

KAKA Industrial®

Specifications

Stock No.176001
 Dia. of Roller.....32mm(1¼")
 Round Steel Capacity.....6.5mm(¼")
 Flat Steel Capacity.....25x4mm(1x0.16")
 Handle length.....320mm(12⅝")
 Packing dimensions.....360x200x210mm
 (14.2x7.9x8.3")
 Net Weight.....6kg (13.2 lbs.)



Unpacking

The ROLL BENDER PR-3 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. 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.

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.

SAVE THESE INSTRUCTIONS

Thank you for purchasing PR-3 ROLL BENDER. 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.

SAFETY RULES

1. **Know your machine.** Read this manual carefully. Learn the machine's

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applications and limitations, as well as specific potential hazards peculiar to it.

2. Keep work area clean and well lit.

Cluttered or dark work areas invite accidents.

3. Keep Children away. All children should be kept away from the work area. Never let a child handle a tool without strict adult supervision.

4. Do not operate this tool if under the influence of alcohol or drugs. Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not attempt to operate.

5. Use safety equipment. Eye protection should be worn always when operating this machine. Use ANSI approved safety glasses. Everyday eyeglasses only have impact resistant lenses. They are NOT safety glasses. Dust mask, non-skid safety shoes, hard hat, or hearing protection should be used in appropriate conditions.

6. Wear proper apparel. Loose clothing, gloves, neckties, rings, bracelets, or other jewelry may present a potential hazard when operating this machine. Please keep all apparel clear of the machine.

7. Don't overreach. Keep proper footing

and balance always when operating this product.

8. Check for damage. Check your tool regularly. If part of the tool is damaged it should be carefully inspected to make sure that it can perform its' intended function correctly. If in doubt, the part should be repaired. Refer all servicing to a qualified technician. Consult your dealer for advice.

9. Keep your hands away from the die when you are working on it.

10. Avoid moving parts during operation. Deep fingers and hands away from moving parts.

11. Stay alert. Watch what you are doing. Use common sense. Do not operate any tool when you are tired.

12. Replacement parts and accessories. When servicing, use only identical replacement parts. Only use accessories intended for use with this tool.

13. Store idle equipment. When not in use, the tool should be stored in a dry location to inhibit rust. Store in an area out of reach of children.

14. Don't force the machine or tool. It will do the job better and more safely at the rate for which it was intended.

15. Use the right tool. Don't force a

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small tool or attachment to do the work of a larger industrial tool, Don' t use a tool for a purpose for which it was not intended.

16. **Secure work.** Use clamps or a vise to hold the work if possible. It' s safer than using your hands and it frees both hands to operate the tool.

Assembly

1. Slide the CONNECTOR (#4) onto the DRIVE SHAFT II (#11). Make sure the holes line up. See Figure 1.
2. Slide the HANDLE (#3) into the holes of the CONNECTOR and DRIVE SHAFT II.
3. Attach the CONNECTOR to the DRIVE SHAFT II using the TAPER PIN (#7).

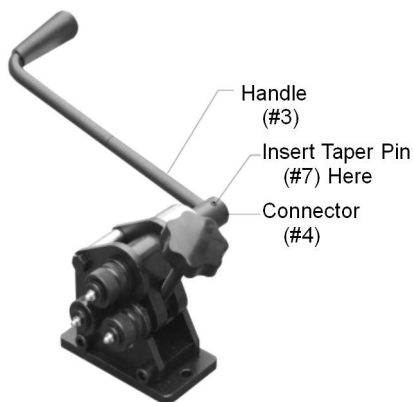


Figure 1

Mounting

Warning

The Planetary Ring Roller must be securely mounted prior to using!

1. Set the unit on the workbench at the desired location.
2. Make sure that you can operate the handle comfortably.
3. Mark the workbench through the two holes in the BASE (#32) of the unit. See Figure 2.
4. Remove the unit.
5. Drill holes through the workbench at the marked locations.
6. Mount the unit using two bolts, lock washers, washers, and nuts (in that order), sold separately.

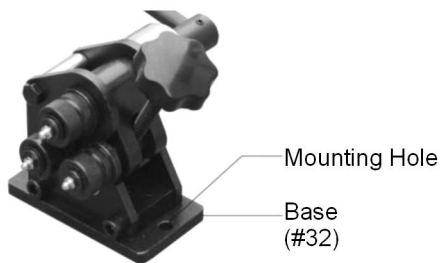


Figure 2

Operations

1. Determine the size ring you wish to obtain.

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2. Move the ADJUSTABLE WHEEL (#27) up or down (as desired) by turning the KNOB (#25). See Figure 3.
3. To obtain 1" rings, the ADJUSTABLE WHEEL must be in its uppermost position.
4. To obtain 2" rings, the ADJUSTABLE WHEEL must be in the middle position.
5. To obtain larger rings, the ADJUSTABLE WHEEL must be in the lowest position.
6. Insert the stock between the upper DRIVE WHEEL (#19) and both the ADJUSTABLE WHEEL and lower DRIVE WHEEL.
7. Turn the Knob clockwise to clamp the stock between the WHEELS.
8. Rotate the HANDLE (#3) counterclockwise to process the ring.
9. To remove completed rings, turn the KNOB counterclockwise to loosen the clamping action.

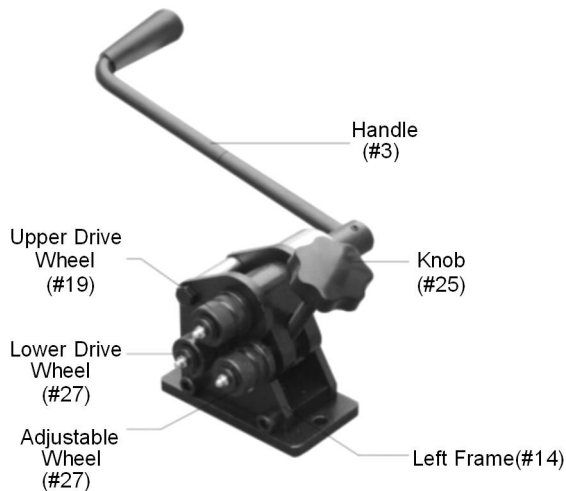


Figure 3

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Maintenance

1. After using, clean using a non-toxic solvent.
2. The three lubrication points are the DRIVE SHAFT I (#12), DRIVE SHAFT II (#11) and the ADJUSTABLE SHAFT (#18). Grease using the ZERK FITTINGS (#21). See Figure 4.

3. Store in a dry area, out of reach of children.

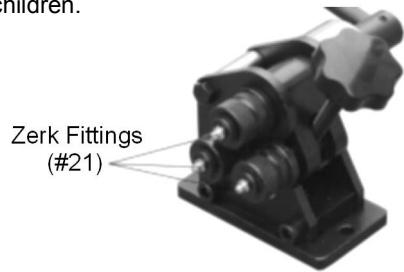


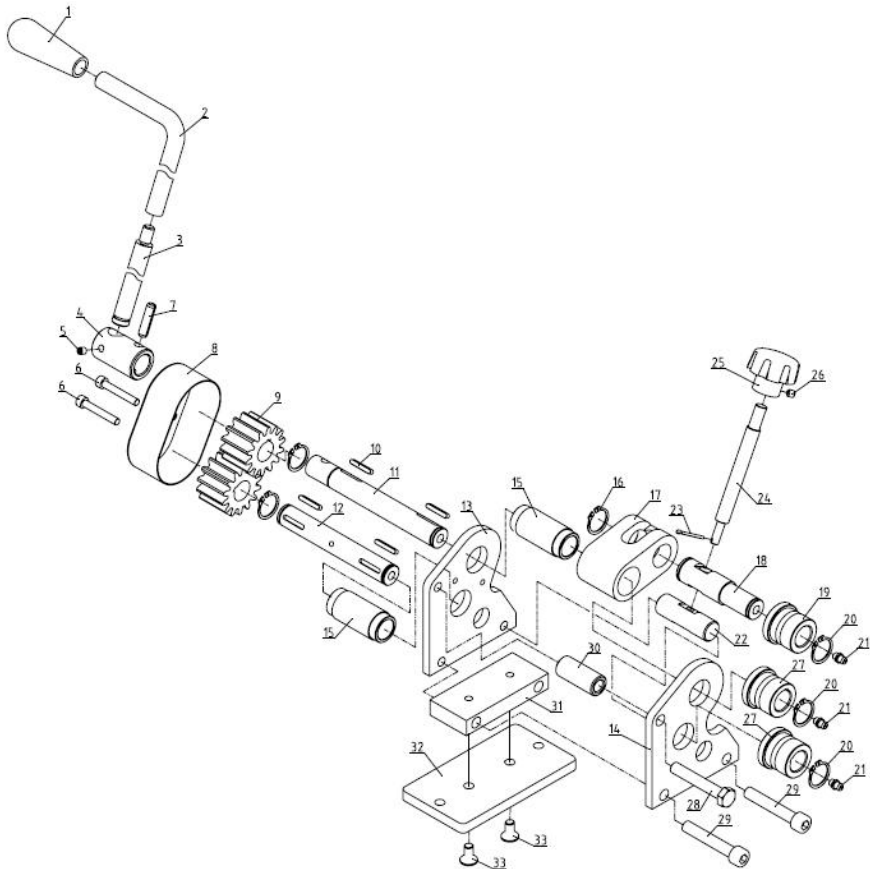
Figure 4

Parts List

| PART# | DESCRIPTION | QTY | PART# | DESCRIPTION | QTY |
|-------|-----------------------|-----|-------|--------------------|-----|
| 1 | Handle Grip | 1 | 18 | ADJUSTABLE SHAFT | 1 |
| 2 | Handle Bar | 1 | 19 | Upper Drive Wheel | 1 |
| 3 | Handle | 1 | 20 | Shaft Ring 19 | 5 |
| 4 | Connector | 1 | 21 | Zerk Fittings M8X1 | 3 |
| 5 | Bolt M6X6 | 1 | 22 | Shaft with hole | 1 |
| 6 | Bolt M6X40 | 2 | 23 | Cotter pin 2.5X18 | 1 |
| 7 | Insert Taper Pin 8x30 | 1 | 24 | Lead screw | 1 |
| 8 | Cover | 1 | 25 | Knobφ63Xφ10 | 1 |
| 9 | Gear | 2 | 26 | Bolt M6x16 | 1 |
| 10 | Flat Key 4x25 | 4 | 27 | Lower wheel | 2 |
| 11 | II Shaft | 1 | 28 | Bolt M10X60 | 1 |
| 12 | I Shaft | 1 | 29 | Screw M10X60 | 2 |
| 13 | Right Frame | 1 | 30 | Spacer sleeve | 1 |
| 14 | Left Frame | 1 | 31 | Connecting Plate | 1 |
| 15 | Bushing | 2 | 32 | Base | 1 |
| 16 | Shaft Ring 22 | 1 | 33 | Screw M8X16 | 2 |
| 17 | Supporting Body | 1 | | | |

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Drawing



NOTES

SERVICE RECORD

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| Date | Maintenance performed | Repair components require |
|------|-----------------------|---------------------------|
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Stock No: 176001
Edition 1 04/2018
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