

KAKA® Industrial

Specifications

Model.....BP-1650
 Stock No.173030
 Max. bending length..... 1270mm / 50”
 Max. thickness..... 1.5mm / 16Ga
 Max. box depth..... 100mm / 4”
 Max. lift of beam..... 32mm / 1 1/4”
 Beam adjustment..... 16mm 5/8”
 Finger nose angle..... 45°
 Packing size..... 168x59x82 cm
 N.W./G.W. 202/247 kg 444/543lbs

If damage has occurred, shipping damage claims must be filed with the carrier and are the responsibility of the user.

Check for completeness. Immediately report missing parts to dealer.

Carefully open crate and unbolt brake from shipping pallet and remove from crate using heavy duty lifting equipment such as an overhead crane.



Warning

The warnings, cautions and instructions discussed in this instructions or situations that could occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

Unpacking

The ARBOR PRESS is shipped from the manufacture in a carefully packed Carton box. Thoroughly inspect the product upon opening the package. After unpacking the unit, carefully inspect for any damage that may have occurred during transit.

SAVE THIS MANUAL

You will need this manual for the safety instruction, assembly instruction, operating procedures, parts list, and diagram. Write your invoice number on the inside front cover. Put both your manual and invoice in a safe, dry place for future reference.

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Safety

Authorized use

- This bench hand break is designed for bending metal and plastic materials only.
- The proper use also includes compliance with the operating and maintenance instructions given in this manual.
- The machine must be operated only by persons familiar with its operation and maintenance and who are familiar with its hazards.
- The required minimum age must be observed.
- The machine must only be used in a technically perfect condition.
- When working on the machine, all safety mechanisms and covers must be mounted.
- Any other use exceeds authorization. In the event of unauthorized use of the machine, the manufacturer renounces all liability and the responsibility is transferred exclusively to the operator.

Safety notes

- Metalworking machines can be dangerous if not used properly.

Therefore, the appropriate general technical rules as well as the following notes must be observed.

- Read and understand the entire instruction manual before attempting assembly or operation.
- Keep this operating instruction close by the machine, protected from dirt and humidity, and pass it over to the new owner if you part with the tool.
- Install the machine so that there is sufficient space for safe operation and work piece handling.
- Keep work area well lighted.
- The machine is designed to operate in closed rooms and must be bolted to the cabinet stand or a solid work bench.
- Keep the floor around the machine clean and free of scrap material, oil and grease.
- Remove all loose clothing and confine long hair.
- Before operating the machine, remove tie, rings, watches and other jewelry.
- Wear safety shoes; never wear leisure shoes or sandals.
- Sheet metal stock has sharp edges. WEAR GLOVES when handling sharp edged work pieces.
- WEAR SAFETY GLASSES.

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- KEEP HANDS AND FINGERS clear of the area in front and rear of the shearing blades.

- Stay alert!

Give your work undivided attention. Use common sense. Do not operate the machine when you are tired.

- Do not operate the machine under the influence of drugs, alcohol or any medication. Be aware that medication can change your behavior.

- Keep children and visitors a safe distance from the work area.

- Keep guards in place and in working order.

- Specifications regarding the maximum or minimum size of the work piece must be observed.

- Support long work pieces with helping roller stands.

- Do not stand on the machine.

Transport and installation

Transport

1. The machine will be delivered in a closed crate.

2. For transport use a forklift or hand trolley. Make sure the machine does not tip or fall off during transport.

3. If you notice transport damage while unpacking, notify your supplier immediately. Do not operate the machine!

4. Dispose of the packing in an environmentally friendly manner.

5. Clean all rust protected surfaces with petroleum, diesel oil or a mild solvent.

6. Coat all machined surfaces with a light coat of oil to inhibit rust.

Installation

1. The machine is designed to operate in closed rooms and must be bolted to the cabinet stand or a solid work bench.

2. Machine location must allow access to all sides.

3. The brake will not bend properly if it is not level. Use a machinist's level and shims if necessary.

4. To avoid tipping the machine must be bolted to the floor.

Assembly

Attach the counter weight (32) with 2 grub screws.

Initial Adjustments

1. The machine has been adjusted at the factory.

2. During shipment the machine may have come out of alignment.

3. See chapter 5 for proper alignment.

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Machine operation

1. Specifications regarding the maximum or minimum size of the work piece must be observed.
2. Support long work pieces with helping roller stands.
3. Sheet metal stock has sharp edges. WEAR GLOVES when handling sharp edged work pieces.
4. WEAR SAFETY GLASSES.
5. KEEP HANDS AND FINGERS clear of the cutting area in front and rear of the shearing blades.

Adjustments

Adjusting for Material Thickness

The hold down assembly (1) must be adjusted to allow for clearance according to the thickness of the material.

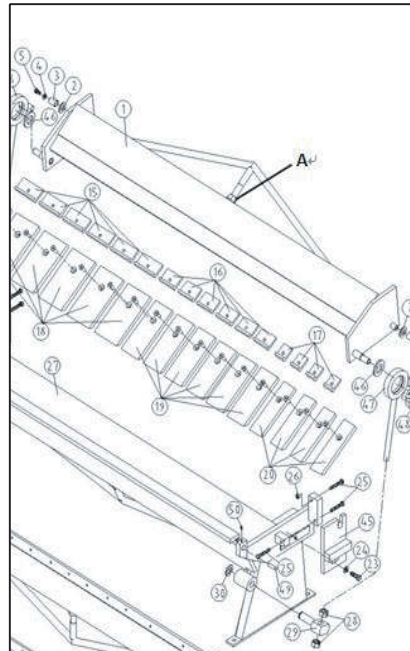
Clearance for material should be 1,5 to 2 times the thickness of the material.

The forward edge of the hold down fingers (18, 19 & 20) should be adjusted parallel to the pivot edge of the clamp block (27).

Release clamping pressure on the hold down assembly by pushing clamp handles (13) slightly to the rear.

Turn the screws (25) to adjust for parallel and proper clearance.

The centre of the hold down assembly (1) can be adjusted by tightening the truss nut (A).



Finger alignment

Finger alignment can be achieved by loosening all screws (21) and rotating the apron (35) to the 90° position.

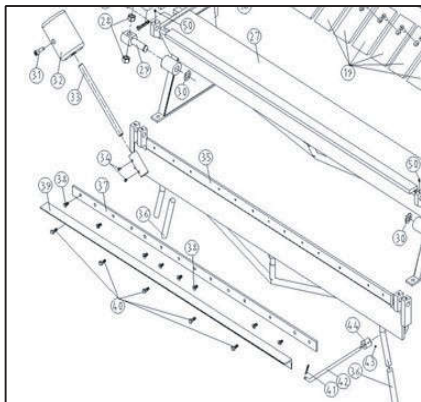
This will align all fingers. Tighten screws (21).

Adjusting the Clamping Pressure

The clamping pressure should be adjusted according to the thickness of the material.

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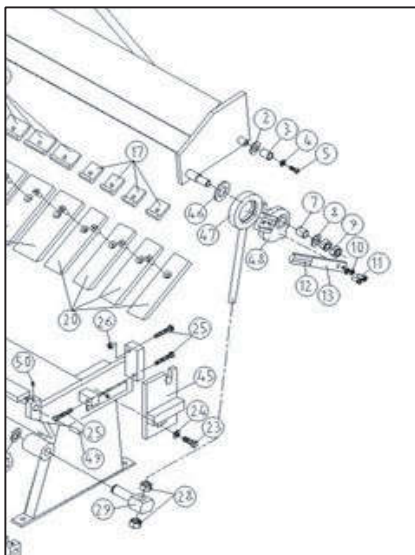
Clamping pressure can be adjusted by turning the nuts (28)



Apron Adjustment

The counter weight (32) can be moved up or down to provide leverage.

The center of the apron (35) can be adjusted by tightening the truss nut (B).



Repeat Bends

Adjust the stop (44) on the stop rod (42) to limit the swing of the apron assembly.

Maintenance

Lubrication:

The machine must be lubricated every day of service with a few drops of oil.

Lubricate all slide and pivot points of the machine.

Oil pinholes are located at both yoke assemblies (47) and near both apron hinge pins (49).

Lightly oil the machined parts when not in use to prevent rust.

Environmental protection

Protect the environment.

Your appliance contains valuable materials which can be recovered or recycled. Please leave it at a specialized institution.

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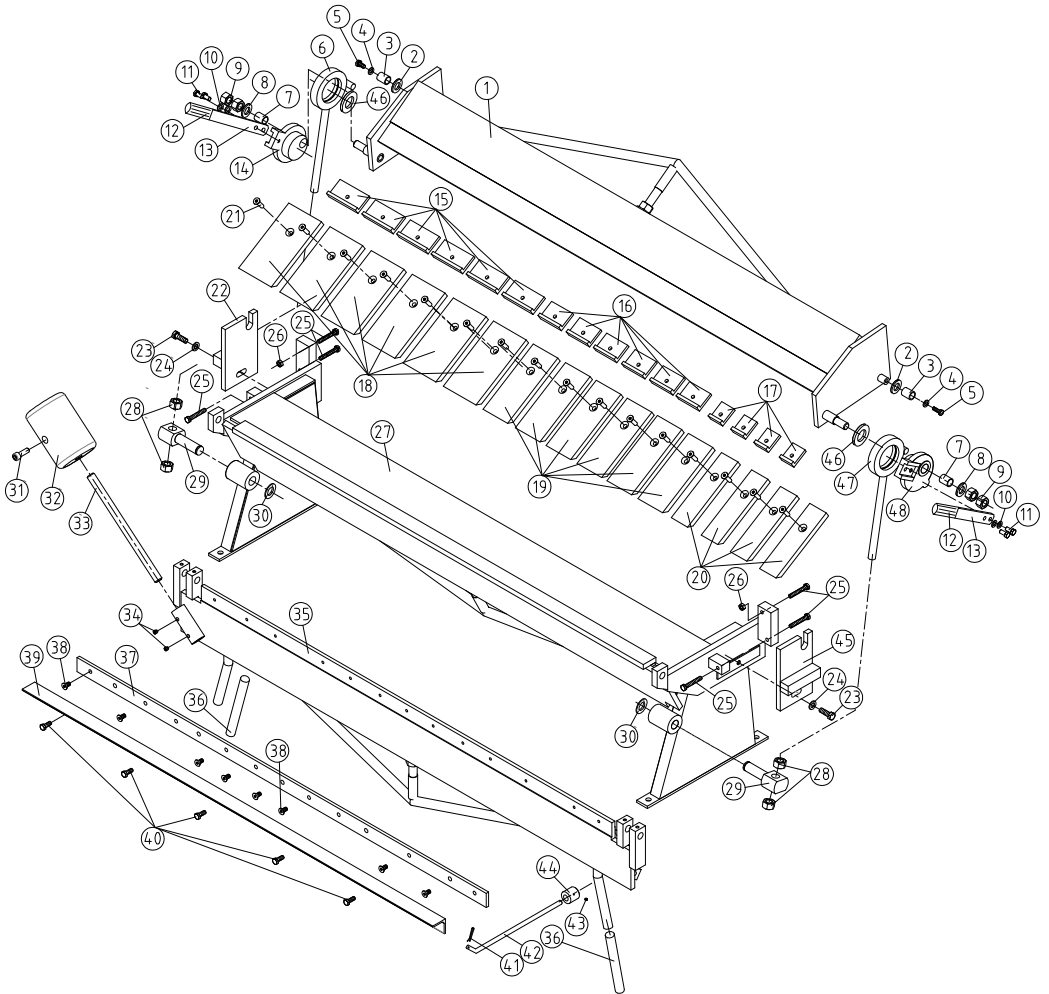
Parts List

Part No.	Name	Qty	Part No.	Name	Qty
1	Head frame	1	26	Nut M8	6
2	Big washer	2	27	Bearing knife	1
3	Bush	2	28	Nut M16	4
4	Washer 8	2	29	Connecting shaft	2
5	Hexagon bolt M8X16	2	30	Check ring 21	2
6	Left rotary arm	1	31	Hexagon bolt M10X30	1
7	Bush	2	32	Head of counterweight hammer	1
8	Washer 16	2	33	Bar of counterweight hammer	1
9	Nut M16	4	34	Hexagon socket set screw M8X8	2
10	Washer 8	4	35	Bending part	1
11	Hexagon bolt M8X16	4	36	Extended handle	2
12	Handle cover	2	37	Scale board	1
13	Handle	2	38	Head screws M8X16	8
14	Left eccentric disc	1	39	Strengthening bar	1
15	Fixed block of upper knife	6	40	Hexagon bolt M8X20	5
16	Fixed block of upper knife	6	41	Cotter ϕ 3X25	1

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17	Fixed block of upper knife	4	42	Limit lever for bending angle	1
18	Upper blade	6	43	Hexagon socket set screw M6X6	1
19	Upper blade	6	44	Limited set of bending angles	1
20	Upper blade	4	45	Right adjusting plate for head frame	1
21	Head screw M8X30	16	46	Big washer	2
22	Left adjusting plate for head frame	1	47	Right rotary arm	1
23	Hexagon bolt M10X30	2	48	Right eccentric disc	1
24	Washer 10	2	49	Rotary shaft	2
25	Hexagon bolt M8X50	6	50	Check ring 16	4

Drawing:



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If you have any questions about the use of this product, please contact the nearest one to you as below:

KAKA INDUSTRIAL LLC

Mail:
info@kakaindustrial.com
Add: 4200 STEVE
REYNOLDS BLVD
STE 6 NORCROSS, GA
30093

KAKA INDUSTRIAL LTD.

Mail:
info@kakaindustrial.ca
Add: 3143 Underhill
Avenue,
Burnaby, B.C V5A3C8,
Canada

KANG INDUSTRIAL PTY LTD

Mail:
kang@kakaindustrial.com
Add: 3 WAYNE COURT
DANDENONG VIC 3175