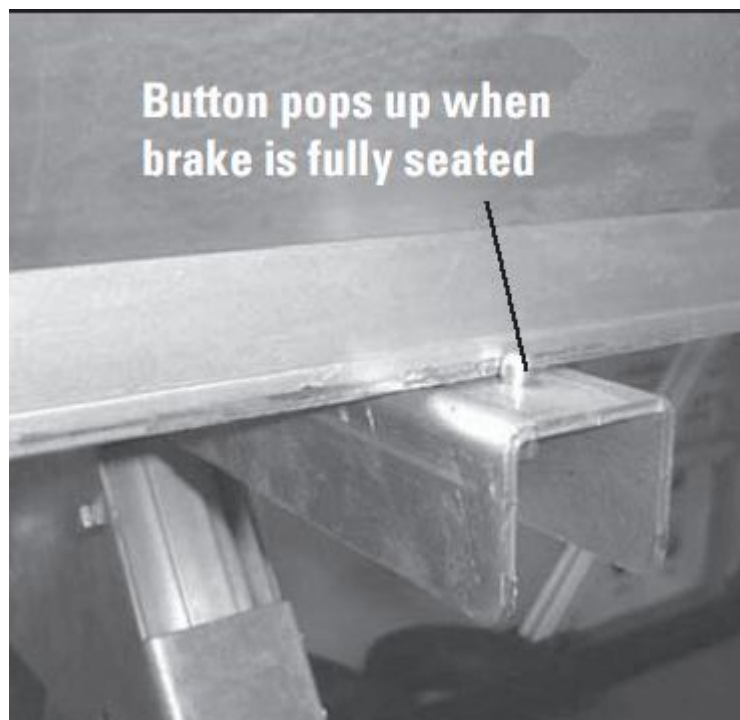
To install Hinge Clip, locate predrilled hole on bottom center of Moving Hinge. Align holes in Clip and Hinge as shown and insert Phillips head screw provided.

Note: You must use hinge clip when using Pro Cut-Off.



Pic. 007

Figure 007: Insert Handle Assembly into hole in bottom of Moving Hinge. Align hole in hinge with Handle Plug and insert screw using T-Handle Hex Key as shown. Secure with 1/4-20 Lock Nut.



Pic. 008

Push the brake firmly rearward into the adaptor hooks. The snap buttons by the front clips will pop up and secure the brake on the Snap Stand.

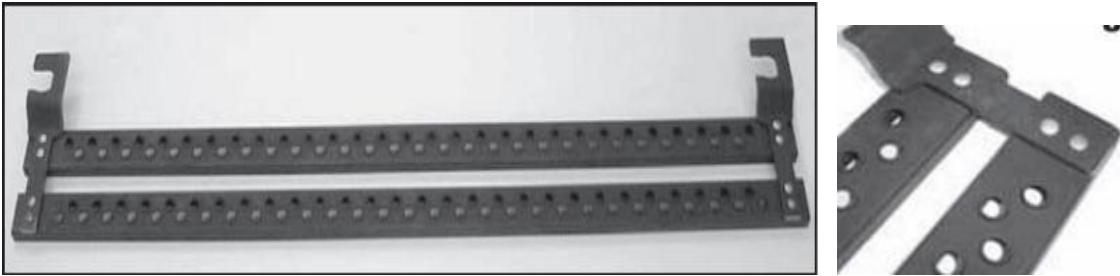
See Figure 008 above.

Removing a Brake from Max Snap Stand

- Removing the brake from the Snap Stand is essentially the opposite of attaching it to

the stand.

- Lifting the Moving Hinge, depress the snap button and pull the brake forward far enough to hold each snap button down.
- Be sure the box rail is out of the Rear Clip. The brake can now be removed from the stand.
- Reverse Steps 2 and 1 to disassemble the stand for transport.



Pic. 009

Attach the Connectors to the Steps using the carriage bolts and nuts provided. The square portion of the carriage bolt will fall into the square holes that are punched in the Connector. Tighten securely using a 7/16" wrench. See figure 009 above for Connector orientation.



Pic. 010

Removal is the reverse of assembly. Lift up on the steps to release them from the legs, and slide the assembly to the right until the connectors are free of the legs.

To attach the Step Assembly to the Snap Stand, hold the assembly at an angle as shown and slide both connectors leftward over both legs of the Snap Stand as far as they will go. Allow the connectors to slip down the legs until the steps are flat and touching the ground. The connectors should be gripping the front and back of each leg. Standing on the steps while bending will lock the connectors in place on the legs.

Removal is the reverse of assembly. Lift up on the steps to release them from the legs, and slide the assembly to the right until the connectors are free of the legs.

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. And please note the local voltage while operating this electric machine.