

# KAKA Industrial®

## Unpacking

The Tube Roller is shipped from the manufacturer in a carefully packed ply-wood case. Thoroughly inspect the product upon opening the package.

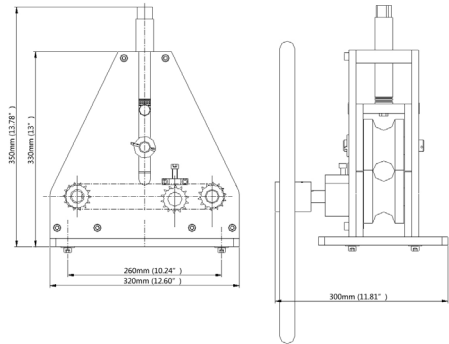
Thoroughly inspect the product upon opening the package. After unpacking the unit, carefully inspect for any damage that may have occurred during transit. Check for loose, missing, or damaged parts. Immediately report missing parts to dealer.

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

## 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.

## Specifications



Size	Profile Type	Spec	Min.Φ	Notes
1"		Φ 25.4mm	330mm	Wall thickness < 2 mm Less feeding amount to make sure the roundness of tube
1½"		Φ 38.1mm	350mm	
1⅝"		Φ 41.3mm	360mm	
1¾"		Φ 44.5mm	360mm	
2"		Φ 50.8mm	370mm	
1½"		12.7mm	340mm	
¾"		19.0mm	340mm	
1"		25.4mm	350mm	

Appearance of the machine

### ▲WARNING

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

### ▲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.

## SAVE THESE INSTRUCTIONS

Thank you for purchasing TR-50 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

# Model TR-50

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.

1 $\frac{1}{4}$ " Square Tube Rolls	191007-304
1 $\frac{1}{2}$ " Square Tube Rolls	191007-305
1 $\frac{3}{4}$ " Square Tube Rolls	191007-306
2" Square Tube Rolls	191007-307

## Optional Rollers :

----- Size ----- Item No.-----

### 1. Round Tube Rollers Sizes

1 $\frac{1}{2}$ " Round Tube Rollers	191007-101
5 $\frac{5}{8}$ " Round Tube Rollers	191007-102
3 $\frac{3}{4}$ " Round Tube Rolls	191007-103
7 $\frac{7}{8}$ " Round Tube Rolls	191007-104
1" Round Tube Rolls	191007-105
1 $\frac{1}{8}$ " Round Tube Rolls	191007-106
1 $\frac{1}{4}$ " Round Tube Rolls	191007-107
1 $\frac{3}{8}$ " Round Tube Rolls	191007-108
1 $\frac{1}{2}$ " Round Tube Rolls	191007-109
1 $\frac{5}{8}$ " Round Tube Rolls	191007-110
1 $\frac{3}{4}$ " Round Tube Rolls	191007-111
2" Round Tube Rolls	191007-112

### 2. Round Pipe Rollers Sizes

1 $\frac{1}{4}$ " Pipe (0.54"OD) Rolls	191007-201
3 $\frac{3}{8}$ " Pipe (0.675"OD) Rolls	191007-202
1 $\frac{1}{2}$ " Pipe (0.84"OD) Rolls	191007-203
3 $\frac{3}{4}$ " Pipe (1.05"OD) Rolls	191007-204
1" Pipe (1.315"OD) Rolls	191007-205
1 $\frac{1}{4}$ " Pipe (1.66"OD) Rolls	191007-206
1 $\frac{1}{2}$ " Pipe (1.90"OD) Rolls	191007-207

### 3. Square Tube Roll Sizes

1 $\frac{1}{2}$ " Square Tube Rolls	191007-301
3 $\frac{3}{4}$ " Square Tube Rolls	191007-302
1" Square Tube Rolls	191007-303

### 4. Misc. Roll Sizes

1 $\frac{1}{2}$ " Rectangular Tube Rolls	191007-401
1 $\frac{1}{4}$ " Flat Stock Rolls	191007-402
1x2" C Channel Rolls	191007-403

## 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.

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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 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. The chain can be tightened or loosened by adjusting the screw #31.
2. Loosening handle #7 to adjust the height of stand.
3. When the roller need to be changed, please screw off #11, #9, take off the cotter pin #37, and washer #36, and remove the back frame #12, then the lower roller #16 can be changed; the upper roller #38 can be changed by taking off pin#39.
4. Turning Screw Rod #43 to adjust feeding amount according to different wall thickness of tube. Thinner tube and less feeding amount, or else the tube section will be deformed.
5. The bearing should be lubricated frequently to increase it's life length.

### ▲ CAUTION

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

### ▲ WARNING

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

## 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.

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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.

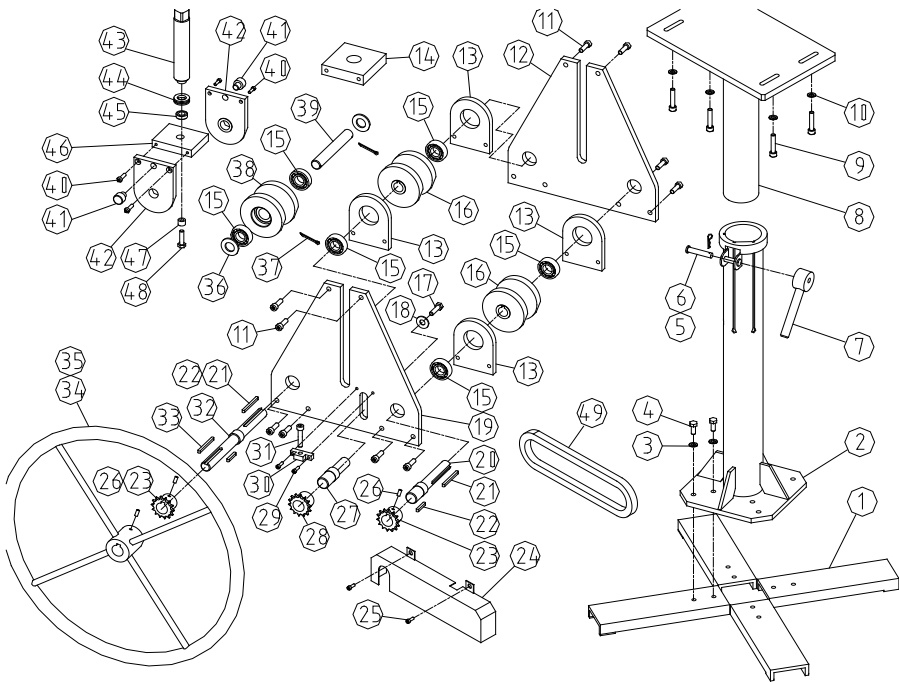
4. Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended

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.

## DRAWING



Notes: Stand in the drawing is optional.

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## PARTS LIST

Ref. Nr.	Description	Qty.	Ref. Nr.	Description	Qty.
1	Stand Base (Optional)	4	26	Screw M6X8	2
2	Lower Stand (Optional)	1	27	Tension Shaft	1
3	Washer 8 (Optional)	8	28	Chain Wheel	1
4	Screw M8X30 (Optional)	8	29	Screw M6X20	2
5	Cotter Pin 3.2x20 (Optional)	1	30	Fixed Block	1
6	Pin (Optional)	1	31	Screw M8X50	1
7	Handle (Optional)	1	32	Long Axis for Lower Roller	1
8	Upper Stand (Optional)	1	33	Flat Key 6X50	1
9	Screw M8X40 (Optional)	4	34	Turning Wheel	1
10	Washer 8 (Optional)	4	35	Screw M6X16	1
11	Screw M8X25	12	36	Washer 20	2
12	Back Frame	1	37	Cotter Pin 4x32	2
13	Lower Roller Wall	4	38	Upper Wheel	1
14	Upper Block	1	39	Axis for Upper Roller	1
15	Bearing 6004	6	40	Screw M6X16	4
16	Lower Roller	2	41	Pin	1
17	Screw M8X16	1	42	Vertical Plate	2
18	Washer	1	43	Screw Rod	1
19	Front Frame	1	44	Bearing 51103	1
20	Short Axis for Lower Roller	1	45	Lining	1
21	Flat Key 6X50	2	46	Horizontal Plate	1
22	Flat Key 6X30	2	47	Bearing 608	1
23	Chain Wheel	2	48	Screw M8X30	1
24	Safe Cover	1	49	Chain	1
25	Screw M8X12	2			

**SERVICE RECORD**

KAKA Industrial ®

Date	Maintenance performed	Repair components require



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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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