

KAKA Industrial®

Unpacking

The Tube Roller is shipped from the manufacturer 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. Check for loose, missing, or damaged parts. Shipping damage claims must be filed with the carrier and are the responsibility of the user.

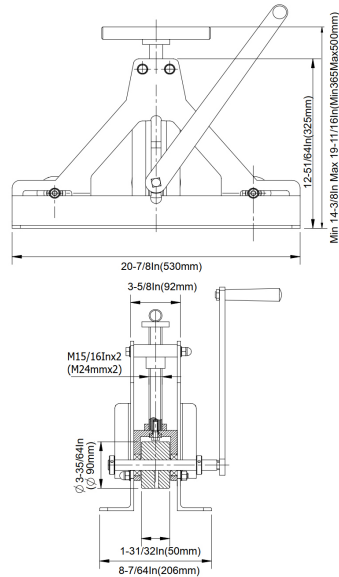
Specifications



Dia. Of Upper roller $\Phi 90\text{mm}$ / 3-1/2 In
 Thickness of Upper roller.....50mm / 2 In
 Dia. Of Lower roller..... $\Phi 40\text{mm}$ / 3-9/16 In
 Thickness of Lower roller.....78mm / 3 In
 Vertical travel of Upper roller.....150mm / 6 In
 Min. Center distance of Lower roller
 320mm / 13 In
 Max. Center distance of Lower roller.....
480mm / 19 In
 Overall dimension..... 20-3/4"x9-3/4"x29-1/2"
 Weight..... 43 lbs

Important:

The tube roller is coated with a protectant. To ensure proper fit and operation, remove coating. Coating is easily removed with mild solvents, such as mineral spirits, and 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.



Can process material of mild steel, cuprum, aluminum, etc.

Appearance of the machine

Max. capacity	Material	20mmx20mmx1.2mm	25mmx25mmx1.2mm	30mmx30mmx1.5mm	40mmx40mmx1.5mm
		Mild steel	3/4"x3/4"x3/64"	1"x1"x3/64"	1-1/4"x1-1/4"x1/16"
Copper		20x20x1.5	25x25x1.5	30x30x1.75	40x40x1.75
		3/4"x3/4"x1/16"	1"x1"x1/16"	1-1/4"x1-1/4"x9/128"	1-1/2"x1-1/2"x9/128"
Aluminum		20mmx20mmx1.75mm	25mmx25mmx1.75mm	30mmx30mmx2mm	40mmx40mmx1.75mm
		3/4"x3/4"x9/128"	1"x1"x9/128"	1-1/4"x1-1/4"x5/64"	1-1/2"x1-1/2"x5/64"
Min. R		180mm	170mm	200mm	220mm
		7-3/32"	6-45/64"	7-7/8"	8-43/64"
Min. Ø		450mm	500mm	550mm	600mm
		17-23/32"	19-11/16"	21-21/32"	23-5/8"

Model TR-40

▲ WARNING

The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions 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 used by the operator.

SAVE THESE INSTRUCTIONS

Thank you for purchasing TR-40 Tube Roller 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

▲ WARNING

For your own safety, read all of the instructions and precautions before operating tool.

▲ 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.

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 cover 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.

Assembly

The Tube Roller must be securely mounted to a solid surface before using, the size of the mounting hole is 11 mm.

Operating the tool for certain operations will

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require exerting considerable force on the handle, thus it is essential that the tool be mounted to a heavy or immovable work bench or other work surface. Be certain there will be adequate clearance for the entire range of motion of the handle with no potential pinch points for the operator's hands.

▲ WARNING

Before drilling the mounting holes, make sure that there is no electrical conduit or water pipes.

Operation

1. Insert the square tube into lower rollers, loosen screw (#18), adjust the distance among stop collars(#21), fix screw(#18).
2. Rotate lifter rod (#12) to make upper roller(#24) move down onto the square tube, rotate crank(#3) through handle(#1), the square tube moving among bracket(#15).
3. Continue to rotating lifter rod (#12) and turning crank(#3), bending the square tube to predetermined circular arc. If the square tube bends in a full circle, you should remove upper axle(#29) and bolt(#13) first, then take upper wheel set out, finally remove the material.
4. The distance between two lower wheel set is different, the minimum bending circle will also be different. The smaller the distance the smaller the bending circle.

▲ WARNING

Do not roll a stock thicker than the roller's capacity.
You will damage the bender. Measure the thickness before use.

▲ CAUTION

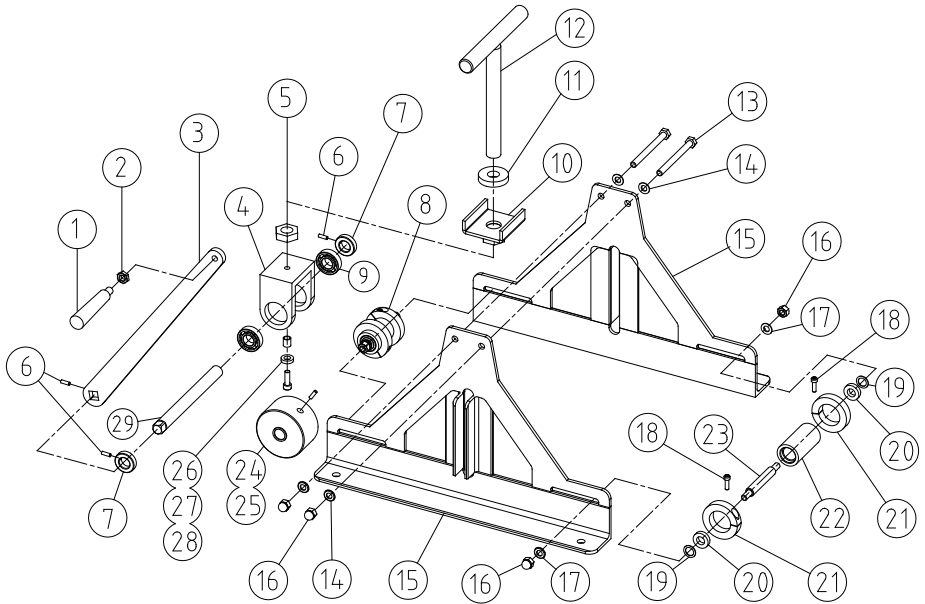
The Center distance of two Lower rollers can be adjusted as required.

Maintenance

1. Maintain your tools. It is recommended that the general condition of any tool be examined before it is used. Keep your tools in good condition by adopting a program of conscientious repair and maintenance in accordance with the recommended procedures found in this manual.
2. Keep tool clean for safest operation. Only use soap and a damp cloth to clean your tools. Many household cleaners are harmful to plastics and other insulation. Never let liquid get inside a tool.
3. Spread some oil on the dies and roller before bending material to make the operation smoother.
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.
6. Any damaged part should be properly repaired or replaced. Do not perform makeshift repairs.

Model TR-40

DRAWING



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PARTS LIST

Ref. Nr.	Description	Qty	Ref. Nr.	Description	Qty
1	Turning handle M12	1	16	Locknut M10	4
2	Thin nut M12	1	17	Lock washer 10	4
3	Crank	1	18	Screw M6X20	4
4	Upper wheel carrier	1	19	Washer	4
5	Thin nut M24x2	1	20	Bearing 61902	4
6	Screw M6X12	3	21	Outer stop collar	4
7	Locating sleeve	2	22	Low roller	2
8	Lower parts	1	23	Low axle	2
9	Bearing 6004	2	24	Upper roller	1
10	U Bracket	1	25	Screw M8X20	1
11	Upper stop collar	1	26	Space bush	1
12	Lifter	1	27	Bearing 608	1
13	Bolt M10X110	2	28	Bolt 8X30M	1
14	Washer 10	4	29	Upper axle	1
15	Bracket	2			

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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