

# KAKA Industrial®

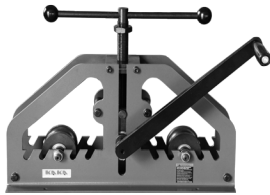
## Unpacking







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.

## Specifications



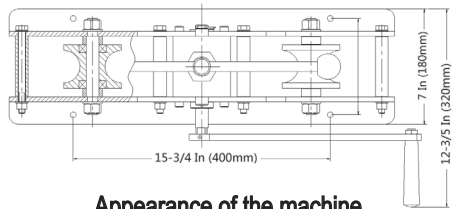
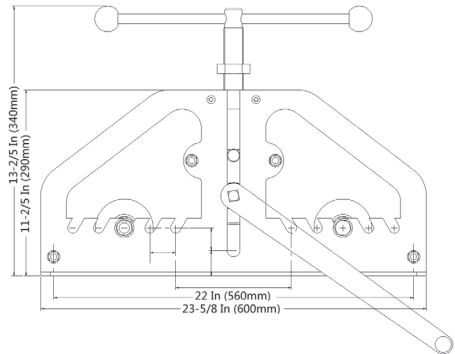
Material	Size	Minimum Radius
Flats 	1 1/4"	10"
C Channel 	1X2"	60"
Pipe Tube 	1 1/2"	20"
Round Tube 	1/4 To 2"	ACCORDING TO MATERIAL
Square Tube 	2"	70"
Rect. Tube 	1X2"	60"

### ▲ 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.

## 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.



Appearance of the machine

### ▲ WARNING

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

## SAVE THESE INSTRUCTIONS

Thank you for purchasing TR-60 Tube Roller machine. Before attempting to operate your

# Model TR-60

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.

## Optional Rollers :

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

### 1. Round Tube Rollers Sizes

1/2" Round Tube Rollers	191009-101
5/8" Round Tube Rollers	191009-102
3/4" Round Tube Rolls	191009-103
7/8" Round Tube Rolls	191009-104
1" Round Tube Rolls	191009-105
1 1/8" Round Tube Rolls	191009-106
1 1/4" Round Tube Rolls	191009-107
1 3/8" Round Tube Rolls	191009-108
1 1/2" Round Tube Rolls	191009-109
1 5/8" Round Tube Rolls	191009-110
1 3/4" Round Tube Rolls	191009-111
2" Round Tube Rolls	191009-112

### 2. Round Pipe Rollers Sizes

1/4" Pipe (0.54"OD) Rolls	191009-201
3/8" Pipe (0.675"OD) Rolls	191009-202
1/2" Pipe (0.84"OD) Rolls	191009-203
3/4" Pipe (1.05"OD) Rolls	191009-204
1" Pipe (1.315"OD) Rolls	191009-205
1 1/4" Pipe (1.66"OD) Rolls	191009-206
1 1/2" Pipe (1.90"OD) Rolls	191009-207

### 3. Square Tube Roll Sizes

1/2" Square Tube Rolls	191009-301
3/4" Square Tube Rolls	191009-302
1" Square Tube Rolls	191009-303
1 1/4" Square Tube Rolls	191009-304
1 1/2" Square Tube Rolls	191009-305
1 3/4" Square Tube Rolls	191009-306
2" Square Tube Rolls	191009-307

### 4. Misc. Roll Sizes

1/2" Rectangular Tube Rolls	191009-401
1 1/4" Flat Stock Rolls	191009-402
1x2" C Channel Rolls	191009-403

## 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.

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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 9mm.

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. Insert desired set of lower roller wheels (#35) into slot of frame (#6) and set symmetrically.
2. Turn rotary rod (#12) raising the upper roller to sufficient height to clear workpiece.
3. Place workpiece into roller.
4. Turn the #12 rotary rod to lower the upper roller to desired position. Turn crank #26 to make repeated passes through the roller, until desired curve is achieved.

### ▲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.

## Changing Roller

1. Loosen nut #4, remove washer #3 and #31 spacer bushing, remove the #32 lower rollers. Change to desired roller set and reinstall.
2. Loosen screws #5 and remove upper roller wheel assembly.  
Remove pin #23 and upper roller axle #24 from assembly, replace with desired roller and reinstall in machine.

## Maintenance

1. Maintain your tools. It is recommended

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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

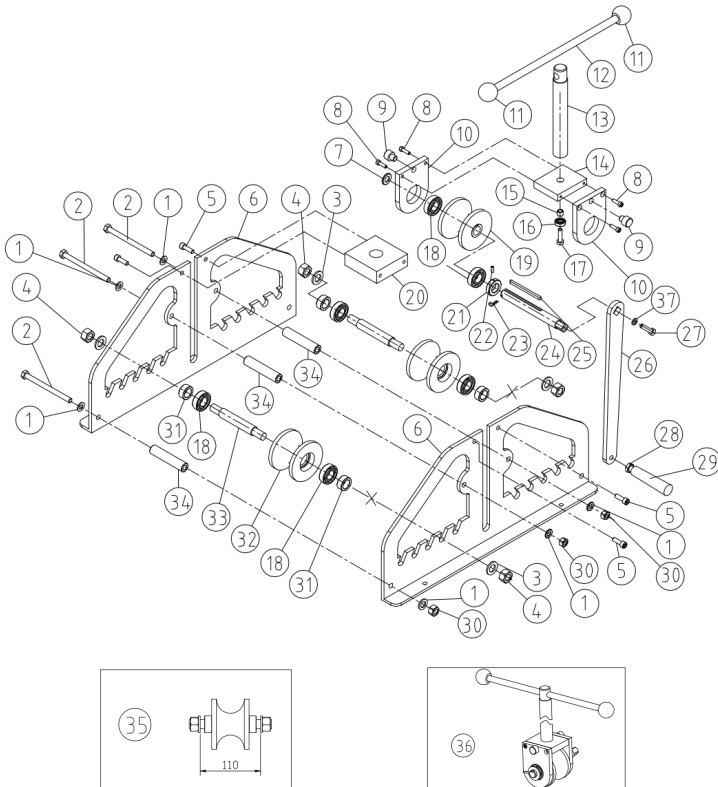
smoother.

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.

## DRAWING



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## PARTS LIST

Part No.	Description	Part No.	Description
1	Washer	19	Upper Roller
2	Bolt	20	Carrier Plate
3	Washer	21	Locating Sleeve
4	Nut	22	Screw
5	Screw	23	Pin
6	Frame	24	Upper Roller Axle
7	Washer	25	Key
8	Screw	26	Crank
9	Guide shaft	27	Screw
10	Upright frame	28	Handle
11	Handle Ball	29	Thin Nut
12	Rotary Rod	30	Nut
13	Lead Screw	31	Spacer Bush
14	Transverse Plate	32	Lower Roller
15	Sleeve	33	Lower Roller Axle
16	Bearing	34	Spacer Bush
17	Bolt	35	Lower Roller Wheel Set
18	Bearing	36	Upper Roller Wheel set

## PACKING LIST

No.	Specification	Description	Qty.	Mark
1	TR-60	Tube Roller	1	
Accessories & Tools				
2	24mm	Spanner	1	
3	6mm	Hexagon spanner	1	





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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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