COMBINATION OF SHEAR, BRAKE AND ROLL

DIRECTIONS FOR USE

3 IN 1/305	3 IN 1/610
3 IN 1/760	3 IN 1/1016
3 IN 1/1067	3 IN 1/1320

1.USES

This machine is used for shearing and braking low carbon plate (mild steel) or the other metal materials which have the same intensity as the low carbon plate. but their maximum thickness is 1 mm.. It can also be used for rolling the low carbon plate(mild steel) or the other metal materials which has the same intensity as the low canbon plate,its maximum thickness is 1 mm.

2.USES AND MALNTENANCE

2.1 Before using this Kind of machine tool you must read this direction, in order to have an intimate knowledge of structre of the machine tool,and also function of the handle,drive andlubrication systems.

2.2 According to the different using conditions, this kind ofmachine tool must be fixed on the ground or special machine seat,in order to avoid slide of the machine tool.

2.3 Please firmly execute the following operating rules:

2.3.1 Before packing this machine tool, antirusting agents are put on it,so when you are getting rid of the kind of rust inhibitor,you can unset the yellow coat with varnish diluent and paint flux for machine oil.

2.3.2 Place near the machine be kept chean,and materials whichavoid slide can be used in this area.

2.3.3 When you move,install,clean and adjust the machine tool. you must keep away from the shears.

2.3.4 Put dowm the protecting cover when you don't use thesliding roll of the roll machine.

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

2.3.6 Operators must be familiar with the structre and function of this machine tool. Proctecting mask and theother safety devics should be used when work on it.

2.3.7 Focus your attention on the machine and operate when someone are near by the machine.

2.3.8 Any metal plate that thick ness and quality goes beyong the seope that machine demands should be refused to process.

2.4 Generally the operating handle was installed on the right sideof the machine tool (Left is also acceptable).

2.5 Back-measure plate(Angle iron).

Back-measure plate is used for shearing and braking.When it's in the place of braking condition .please screw two long barsinto the nut of concave mould plate. ensure that the bars pass through the front part of the concave mould plate , tighten up the nut and then back-measure plate and concave mould plate can move mould plate can move up and down in company.

When it is in the place of shearing condition,before putting the bars into the positioning plate,screw a 2-M12 nut intothe positioning plate, and then followed the bar which was fixed by the nut in the end.

In these two kinds of position,the circular adjustable knob was installed at the back of angle iron.

2.6 Adjustment of the braking installation

2.6.1 Adjustment of the upper die:

Loosen the screw bolt, the upper die will come off the machine.If you don't want the upper die will come off the machine or you wilking to install another new mould plate,you can put a piece of hard wood (25. 25. 160mm) or the other similar matherials on the concave mould plate.turn the handle and raise the concave mould plate until the wooden piece getting in touch with the upper die (formplunger).

After putting up the new die, all the fasten bolts of the die should be tightened up. In some cases, especially the using of narrow die it is necessary to put a piece thin paper between the upper die and the lower die.

2.6.2 Adjustement of the cross girder

To make the braking work go on smoothly,and to seperate the formed metal that between the upper die and the lower die form being blocked. you must adjust the crossbeam.

First, you put a steel plate (its width echo the demand of themachine and its thicknees is 1 mm) on the concave mould plate,then turn the handle carefully to raise concave mould plate. Loosen the fasten bolt of the crossbeam when the upper die(formplunger) getting in touch with the processing metal plate,after that,in order to fix the crossbeam. You can adjust the screw which on the crossbeam. at last,tighten up all the fasten screws.During this period. the handle is not fixed to turn an angle of 360 degrees. brake a piece of metal plate that with game width and thickness on both side of the braking system,their angles should be simiar,the job should be excessively braked when you turn the handle and fully brake the job.

2.7 Adjustment of the shearing installation

You should adjust the zero-clearance of the upper cutter and the lower cutter.

Adjustment of the lower cutter:

Unload the pressing plate, loosen the fasten screw and the twoadjustable screws of the working table, turn the handle make theupper cutter near the cutter on the working table, tighten the fasten table rom moving bake when the machine is used. Install the pressing plate once again and ensure that it run paralled to the upper cutter.

Adjustment of the positioning plate:

During the period of the shearing,there will be a powerful strengdth prcduced at the middle of the cutter,in order to avoid the clearance that between the upper and lower cutter,you should adjust the ceatral screw that behind the positioning plate.If the adjustment was not suitable. the metal plate will be foldedin the middle of the two cutters when shearing is executed

If the lower cutter and upper cutter still press close together after the adjustment,two parts must be examined: First, the fasten screw of the lower cutter, you can fully tighten the cutter up,then lossen the screw about 1/8 cirle.Second,the contact face of the an cover mould plate and the positioning plate.In most,cases this contact face and lubricate.

2.8 Adjustment of the rolling installation

This rolling installation can roll straight, roll taper or metal ring with the help of the liner channel roller.

When a job was finished, turn the pin to right,the left side of the roller can be taken off the machine ,the job will be taken out with ease.

When you operate the slide roller,you must give enough pressure to roller for the purpose of suitable import of the job.

Adjust the cleance of the upper roller have the same learance.

2.9 When you finished your work,you must clean the machine and spread oil on the surface that not be applied a coat of paint.

3.CHIEF TECHNICAL SPECIFICATIONS

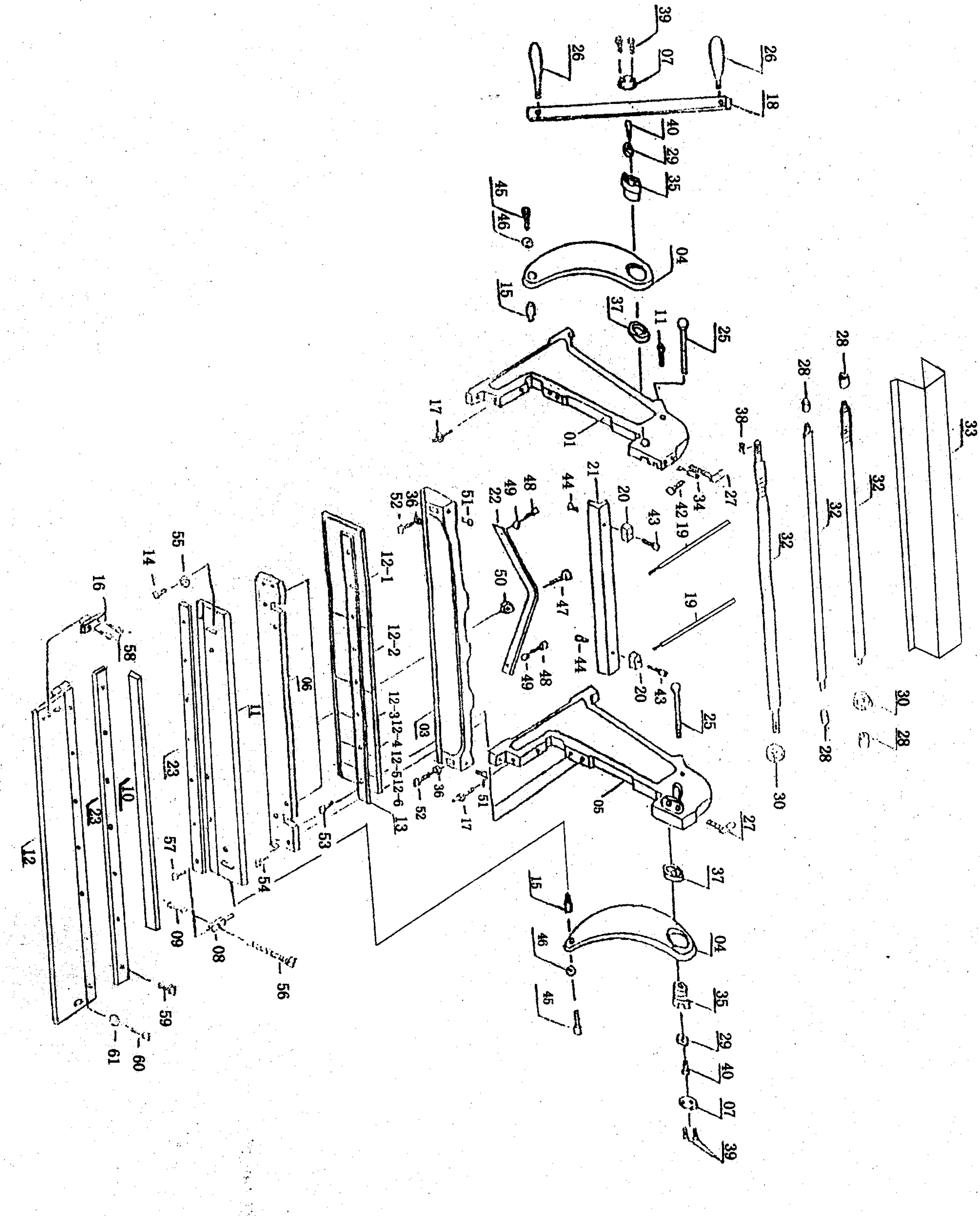
Capacity(mm)	Model					
	12″	24″	30″	40″	42″	52″
Bed width （mm）	305	610	760	1016	1067	1320
Max.Shearing Thickness （mm） low carbon plate	1	1	1	1	1	1
Max.Bending Thickness （mm） low carbon plate	1	1	1	1	1	1
Max.Rolling Thickness （mm） low carbon plate	1	1	1	1	1	1
Min.Rolling Dia(mm)	Φ39	Φ39	Φ39	Φ43	Φ43	Φ43
MEAS （L × W × H） （cm）	48×32 ×42	82×44 ×65	98×44 ×67	128 × 44×67	138 × 56×74	162 × 58×74
N.W. （kg）	45	105	120	200	268	330

4. LUBRICATION OF THE MACHINE TOOL

Oilling the machine oil into eccentric mechanism and clearance once for a day.

5.ACCESSORIES OF THE MACHINE TOOL

Allen keys (5mm,12mm,two kinds in all)with every set of machine tool.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PACKING LIST

ordinal number	contents	quantity
1	3 in l combinayicn of shear,brake and roll	1 set
2	5mm Allen key	1 piece
3	12mm Allen key	1 piece

Inspecter

Date

NUMBER OF DESRGNATION FIGUE

01. Left wall
02. workbench
03. Crossbeam
04. Crankarm
05. Right wall
06. Bear farme
07. Cover
08. Bear fname
09. Spring
10. pressing plate
11. Moving cutter plate
12. Ipper braking die
13. Pressing plate
14. Bolt
15. Cranking arm rolling wheel
16. Positioner
17. Adjustable bolt
18. Handle
19. Screw
20. Positioning piece
21. Positioning plate
22. Supporting Plate
23. Cutter
24. Back pressing roll
25. Screw
26. Handle jacket
27. Adjustable bolt
28. Jacket
29. Press cover

30. Gear
31. Lowerpressing roll
32. Upper pressing roll
33. Protecting cover
34. Rotation shaft
35. Eccentric shaft
36. Gasket(Washer)
37. Jacket
38. Flat key
39. Hexagon heard bolts
40. Hexagon socket cap head screws
41. Hexagon head cap bolts
42. Hexagon scoket cap head sctews
43. Hexagon head bolts
44. Hexagon head bolts
45. Hexagon socket cap head screws
46. Gasket(Washer)
47. Hexagon head bolts
48. Hexagon head bolts
49. Gasket(Washer)
50. Hexagon nuts
51. Hexagon head bolts
52. Hexagon screws
53. Hexagon screws
54. Hexagon screws
55. Gasket(Washer)
56. Hexagon head bolts
57. Hesagon screws
58. Hesagon screws
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61. Gasket(Washer)