

Instruction Manual

ELECTRIC REBAR BENDERS

& REBAR CUTTERS

MODEL: RB-25 RB-32

RBC-25 RBC-32



CE



WARNING

Please read the operation manual carefully before operate the machine and keep it for the reading in future

1. Safety

1. 1 SAFETY RULES

1. 1. 1.GENERAL SAFETY RULES



WARNING

Do not attempt to operate until you have read thoroughly and understand completely all instructions, rules, etc. contained in this manual. Failure to comply can result in accidents involving fire, electric shock, or serious

personal injury. Keep owners manual and review frequently for continuous safe operation.

1. KNOW YOUR MACHINE.

For your own safety, read the owner's manual carefully. Learn its application and limitations as well as specific potential hazards pertinent to this machine.

2. KEEP WORK AREA CLEAN.

Disorder area and working table will cause accident.

3. DO NOT USE IN DANGEROUS ENVIRONMENTS.

Do not use power tools in damp or wet locations, or expose them to rain. Keeps work area well illuminated.

4. KEEP NON-PROFESSIONAL PEOPLE AWAY.

All visitors should be kept at a safe distance from work area.

5. USE THE SUITABLE TOOLS, DO NOT FORCE THE MACHINE.

It will do the job better and be safer at the rate for which it was designed.

6. WEAR PROPER APPAREL.

Avoid loose clothing, gloves ,neckties, rings, bracelets, or jewelry, which could be caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

7. THE MACHINE SETTING

Bender should be on flat and steady ground before starting.

Any shaking may cause imprecise work.To avoid the safety accident, please make sure the machine is not shaking before working.

8. OPERATION IS OFF, MAINTAIN THE MACHINE

Keep the machine clean and safe. After operation, clean and remove dust and scrap iron in the main gear and body

9. USE RECOMMENDED ACCESSORIES.

Before the service, replaces the fitting, or perhaps the assembly and assembles the motor, must cut-off machine's power source from the power source place (the note: Carries on the operation by the specialists).

10.POWER SUPPLY

①.The power source ,please connect with the single-phase 110V or 220V (see the parameter in the machine) power source to uses

②.when connects to the power source RB-25 and RBC-25 must use 3.5 ~ 5.5sq (cv) the power line, RB-32 and RBC-32 must use 4 ~ 6.5sq (cv) the power line. The power line is must maintain can below 30~40m to assure operation normally

※ Reference-----in situation of use extend line

This product is set in the situation of far distance from the power to use the extend line to connect, according to the thickness of line and the different of current capacity , so must use the above provisions. Extension line. Use line is too long or too thin will make the loss of electric current and overload of the voltage, lead to edge of the wiring insulation rapid turn heat,then insulating ability to reduce ,finally to leak electric poaer or fire.besides will weaken the motor output force, internal electrical circuit easy to failure .

to began using the Line from the power line connect point must suit to the provisions of the above extension line, also do not mean operation near the electric power supply is good, in situation of long distance operation,please refer to the table to using appropriate degree of power line according to distance.

(wire) max. length	RB-25 / RBC-25	RB-32 / RBC-32
	Diameter of wire / wire size	Diameter of wire/ wire size
15m	2.0sq X 3C	3.5sq X 3C
25m	3.5sq X 3C	4.5sq X 3C
40m	5.5sq X 3C	6.5sq X 3C

1.1.2 Additional safety rules

- ①. When the machine is running, don't clean or remove scraps
- ②. Do not remove or modify the warning signs even not replace or any may cause confusion of marks.
- ③. Carefully reading the manual before operating the machine.
- ④. The machine on ground correctly, to avoid hazard shock.
- ⑤. Not away till the machine is off.
- ⑥. Before replace the module the machine should stop completely .
- ⑦. before starting, confirm. determine the correct, bending Angle.
- ⑧. Do not to put any tools on platform before starting work, to avoid accidents .
- ⑨. Use appropriate tools to adjust machine.

1.2. Warning signs:

This machine has warning symbols attached on it as shown below to ensure proper and safe operation.

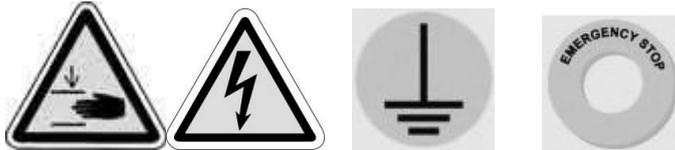
These symbols are used on the machine to indicate points or instance of specific danger to operating personnel.

Do not remove safety symbols from the machine.

The safety have two grade that are ⚠ Danger and ⚠ Attention in this manual:

⚠ Dangerous—Means the dangerous by the wrong operating and lead death and GBH.

Attention — Means the dangerous by the wrong operating and lead the hard damage of common or venial harm. Attention can help the user to know the result of ignore the warning and recognize the dangerous and avoid the dangerous.



1. Avoid the damage

⚠ Danger

Don't put your hand or head inside the guard fence, if not will harm yourself.
 Don't touch the button with wet hand, if not will get the electric shock.
 Every work include the installation, test and inspection & maintenance need to be done by the professional technician.

2. Transit and Installation

⚠ Attention

Please use the proper rise and fall tools to transit the equipment when transit the equipment to avoid the damage and accident.
 Flow the operation manual to install the equipment.
 Check and confirm the installation place and the position of the slitting rewinder.
 Don't let the machine get the violent strike or hit when transit the machine.
 Don't lift or hang the motor when transit as by this will damage the motor.
 Don't test the machine if there is lack of or damage any electric element.

3. Setting Line

⚠ Danger

Don't connect the chief power supply to the fan-out of creepage protection button.
 Please cut off the power supply and confirm by checking when setting the line or inspect.
 Setting the line after installation, if not will lead accident.
 Don't press or clamp the cable, not damage or refute arbitrarily, either. Unless will lead the electric shock.

4. Attempt Running

⚠ Attention

Check the whole machine and confirm the suddenly start-up can not damage the equipment.
 Adjust the three phase relatives between the control tank and each motors to confirm the turning position of each motor is right.

5. Operation

⚠ Attention

Don't touch the running part of the slitting folder by your hand in the period of early testing to avoid the hurt.

Don't do any modification for the equipment unless have the technician's help from BS. If not BS will not bear any duty of the result.

6. Other Attention Item

⚠ Attention

The completely inspection and attempt running are needed before using after leave unused for a long time.

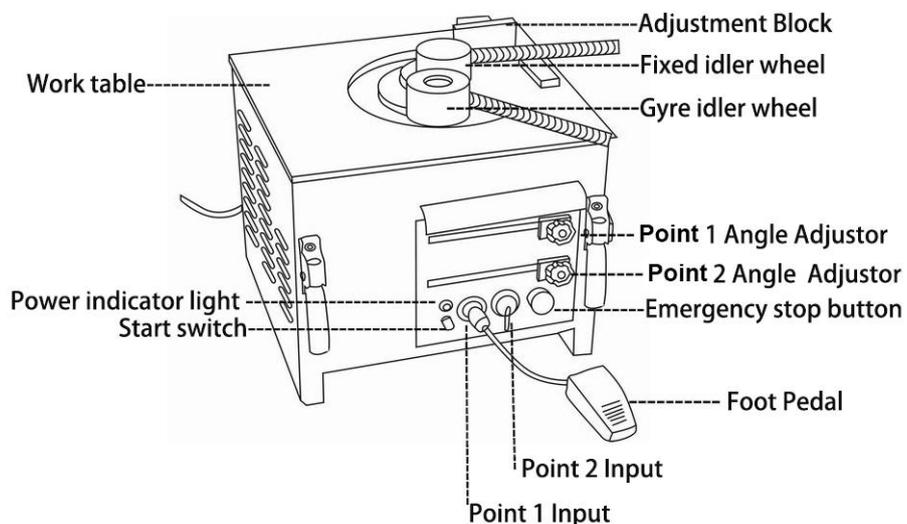
It is not allowed to operating or maintain the machine when the operator is not clear-headed by drink or tired.

Please use the spare parts from BS for the maintenance and part change. BS will not guarantee to keep it in good repair if the customer damage the machine by using the spare parts from other company

Main Parameters

Model	RB-25	RBC-25	RB-32	RBC-32
Voltage \pm 5%	110V/230V AC only	110V/230V AC only	110V/230V AC only	110V/230V AC only
Wattage	1700W/1600W	1700W/1600W	2800W/3000W	2800W/3000W
Net weight	91 KGS	136 KGS	175 KGS	225 KGS
Cutting speed	5-6 s	5-6 s	6-7 s	6-7 s
Max rebar diameter	ϕ 25mm	ϕ 25mm	ϕ 32mm	ϕ 32mm
Min rebar diameter	ϕ 6mm	ϕ 6mm	ϕ 6mm	ϕ 6mm
Machine size	450*500*440mm	500*450*790mm	600*580*470mm	600*580*980mm

Rebar bender Parts



2.Means of operation

2.1 Using methods

① When the power line connection to the 110V/220V power source and the power indicator light shone on namely mean of the machine operation preparation finishes may go on the normal work.

② The fixed idler wheel, the move idler wheel and the steel bar adjustment block's spacing needs to make the corresponding adjustment according to the specification of the steel bar.

③ The foot switch connection to point1,2 will make more convenient to go on work .

Point 1, connect to work - angle set by is point 1, press the START switch or point1 foot pedal switch control to operation.

Point 2,connect to work, The angle setby is point 2, through the foot switch control operation, this time the point1 angle set by handle must establish with point 2 in the same level angle or is bigger than the point 1 angle . while also after the angle handle setting must fix well the handle nut or when the machine operation will become loose.

④ Adjust the angle that you need by through move Left or right, after angle adjustment is set accurately, assure that angle setting handle is fixed .

⑤The operator must stand outside of the rebar bender operation's direction.

⑥ when press the starting switch or the foot switch will bend the rebar to the angle which you have set

⑦ when you find some abnormal during the operation you must press down emergency stopped to closes down the machine'operation.

⑧sure to remember, when bending processing, the angle of point 1 must be bigger than point 2, otherwise the machine cannot the normal operation. (This is for RB-25 AND RBC-25 , RB-32 AND RBC-32 is no problem .)

⑨ under situation of use foot switch beyond control machine'operation when please through press nearby power light's hand switch test machine whether to revolve judges the foot switch whether to present the breakdown.

Note: ① when press the emergency switch to run the machine,the move idler wheel will reture to its position.

② under the work situation of point 2 bending, the point 1 handle'position must be keep the same level angle with point 2 or to set smaller in the angle 5 degrees than the point 1 and then fix the angle handle, so that not to occure the electricial or the machine misoperation.

※Matching of different wheel (RB-25 / RBC-25) :

Rebar specification	Fixed idler wheel	Gyre idler wheel	Contemporary bending capacity
Ø22- Ø25	Ø78	Ø94	1 pcs
Ø16- Ø20	Ø78	Ø94	1-2 pcs
Ø10- Ø13	Ø78	Ø94	4-5 pcs
Ø6- Ø13	module	Ø94	3-6 pcs
Special situation	Possible customize	Possible customize	

※Matching of different wheel (RB-32 RBC-32) :

Rebar specification	Fixed idler wheel	Gyre idler wheel	Contemporary bending capacity
Ø10- Ø13	module	Ø148	5-6 pcs
Ø16- Ø22	Ø78	Ø148	2-3 pcs
Ø25- Ø32	Ø109	Ø99	1 pcs

2.2.Attention items

- ① Must according to Contemporary bending capacity to use this products, surpasses easily to cause this product breakdown.
- ② when go on steel bar bending work, special attention to avoid injure the finger and so on safety incident.
- ③ according to the different hardness of reinforced material ,special attention should be paid to avoid the fragcture which may lead to safety incidents such as wounding.
- ④.please do not operate untill you confirm no person and object in the reinforced bending radius.
- ⑤.the product is electric functional machinery.as encountered by rain or watter lead to

leakage,it must be coverd with waterproof membrane after use.

⑥ assure the stationary ring bolt is fixed when transit or move the machine.

⑦,when operating under point 2,fix angle of point 2 same as or no larger than point 1 of 5 degree,to ensure that under the condition when exterior shock attacks the machine itself will not move to left and right to operate the machine.

⑧.make sure the stationary ring bolt is fixed when transit or move the bender.chains must be inserted into the safety pin to pretend the bender from shaking or waving in transit.when move the bender by fixing handle ,4bolts can not loose ,then move the bender together by 4 handles.

⑨ prohibit to use idler wheel items

If marks according to below (X) the method operation troughing of belt hoop will burst easily. Records the proper operation sincerely!

3. Environment:

Please use it under these kinds of the environment conditions.

Environment	Environment temperature	-10℃~45℃ (does not ice up)
	Environment humidity	Below 90%RH (does not congeal dew)
	Storage temperature	-20℃~+65℃
	Environment	In room (non-corrosiveness gas, flammable gas, oil mist and so on)
	Altitude above sea level	Below elevation 1000m

4. Operation

4.1 Operation position

After installed the equipment, the operator can operate the equipment stand on the about 0.5m before operation panel

Notice

- Do not use your hand to touch all the running parts when the equipment is running in case to accident to happened.
- After adjust the quantity to remember lock the nut.
- If have abnormal during the running should to stop the working.

When the container is big the diameter of the filling mouth should not too small in case to protect the filling mouth from damage when filling the pressure is too big.

4.2 Emergency Stop

This machine install one emergency stop button so once you press it the machine will

stop wholly. When there are emergency things happen please press this button.

4.3 Power

110V OR 220V single phase power supply only. The power line should follow the demand as mentioned in safety rules.

4.4 Control panel

1 indicating light: when connecting the power supply, the light should be on.

2 manual switch: if the foot switch could not control the machine operation, replace foot switch 1 by the manual switch near the power light.

3 foot switch 1: press foot switch 1 to complete the operation of angle 1 settled by the “1 point” angle adjustor.

4 foot switch 2: press foot switch 2 to complete the operation of angle 2 settled by the “2 point” angle adjustor.

5 emergency stop switch: during the operation, if there is any trouble, release the button and stop all actions.

6. angle 1: adjust the bended angle by the “1 point” adjustor (corresponding with foot switch 1)

7. angle 2: adjust the bended angle by the “2 point” adjustor (corresponding with foot switch 2)

8. Before bending, please note the angle setting of “1 point” must be bigger than the “2 point”, or the machine can't work. This is for RB-25 AND RBC-25 , RB-32 AND RBC-32 is no problem .

4.5 Operate process

- 1). please connect the power wire to 110V/220V electric and see the indicator light lights up. It means the bender is ready to work.
- 2). please choose the correct size fixed idler wheel and correct size idler wheel according to the rebar diameter.
- 3). Please Connect pedal switches with 1 point and and 2 point holes tightly.
- 4). The 1 point angle setting adjustor is for setting the foot switch connecting with 1 point hole. For example to bend 180 degree by foot switch 1, you set the angle 180 degree by the 1 point adjustor, then you touch the foot switch 1 to bend the rebar 180 degree.
- 5). The 2 point angle setting adjustor is for setting the foot switch connecting with 2 point hole. For example to bend 90 degree by foot switch 2, you set the angle 90 degree by the 2 point adjustor, then you touch the foot switch 2 to bend the rebar 90 degree.
- 6). please note the angle setting of “1 point” must be bigger than the “2 point”, or the machine can't work. please see the below two pictures.
- 7). Fix the angle adjustor by moving to left and right accordingly.
- 8). Operator should work on the outside of the rebar's bending direction.
- 9). Rebar will be bent to set angle when pressing the start switch or pedal switch.

Attention: In order to work precisely, Pls set at point 1 when the bending angle is large (90°) , and set at point 2 when the bending angle is small (135 °)

4. Note :

- ① follow the processing capacity while use the product is a must, surpass the product easily

lead to failure.

②operation gripping bending reinforced material should pay special attention to safety incidents such as bumping fingers.

③ According to the different hardness of reinforced material, special attention should be paid to the fracture which may lead to safety incidents such as wounding.

④ Please do not operate until you confirm no person and object in the reinforced bending radius.

⑤ the product is electrical functioning machinery. As encountered by the rain or water leading to leakage, it must be covered with waterproof membrane after use.

4.6 Movement

1. Move the bender after making sure the handle fixing bolt is tight.

2. Make sure the stationary ring bolt is fixed when transit or move the bender.

3. Chains must be inserted into the safety pin to pretend the bender from shaking or waving in the transit.

4. When move the bender by fixing handle, 4 bolts can not loose or damaged. Move the bender together by 4 handles.

5. Maintenance

5.1 Check and Change

①Change the carbon brush --- The power must be cut off. If the machine stops operating during the process, please confirm the wearing and tearing intensity of the carbon brush. The carbon brush that electric machinery uses belongs to consumables. If the carbon brush is used beyond the restraining line of the wearing and tearing, the electric machinery will subside, even stop running. Then turn off the machine and resume it. If the machine shuts down automatically after transient running, it proves to be necessary to change the carbon brush. Please do use the machine after the change of the carbon brush as the continuing use accelerates wearing and tearing of the commutator which leading to the damage of the rotor coil.

②Means of changing:

Open the upper brush cap with a screwdriver so that the carbon brush can be taken out in the machine.

Please use the attaching brush while purchasing the machine to clean the internal centre axle and fixed gyro wheel before changing and using.

5.2. Lubrication:

5.2.1. Cycle:

The lubrication should be done by the personnel regularly and also can be maintained during the time that not be used.

PLS put the lubrication every week.

5.2.2. Oil

It adopts the common lithium grease; do not use the different lubrication at the same time, if you choose one because it will influence the life span.

5.2.3. Cleaning the oil mouth

Before put the lubrication grease should clean the oil mouth and do remember to wipe off the remaining.

5.3 Check and maintain

Check the bolts and nuts of every position, if they become flexible.

In moist season or after rainy days, the rain-proof ventilate must be opened to dry. In the case of heavy power shock when turn the gyro wheel go back to the location, round it tight after adjusting the unclamp, bludgonned bolt into the very slow state.

Panel indicator lamp on means the machine is turned round and planned.

Check the power and cable if not bright when putting through the power rear board indicator lamp.

Indicator lamp shows the panel, if it is unable to start the machine when press START switch --- Please confirm the tearing state of wearing or carbon brush .

In addition, please consult each branch and after sale service centre of general headquarters for other items.

6. Electrical safety

6.1. Safety rules of electrical system

1. Only personnel who are properly trained and have adequate knowledge and skill should undertake all electrical troubleshooting and repair.
2. Do not alter or bypass protective interlocks.
3. Before starting, read and observe all warning labels
4. When trouble shooting make sure the power source has been cut-off and main switch has been locked.
5. Take extra precautions in damp areas area to protect you from accidental grounding.
6. Before applying power to any equipment it must be established, without a doubt, that all persons are clear.
7. Do not open the electrical control panel unless it is necessary to check the electrical equipment.
8. Do not alter the electrical circuits unless authorized to do by the manufacturer
9. When replacing electrical components, make sure they conform to the manufacturers specifications, including proper color-coding.
10. Do not wear metal glasses, metallic necklaces or chains while working on any electrical equipment.

Also do not wear any ring, watch or bracelet while operating electrical equipment.

Additional instructions for rebar cutter (Rebar cutter and bender Model)

General Safety Precautions

Usage

Use rebar cutters on concrete re-forcing bars only.

Restrict use to designated materials

There is always a chance that the cut end may shoot out, especially if less than 30cm in length. Exceeding designated material specifications greatly increases this risk and will also damage the tool. Do not attempt to cut rebars. Harder, thicker or thinner than those specified.

Use eye protection

Wear safety goggles , safety glassed with side shields or a face shield when using cutter.

Provide safety barriers

Erect safety screens to protect co-workers from possible flying ends. Place safety screen under the rebar when working in high places.

Exercise proper control

Hold cutter firmly and maintain proper footing and balance. Do not over-reach when working in high place , secure cutter to scaffolding with a safety rope. Check that power cord is not fouled and keep cord away from sharp edges and heat. Check that all adjusting wrenches have been removed before using cutter.

Guard Against electric shock

To avoid possible electric shock, do not handle cutter with wet hands or use cutter in the rain or damp places. Be aware of all power lines, electric circuits and other hazards that may be contacted , especially those that are below the surface or otherwise hidden from view .

Unplug tool

Disconnect cutter from outlet when not in use and before cleaning, adjusting or servicing. Do not disconnect plug from outlet by pulling the cord. Always check that the switch lock if OFF before plugging in.

Beware of environment

Do not use cutter in the presence of flammable materials (e.g. Paint, thinner,petroleum products, adhesives).

Do not use cutter in a possibly lighted and clear of obstructions. Operator should at all times have an unobstructed view of the cutter, rebar and surrounding area.

Wear proper apparel

Do not wear loose clothes, dangling objects or jewellery. Restrain long hair. The use of a safety-helmet and rubber soled boots is recommended . If safety gloves are worn, be especially careful that gloves does not get caught in moving parts.

Keep visitors away

Keep all visitors at a safe distance from the work area for their own protection and to prevent distraction of the operator.

Maintain cutter with care

Inspect cutter before each application. Faulty or loose cutter blocks could result in personal injury . Keep handle dry, clean and free from oil and/or grease. Keep housing and piston free of

dirt and iron filings. Check that no screws or bolts are loose or missing. Following instruction for maintenance . Inspect switch, cord,plug and any extension cable at regular intervals.

Store carefully

When not in use, store cutter and accessories in dry place where they can't be accessed by unauthorized person.

Operating Instructions

! Caution : Indicates hazard that could result in minor personal injury and/or product damage.

Care :Indicates hazard that will result in product damage.

Pre-use checks

1. Check oil level.

2. Check condition of cutter blocks and tightness of cutter block bolts.

! Caution : Using loose or cracked cutter blocks may result in injury to operators as well as damage to unit.

3. Check that the power source is appropriate for the cutter.

Care : If voltage is too high , the motor will burn out. If the voltage is too low, insufficient power will be generated. Never use DC current.

4. Check that power supply is properly earthed.

! Caution : Failure to earth power supply may result in electric shock to operator.

5. Check that cord is undamaged and that plug is not loose.

! Caution : Cut or abraded covering could result in a short and electric shock to operator.

Warm-up

In cold weather , warm up unit for 30-60 seconds so that the hydraulic oil reaches the proper viscosity. Pull trigger -switch to extend piston and release when it has reached its full stroke, Repeat 15-20 times.

Stopper adjustment

The adjustable stopper function to maintain the rebar in the correct position during cutting and must be properly set for each size of rebar before making a cut.

- Screw in stopper to provide sufficient clearance for rebar.
- Insert rebar fully into U-shaped support. Make sure that rebar is resting on the base of the stopper.
- Keeping rebar at right angles (90°) to front cutter block, screw out stopper until it is just touching the rebar. Once set, the stopper needs no further adjustment while cutting rebar of the same diameter, but must be re-set for a different size rebar.

! Caution: Failure to correctly set the stopper will result in excessive wear of cutter block and may cause cut end to fly out.

Cutting

1. Insert rebar between stopper and front cutter block, making sure that it is properly seated in U-shaped support.

2. Pull trigger -switch and keep depressed while piston advances and rebar is cut. (If switch is released at an intermediate point, piston will stop.)

3. When cut is completed, release switch. Piston retracts automatically. (Note that switch can't be re-activated until piston has fully retracted.)

Points of attention

1. Be especially careful when cutting off short lengths (30cm or less) as the cut end tends to fly out.

! Caution : Flying ends are a hazard to all personnel in the vicinity. Erect safety screens.

2. Do not cover air vents.

Care : If events are covered , motor will overheat and may burn out.

3. If hydraulic oil exceeds 70 ° (158 F) in temperature, power will drop.

Allow until to cool before resuming operation. (Be particularly careful in summer, when the aluminum pump case heats up quicker.)

4. If a drop in power is observed and motor is unusually hot, check carbon brush .

5. If piston should ever fail to retract completely, push rear cutter block backwards to manually retract piston.

! Caution: Use a rebar or flat metal bar for this purpose. Never push cutter block with any part of the hand, even if gloved.

Once piston has been retracted , pull trigger-switch long enough to partially advance piston. Unplug unit. And check piston and housing for accumulated dust iron filings that may be jamming the piston. After cleaning, piston still does not automatically retract when fully extended, the piston itself may be damaged. Return the unit to an authorized agent for repair.

Maintenance

Cutter blocks

Before using, always check that the two bolts on each cutter block are properly tightened. Using a loose block will result in damage to block and housing. Also check condition of cutter blocks. If either cutting edge is dull or chipped, remove retaining bolts and rotate both blocks so that two new edges come into use. Replace and tighten bolts (each block has four cutting edges)

When all four cutting edges have been used or if either block is cracked or otherwise damaged, replace both block.

! Caution : A loose or cracked block may result in injury to operator .

Cleaning

Cleaning cutter after use.

! Caution : Wear gloves to protect hands from metal splinters. Do not use an air-gun, blasting with air can cause metal filing and/or dust to get into eyes and respiratory system.

1. Disconnect unit.

2. Wipe or brush away all dirt and metal filings. Pay particular attention to the lower half of the piston, where dirt is more easily accumulated.

Oil-level check

As the cutters are hydraulically operated, the oil level must be checked at frequent intervals, preferably every day. Failure to maintain the oil at the proper level results in a drop in pressure and loss of cutting power.

! Caution : Hydraulic oil is highly flammable. Keep away from sparks and naked flame. Do not smoke.

! Caution : Hydraulic oil may cause inflammation of the eyes and skin. If ingested, it will cause diarrhoea and vomiting.

In case of eye contact, rinse in clean water for at least 15 minutes and consult a physician. In case of skin contact, wash thoroughly with soap and water.

In case of ingestion, consult a physician immediately. Do not deliberately induce vomiting.

1. Oil should be warm but not hot. Warm up unit if cold.
2. Adjust stopper and make three or four cuts, noting exactly at what point the rebar is actually breaking.
3. Pinch a short piece of rebar, stopping just before it breaks off. Unplug unit from power source.
4. With partially severed rebar in place, turn unit over so that oil-plug is uppermost. (If unit is hot, allow to cool down.)
5. Remove oil-plug and seal-washer (packing)
! Caution : Never remove oil-plug when unit is hot or oil will spurt out.
6. check that oil is level with bottom of plug hole. (i.e. That pump case is full to the brim). If oil level is too low, top up with 20-weight hydraulic oil with anti-foam and anti-abrasion properties. (ISO viscosity grade VG46. E.g. Shell oil tellus 46, mobil oil DTE-25 OR Esso uni power SQ46.)
7. After topping up, extract air from system. Gently tilt cutter lengthwise and return it to a level position. Top up again and tilt in the opposite direction . Repeat this process until all air has been extracted.
Care: Cutter can't function properly if oil contains air bubbles.
8. Replace seal washer (packing) and plug. Connect cutter to power source and completely serve rebar.

Oil change

The hydraulic oil should be changed at least once a year. Sooner if it appears dirty.

2. Unplug unit from power source. Remove oil plug and packing. Turn cutter over and drain oil into a suitable receptacle. When oil ceases to drain out, tilt unit to rear so that oil trapped in the piston housing can run out. When housing is empty, tilt unit in the opposite direction to empty the residue in the pump case.
3. With drain-hole uppermost, slowly fill the unit with fresh oil. Replace plug and lightly tighten. Connect unit to power source and advance piston two or three times. Unplug unit and remove oil-plug . Top up oil level and replace plug.
4. Finally follow procedure for oil level check.

Note: Dispose of hydraulic oil in accordance with local regulations. Do not pour into the sea, river, lake or drains.

Bolt tightness

Once a week or after every 500 cuts, check the tightness of all bolts, especially those securing the housing to the cylinder. Loose bolts will result in a loss of power.

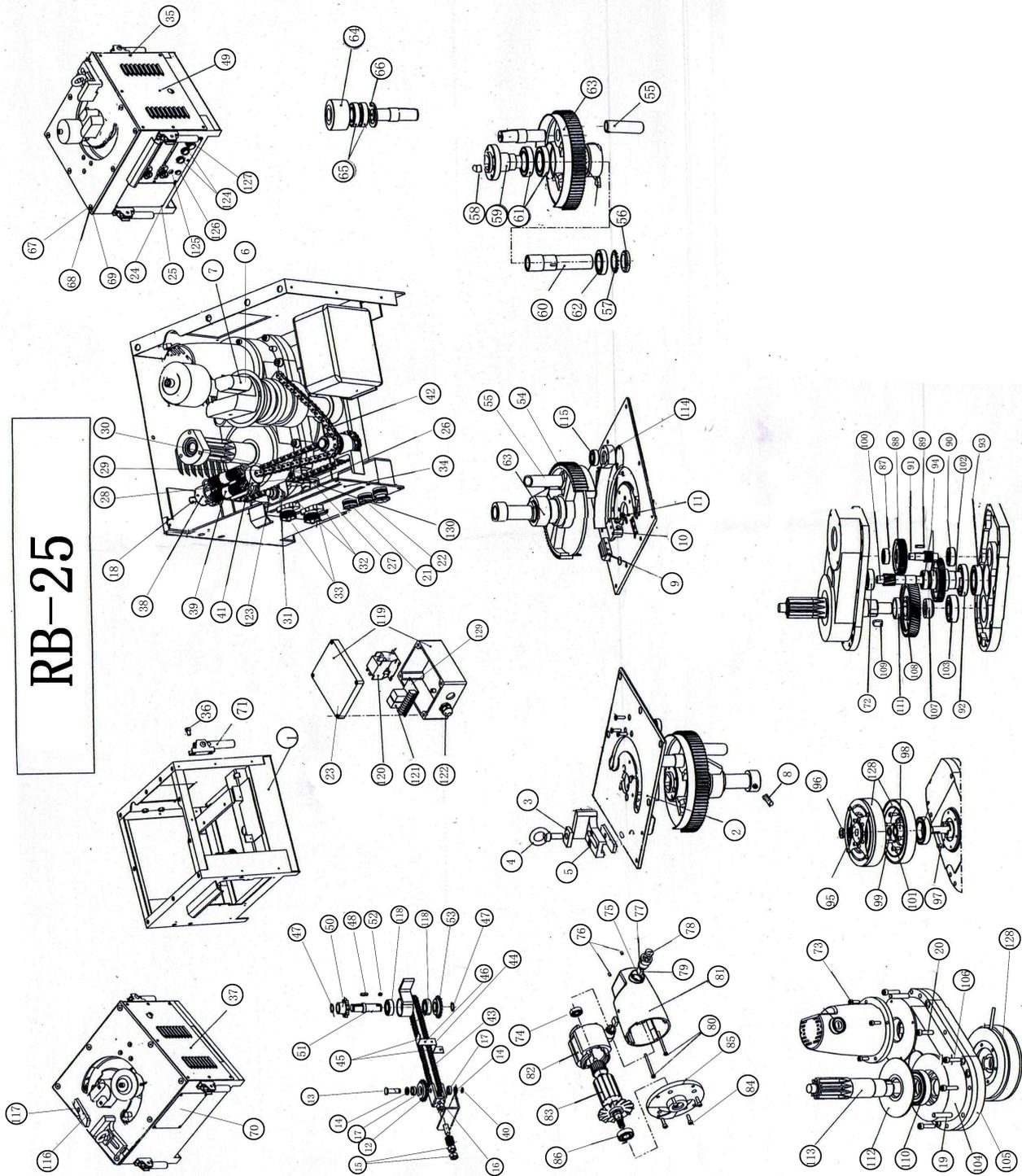
Carbon brushes

Inspect the two carbon brushes at least once every two months. (normal brush life is 200 hours.)

Care: Worn brushes will result in power loss, cause the motor to run hot and irreparably damage the armature's commutator.

1. Disconnect unit
2. Unscrew both brush caps and pull out carbon brushes.
3. Replace brushes if less than 6 cm in length.

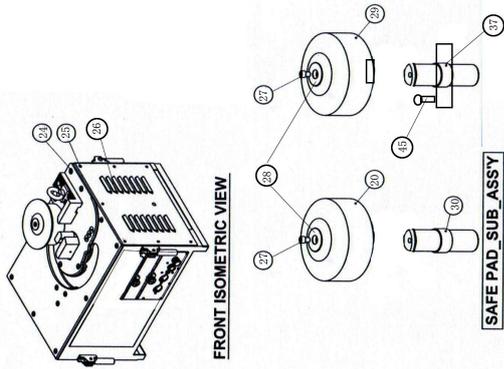
RB-25



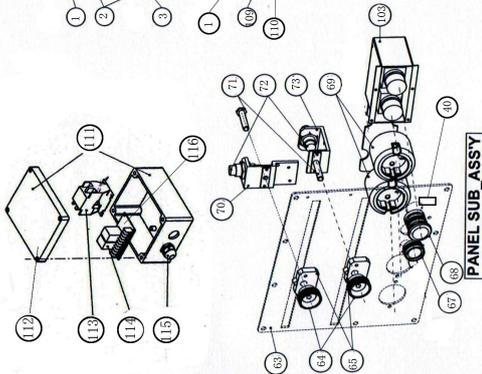
RB-25 PARTS LIST

NO.	PARTS NAME		NO.	PARTS NAME		NO.	PARTS NAME
1	Foot stand sets		44	stop film		87	6202 bearing 15×35×11
2	work table sets		45	chain connector		88	gear
3	fixed gasket		46	cup head rivet Φ3.5×4		89	round head flat key
4	hexagonal screw		47	shaft circlip Φ20		90	6302 bearing 15×42×13
5	adjust block		48	round head flat key		91	gear shaft
6	model		49	right shutter		92	61910 bearing 50×72×12
7	locating shaft		50	chain wheel		93	10008 bearing 40×68×9
8	hexagon socket set		51	chain wheel shaft		94	6004 bearing 20×42×12
9	buffer block		52	round head flat key		95	stop washer 16
10	stop block		53	chain wheel		96	round nut M16×1.5
11	hexagon socket set		54	inner hexagon screw		97	round head flat key
12	chain wheel		55	leakage terminal welding		98	Needle bearing
13	pin roll		56	round nut M45×1.5		99	bearing gasket
14	gasket 12		57	stop washer Φ45		100	gear shaft
15	nut M12		58	round head flat		101	inner hexagon screw
16	chain wheel foot stand		59	locating sleeve		102	connecting gear
17	61901 bearing 12×24×6		60	connect sleeve		103	6305 bearing 25×62×17
18	hexagon headed bolt		61	6011 bearing 55×90×18		104	gear case(up case)
19	round pin 10×35		62	6009 bearing 45×75×16		105	gear case(down case)
20	inner hexagon		63	big gear component		106	inner hexagon screw
21	cord arma		64	roll wheel		107	washer
22	cord arma		65	6207 bearing 35×72×17		108	gear
23	electrical housing		66	hole collar Φ72		109	round head flat key
24	gasket		67	chamfer head screw		110	6208 bearing 40×80×18
25	pan head screw M4×7		68	spring washer Φ10		111	washer
26	Down sensor holder		69	nut M10		112	housing
27	nut M4		70	air door plate		113	gear shaft
28	chamfer head screw		71	handle rivet sets		114	washer
29	nut bolt		72	6303 bearing 17×47×14		115	6204 bearing 20×47×14
30	nut M5		73	inner hexagon screw		116	gasket
31	up sensor holder		74	6200 bearing 10×30×9		117	inner hexagon screw
32	cord holder		75	carbon holder's washer		118	6004 bearing
33	hand wheel		76	hexagon socket set		119	electric box
34	panel		77	carbon holder sets		120	contactor
35	pan head screw		78	carbon holder cap		121	relav
36	inner hexagon screw		79	carbon brush sets		122	water joint
37	left shutter		80	inner hexagon screw		123	sensor
38	tension spring holder		81	Motor housing		124	navitage plug
39	tension spring		82	stator components		125	indicator lamp
40	split pin Φ3.2×16		83	rotor components		126	jogging switch
41	tension spring holder		84	inner hexagon screw		127	emergency switch
42	chain 08B-1-35		85	motor end housing		128	magnetic clutch
43	chain 06B-1-T6		86	6203 bearing 17×40×12	129	PC Board	130 limited switch

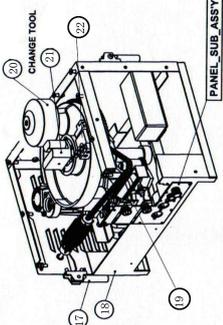
RB-32



FRONT ISOMETRIC VIEW



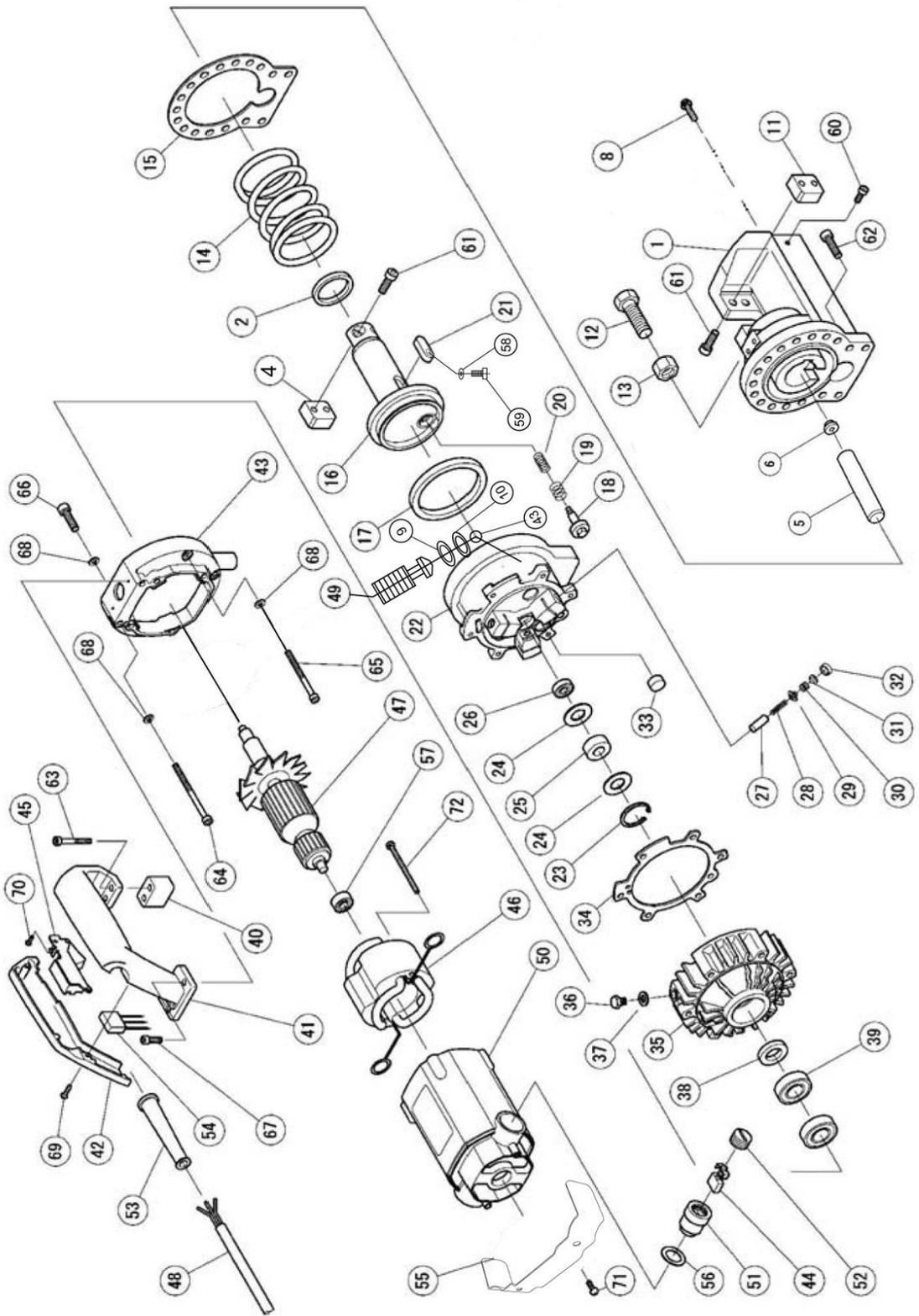
PANEL SUB_ASSY



RB-32 PARTS LIST

NO	PARTS NAME		NO	PARTS NAME		NO	PARTS NAME
1	connecting chain		40	ON-OFF switch		79	gear case (down case)
2	bearing 6902 28×15×7		41	big gear component		80	hexagon socket set
3	chain shaft		42	leakage terminal pipe		81	inner hexagon M6×25
4	chain connector		43	bearing housing		82	nut
5	chain 3		44	small air door plate		83	gasket
6	chain 4		45	inner hexagon M12×12		84	magnetic clutch
7	tension spring holder		46	foot stand sets		85	gasket
8	tension spring		47	Ring Screw M18×55		86	needle bearing
9	tension spring holder		48	fixed gasket		87	inner hexagon
10	outer hexagon M10×40		49	adjust block		88	6305 bearing
11	chain wheel		50	work table		89	6203 bearing 40×17×12
12	6002bearing32×15×9		51	stock block		90	gear
13	nut M12		52	hexagon socket set		91	pin
14	chain pin		53	6203 bearing 40×17×12		92	bearing shaft
15	chain wheel foot stand		54	rotor components		93	6204bearing
16	hexagon socket set		55	stator components		94	gear shaft
17	handle sets		56	bearing 6200 30×10×9		95	stop washer \varnothing 20
18	housing		57	motor end housing		96	gear
19	round pin \varnothing 10×40		58	inner hexagon M5×70		97	6006bearing 65×30×13
20	idler wheel		59	carbon brush		98	pin
21	module		60	brush holder cap		99	gasket
22	buffer block		61	hexagon socket set		100	connecting gear
23	left shutter		62	brush holder		101	6913 bearing 90×65×13
24	hexagon chamfer screw		63	panel		102	6306bearing 72×30×19
25	cup head screw M5×8		64	hand wheel		103	electric housing
26	right shutter		65	cord holder		104	limited switch
27	inner hexagon M12×15		66	back emergency switch		105	motor housing
28	gasket		67	Micro switch		106	6308bearing 90×40×23
29	locating sleeve		68	emergency switch		107	6009bearing 75×45×16
30	idler wheel shaft		69	Aviation plug		108	hexagon chamfer screw
31	connecting sleeve		70	up sensor holder		109	spring washer
32	bearing6011 90×55×18		71	screw		110	M12
33	stop washer \varnothing 20		72	sensor		111	electric box
34	round nut M55×2		73	down sensor holder		112	electrical housing
35	locating ring		74	bearing 6206 62×30×16		113	contactor
36	hexagon socket set		75	main gear shaft		114	relay
37	locating shaft		76	gear box cover		115	water joint
38	locating sleeve		77	inner hexagon M10*40		116	PC board
39	bearing6014		78	gear case(up case)			

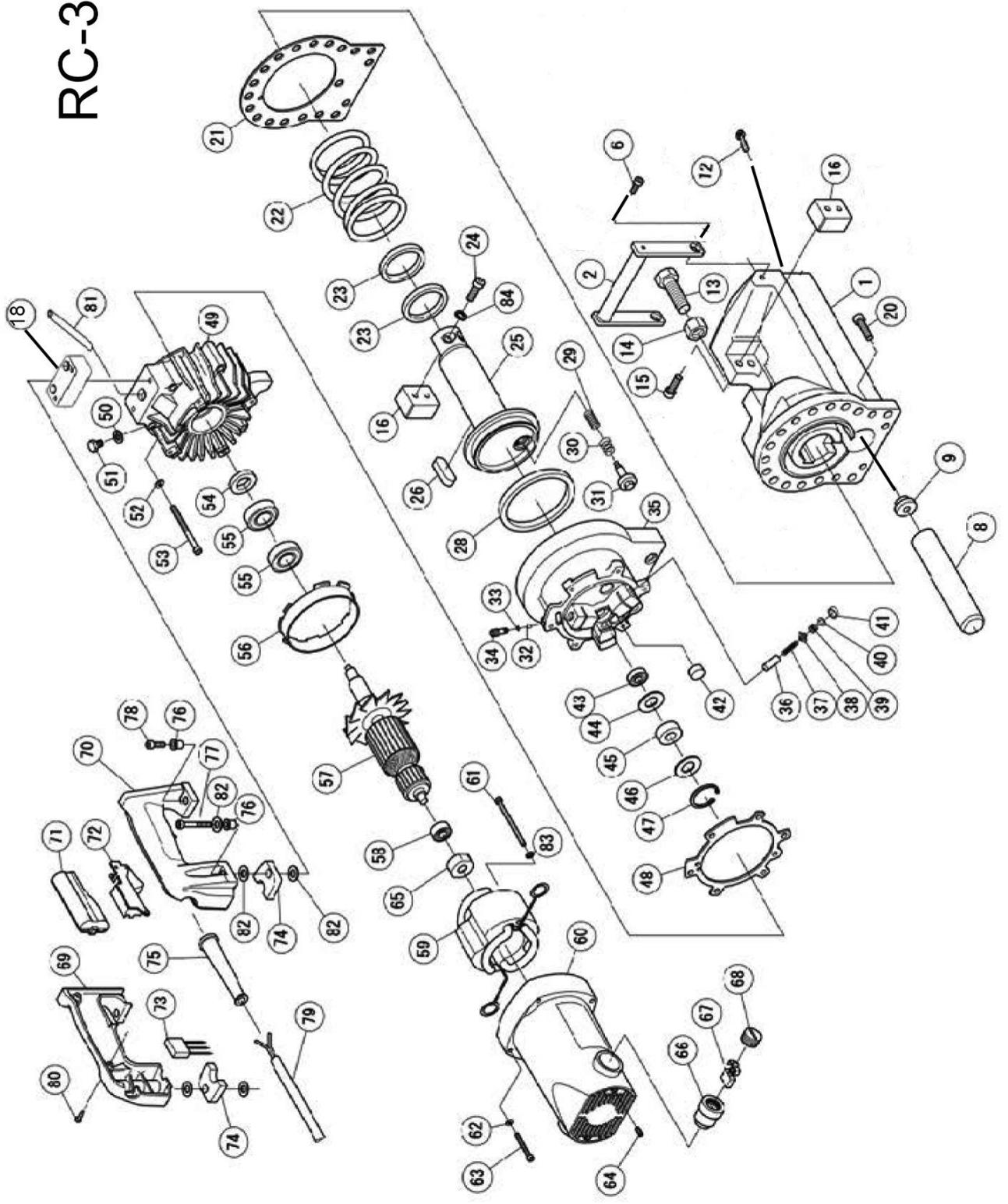
RC-20, RC-22, RC-25 Portable Rebar Cutter Parts List



RC-25 PARTS LIST

NO.	PARTS NAME	NO.	PARTS NAME
1	CUTTER HEAD	40	CONNECTING BLOCK
2	GASKET RING 40×50×6	41	HANDLE
3	**	42	HANDLE COVER
4	CUTTER BLOCK / BLADE	43	PHOTOSPHERE Φ4.763
5	AIR BAG	44	CARBON BRUSH
6	NUT	45	SWITCH
7	**	46	STATOR COIL
8	SCREW	47	ARMATURE
9	O RING	48	ELECTRICAL CORD
10	O RING	49	BOLT
11	CUTTER BLOCK / BLADE	50	MOTOR HOUSING
12	HEXAGONAL SCREW	51	CARBON BRUSH HOLDER
13	NUT	52	CARBON BRUSH CAP
14	BIG SPRING	53	CABLE ARMOR
15	GASKET	54	**
16	CUTTER ROD	55	**
17	GASKET RING 80×95×9	56	GUM WASHER
18	RETURN SHAFT	57	BEARING 6200
19	SPRING	58	WAVE WASHER
20	SPRING	59	BOLT M4*8
21	PIN 12×40	60	BOLT M8*25
22	CYLINDER	61	BOLT M8*30
23	SNAP RING	62	BOLT M8*30
24	MANGANESE STEEL GASKET	63	BOLT M6*20
25	NEEDLE BEARING 14×30×12	64	BOLT M6*20
26	BEARING 609	65	BOLT M6*25
27	PISTON	66	BOLT M6*50
28	SPRING	67	BOLT M6*20
29	OIL VALVE	68	WASHER
30	SPRING	69	BOLT M4*12
31	SPRING GUIDE	70	BOLT M4*8
32	OIL SEAL	71	**
33	FILTER MAGNET	72	BOLT M5*75
34	GASKET	73	CONNECTING PLATE
35	PUMP CASE		
36	HEXAGONAL SCREW M10×16		
37	COMPOUND GASKET Φ10		
38	OIL SEAL 20×35×8		
39	BEARING 104		

RC-32



RC-32 PARTS LIST

NO.	PARTS NAME		NO.	PARTS NAME		NO.	PARTS NAME
1	HOUSING		28	SEAL 85X100X9		55	BEARING 6004
2	SUB HANDLE		29	RETURN SPRING UP		56	FAN COVER
3	COLLAR		30	RETURN SPRING		57	ARMATURE
4	P. WASHER		31	RETURN VALVE		58	BEARING 6200
5	S .WASHER		32	STEEL BALL		59	STATOR COIL
6	CAP BOLT M8X16		33	O RING		60	MOTOR HOUSING
7	SEAL 26X32X4		34	RELEASE VALVE		61	TAPPING SCREW
8	AIR BAG		35	CYLINDER		62	P.WASHER M6
9	TIGHT SCREW		36	PISTON		63	CAP BOLT M6X25
10	**		37	SPRING		64	CAP BOLT M5X16
11	**		38	DELIVERY VALVE		65	**
12	SCREW		39	SPRING		66	BRUSH HOLDER
13	BOLT M16X40		40	SPRING GUIDE		67	CARBON BRUSH
14	NUT M16		41	PUMP HEAD SEAL		68	BRUSH CAP
15	CAP BOLT M8X30		42	MAGNET FILTER		69	HANDLE COVER
16	CUTTER BLOCK		43	BEARING 609		70	HANDLE
17	CAP BOLT		44	BEARING GUID		71	SWITCH SUPPORT
18	**		45	NEEDLE BEARING		72	SWITCH
19	CAP BOLT M6X20		46	BEARING GUIDE		73	CONDENSER
20	CAP BOLT M10X40		47	SNAP RING		74	HANDLE STAY
21	CYLINDER PACKING		48	PUMP CASE PACKING		75	CORD ARMOR
22	RETURN SPRING		49	PUMP CASE		76	P.WASHER M6
23	SEAL 45X55X6		50	SEAL WASHER		77	CAP BOLT M6X35
24	CAP BOLT M8X25		51	CAP BOLT M10X16		78	CAP BOLT M6X35
25	CUTTER ROD		52	SEAL WASHER		79	CORD
26	PIN 12X40		53	CAP BOLTM6X50		80	TAPPING SCREW
27	**		54	OIL SEAL 20X35X8		81 TAPPING SCREW	82 WASHER