

KAKA Industrial®

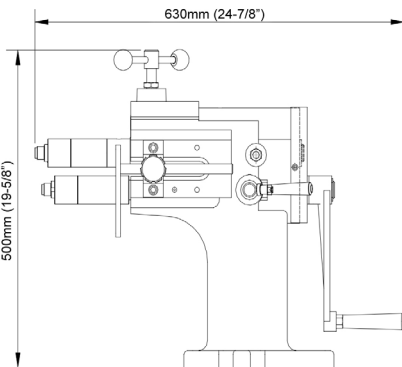
Unpacking

The manual bead bending machine is shipped from the manufacturer in a carefully packed ply-wood case. Thoroughly inspect the product upon opening the package. After unpacking the unit, carefully inspect for any damage that may have occurred during transit. Check for loose, missing, or damaged parts.

Shipping damage claims must be filed with the carrier and are the responsibility of the user.

Specifications

Max. thickness.....1.2 mm (18 Ga)
 Cylinder length.....140 mm (5-1/2")
 Throat depth.....200 mm (8")
 Center distance between the rollers...56 mm (2.2")
 Overall dimension....631.83 mm x 269.88 mm
 x 498.48 mm (24-7/8" x 10-5/8" x 19-5/8")
 Weight46 kg(106 lbs)



Important:

The manual bead bending machine is supplied with a protective coating which should be removed before operation. Remove this coating with a mild solvent, such as a mineral spirits using a soft cloth. Avoid getting cleaning solution on paint or any of the rubber or plastic parts. Solvents may deteriorate these finishes. Use soap and water on paint, plastic or rubber components. After cleaning, cover all exposed surfaces with a light coating of oil.

▲WARNING

Never use highly volatile solvents.
 Non-flammable solvents are recommended to avoid possible fire hazard.

SAVE THESE INSTRUCTIONS

Thank you for purchasing The Manual Bead Bending Machine. Before attempting to operate your new tool please read these instructions thoroughly. You will need these instructions for the safety warnings, precautions, assembly, operation, maintenance procedures, parts list and diagrams. Keep your invoice number with these instructions. Write the invoice number on the inside of front cover. Keep the instructions and invoice in a safe, dry place for future reference.

General Safety Information

▲CAUTION

Always follow proper operating procedures as defined in this manual even if you are familiar with use of this or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury.

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SAFETY RULES

1. Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
2. Wear protective hair covering to contain long hair.
3. Wear safety shoes with non-slip soles.
4. Wear safety glasses complying with United States ANSI Z87.1.

Everyday glasses have only impact resistant lenses. They are NOT safety glasses.

5. Be alert and think clearly. Never operate tools when tired, intoxicated or when taking medications that cause drowsiness.
6. Keep work area clean. Cluttered work areas invite accidents.
7. Work area should be properly lit.
8. Keep visitors at a safe distance from work area.
9. Keep children out of workplace. Make workshop childproof. Use padlocks to prevent any unintentional use of tools.
10. Assemble only according to these instructions. Improper assembly can create hazards.
11. When tools are not in use, store them in a dry, secure place out of the reach of children. Inspect the tools prior to storage and before reuse.
12. Maintain product labels and nameplates. These carry important safety information.

▲ WARNING
 Before drilling mounting holes, stay clear of electrical conduit, water pipes or any other potential hazard.

Assembly

This manual bead bending machine must be

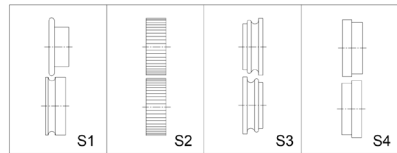
securely mounted to a solid surface using the 13mm mounting holes provided.

The operation of this machine will require exertion of considerable force on the handle so it is essential that it is mounted to a heavy and immovable work bench or work surface. Be certain that there will be adequate clearance for the entire range of motion of handle #10 while avoiding potential pinch points of the operator's hand.

Operation

1. Forming Force: Upper Roller Shaft
2. Positioning Roller: Lower Roller Shaft
 - A. Lower shaft slide/position control #24
 - B. Raise and lower upper roller shaft #17 to adjust distance between the upper and lower roller shafts. To lock upper roller shaft position, rotate the handle #10 and lock with #15 Locknut.
 - C. To position lower roller shaft #24, unscrew locking handle #25 and slide the shaft to the desired position. Tighten locking handle #25.

3. STANDARD ROLLERS:

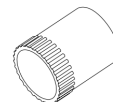


Work-piece shapes respectively:

1) S1



2) S2

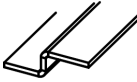


3) S3

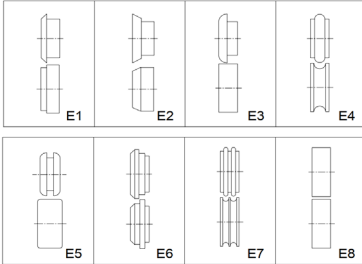


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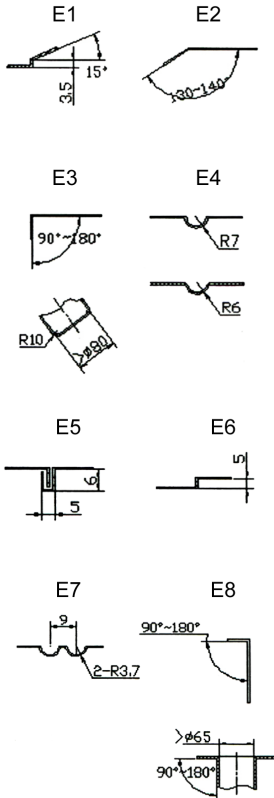
4) S4



4. OPTIONAL ROLLERS (not included):



Work-piece shapes respectively:



▲ CAUTION

The center distance of upper and lower rollers can be adjusted by turning handle (#10) as required.

▲ WARNING

Do not roll a plate thicker than the benders capacity. You will damage the Bender. Measure the thickness before use.

Changing Rollers

Loosen pressure cover #19, #20, #26 in order to remove/replace the rollers.

Install select roller set and secure pressure cover. Please refer to Figure 1 below.

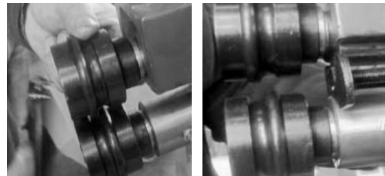


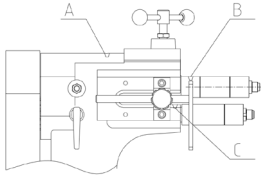
Figure 1

Maintenance

1. It is recommended that the general condition of any machine be examined before it is used. Keep your bending machine in good working condition by adopting a program of consistent inspection and maintenance in accordance with the recommended procedures found in this manual.
2. Keep bender clean by using soap and a damp cloth. Many household cleaners are harmful to plastics and other material. Never let liquid get into a tool.
3. Spread a thin film of oil on the roller dies before bending material to make the operation smoother and to preserve roller life. This bead bending machine is a SINGLE LUBE-SINGLE RUN machine.

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Therefore, lubrication should be applied before each short run of parts using 30W oil at locations A and B shown on the diagram below.



4. Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended function.

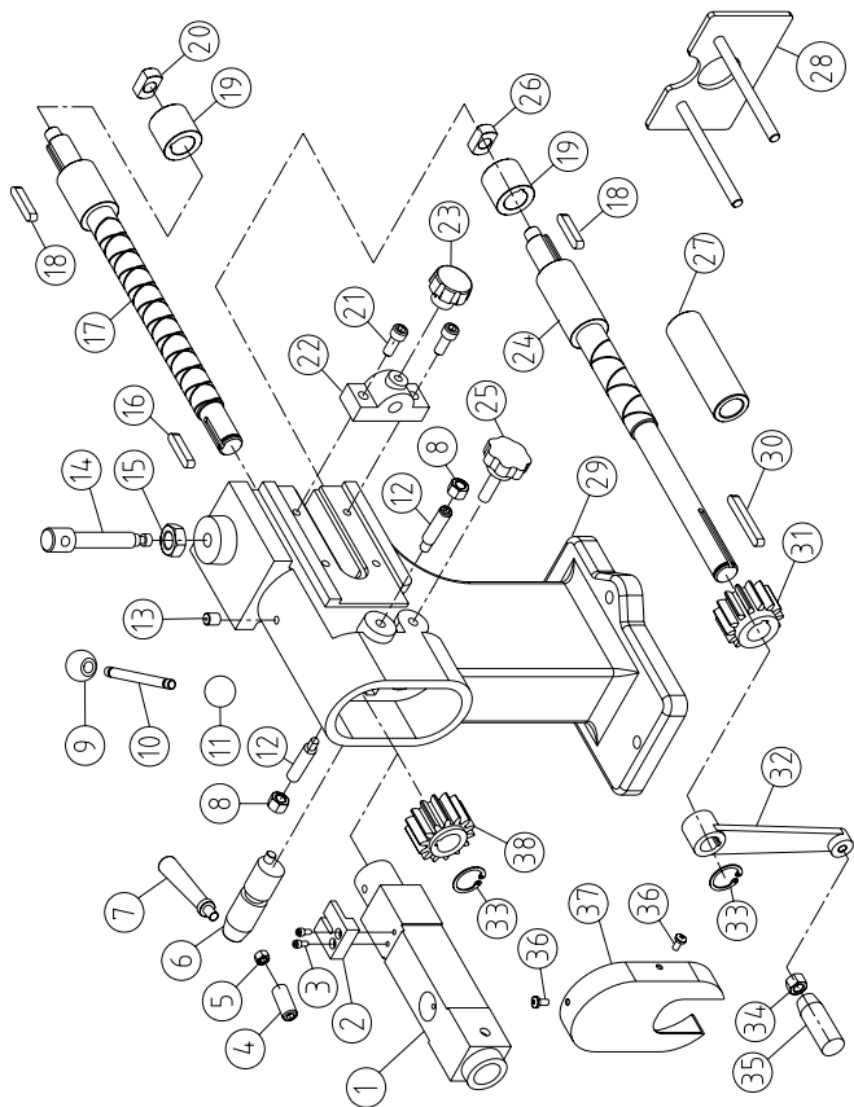
5. Check for damaged parts. Check for alignment of moving parts, binding, breakage, and mounting or any other condition that may affect a tool's operation.

Packing List

Ser No.	Description	QTY	Ser No.	Description	QTY
1	Bead bending machine	1	4	Oil cup	1
2	Rollers	4 sets	5	Operational manual	1
3	Spanner 17mm	1 pc			

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Drawing



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Parts List

Ref.No.	Description	QTY	Ref.No.	Description	QTY
1	Lower sleeve	1	26	Pressure cover	1
2	Snap-gauge	1	27	Lower sleeve	1
3	Bolt M6X20	2	28	Stop plate	1
4	Bolt M8X30	1	29	Body	1
5	Nut M8	1	30	Flat key 6X80	1
6	Adjusting shaft	1	31	Lower gear	1
7	Handle	1	32	Handle	1
8	Nut M12	2	33	Knot	1
9	Handle ball M10	1	34	Nut M12	1
10	Handle	1	35	Handle bar	1
11	Handle ball M10	1	36	Screw M6X12	3
12	Bolt	2	37	Cover	1
13	Oil cup	1	38	Upper gear	1
14	Screw rod	1	39	Roller S1	1
15	Nut M16	1	40	Roller S2	1
16	Flat key 6X36	1	41	Roller S3	1
17	Upper roller shaft	1	42	Roller S4	1
18	Flat key 6X45	2	43	Optional Roller E1	1
19	Sleeve	2	44	Optional Roller E2	1
20	Pressure cover pre	1	45	Optional Roller E3	1
21	Bolt M10X30	4	46	Optional Roller E4	1
22	Shaft seat	2	47	Optional Roller E5	1
23	Star-handle M10X20	2	48	Optional Roller E6	1
24	Lower roller shaft	1	49	Optional Roller E7	1
25	Locking handle M12X32	1	50	Optional Roller E8	1

SERVICE RECORD

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Date	Maintenance performed	Repair components require

NOTES

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

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