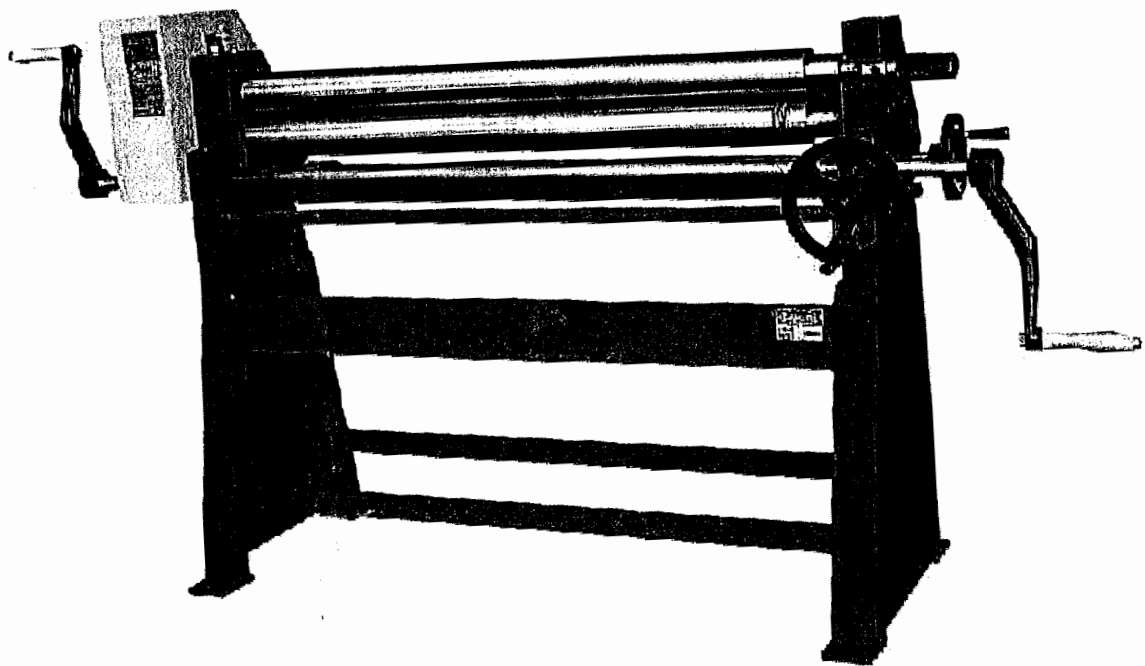


USER'S MANUAL
RS
MANUAL
PLATE BENDING MACHINE



GENERAL NOTES

1. Introduction

Thank you for choosing a our company. We are proud to have you in our long list of satisfied customers all over the world.

This User's Manual is absolutely for your safety and is essential for the machine to have a long production life. As long as you keep up with our Manual you will be able to run your machine smoothly and safely. Keep in mind that the machine is designed absolutely to perform maximum safety and for efficient working.

In this Manual you can find instructions and information about:

- Correct installations of the machine
- Description of the functional parts of the machine
- Set-up and start-up adjustments
- Correct standard and scheduled maintenance
- Simple safety regulations and accident prevention.

Therefore, as far as the user's safety is concerned, in this handbook the possible risks connected with machine operation are pointed out as follows:



Attention: Showing the risks of accident, if instructions are not followed.



Warning: Showing the probable damages to the machine or equipment, if the instructions are not strictly followed.



Note: It gives useful information.

It is certainly necessary that the operator should read and understand all the **Attention, Warning, Note** specified in this Manual before starting with operation of the machine and before any lubrication or maintenance intervention

On all steps of installation, operation and maintenance safety must be your first concern for the protection of yourself, other users and the service of the machine. In case of any failure please first refer to this Manual, and then if a solution cannot be found contact first of all the distributor where you purchased our product. Do not forget to refer to the drawings and the numbers for any spare part needed or to define any problem. Make sure you have the serial number and production year of the machine.

Our technical staff will make their best to help you in the most convenient way.

2. Transport

As soon as you receive the machine, check for any visible transport damages. Should there be any visible damages; report it straight away to the transporter company and of course. Our company or your supplier.

GENERAL WARRANTY TERMS

- *Your machine is covered by manufacturer's guarantee for a period of **12 months** from the date of purchase against manufacture defects. The warranty period does not exceed 18 months from the date of delivery from the manufacturer's factory.*
- *Warranty covers only manufacture defective parts and / or components that are reported as "defective" by a our company Technician or the Agent Technician and must be reported to in writing by fax or email.*
- *The manufacturer is responsible for the supply of free of charge spares only and cannot be held responsible for loss of work.*
- *Shipping and customs fees for the spare part must be paid by the end-user.*
- *If a technician travel is necessary we will not charge for labor and workmanship costs but the customer must pay traveling and accommodation charges.*
- *A Warranty claim does not relieve the Customer from payment obligations.*
- *The Customer can not ask or demand any reimbursement of damage nor the Customer will have the right to extend or delay payment obligations nor the cancellation of order and the refunding of damages as the guarantee is given for the defective parts of the machine and not for the job.*



Note: All warranty claims must be applied with the Model, Serial Number and the Manufacture Year of the machine.

TECHNICAL PROPERTIES

The RS Model Manual Benders have these specifications:

TECHNICAL SPECIFICATIONS AND STANDARD EQUIPMENTS

- Two rolls powered by a gear system
- SAE 1050 Quality certificated steel rolls with high tensile strength
- Cast iron main frame
- Conical bending device
- User manual book
- Built according to EC safety directives
(CE – Mark)

MODEL: RS Technical Properties					
MODEL		RS 1050x90	RS 1270x90	RS 1550x90	RS 2050x95
Bending capacity	mm	3.0	2.5	2.0	1.5
Roll Diameters	Ø mm	90	90	90	95
Dimensions	mm	2080x1250x700	2300x1250x700	2580x1250x700	3080x1250x700
Useful length	mm	1050	1270	1550	2050
Weight	kg	410	450	560	760



Note : Machine dimensions are approximate

OPTIONAL ACCESSORIES

- Induction hardened rolls



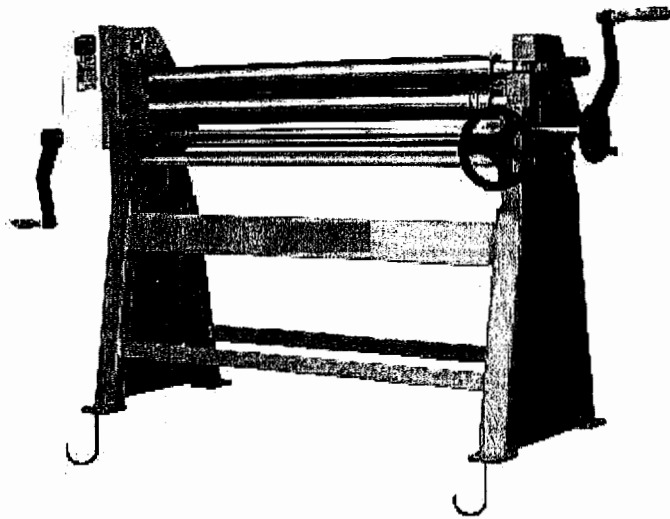
Warning: Do not feed profiles having a higher thickness than specified for the capacity of the machine. Do not feed more than one piece at a time. Do not use the machine for any other job the one for which it has been designed.

START-UP INSTRUCTIONS

The machine can be bolted to the ground as shown below. The bolts must be tightly screwed for the machine not to move under strain. Also check these bolts for breaking periodically.

- Please drill the ground about 100mm long
- Please clean the ground
- Replace screws machine body to the ground carefully
- Please check the screws in the ground at every six months.

Foundation Plan



Environment Conditions

While setting up the machine dimension that should be taken as reference are given in the machines working area.

To get a higher working performance and to lengthen the life time of the machine and for the security of the environment and the replacement place take care to these:

- Keep away from, the machines that make dust and sawdust
- Keep away from, the machines that may cause vibration
- Should be replaced on a concrete surface against vibration
- Under necessary conditions it is usefull to separate the placing surfaces.

Cleaning Of The Rust Cover

Please clean the every part in the rust cover, and use Nitro or Triklörütlen for cleaner.

Adjustment (set up)

All of machines must adjust goodly and carefully to take smooth working from machine. Machine adjustment must make with water balance equipment.

Sensitive: 0,04mm/m. adjust the machine from main screws or feed the machine adduced sensitive and control the adjustment time after time.

EXPLANATION FOR OPERATOR

Operator under age of 16 years to operate the machine is strictly forbidden (EC-Directive). The operator of the machine should carefully read this manual and understand the danger he might be in if he misuses or abuses the machine. If any part of this manual is unreadable or illegible please contact to the dealer and manufacturer

The owner of the machine should be responsible for operating the machine with qualified personnel.

PERSONAL PROTECTION

Gloves and safety glasses and safety cap are recommended during operator.



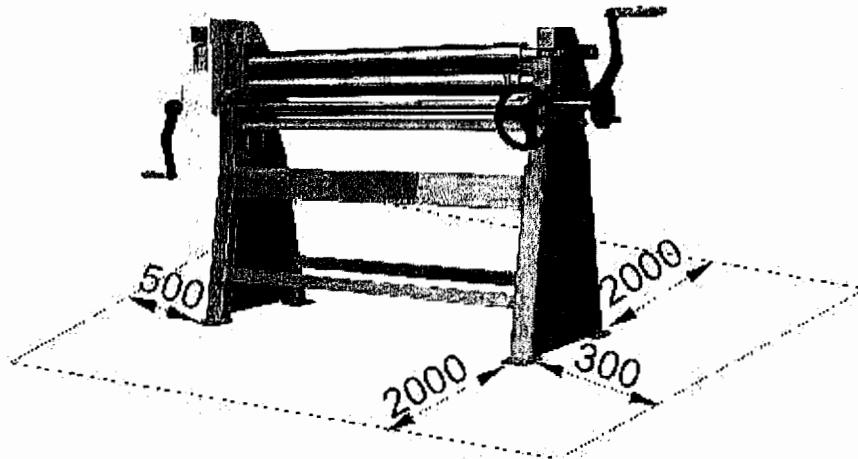
Attention:

- No material should be fed if the machine is running.
- The user must be careful for third persons entering the operation area of the machine.



Note : If any labels are lost or unreadable contact the manufacturer for new supplies.

WORKING AREA OF THE MACHINE



General Safety Instructions

Following instructions are meant for the operator of the machine and it is the End-User's responsibility to make sure the operator reads and understands the following and the User's Manual for safe operation.

- Read the User's manual before operating the machine.
- Never touch rotating or moving parts.
- Keep your working dress or long hair or necklace etc away from rotating parts.
- Work with necessary safety clothes if necessary (safety shoes, glasses , earplugs etc).
- See and understand Safety Labels on the machine.
- Perform periodic maintenance.
- **DO NOT** overload the machine.
- If you see abnormal behavior of the machine, stop the machine and inform your supervisor immediately.
- Be careful of other people around the machine during operation.
- Be extremely careful during transport or re-placement of the machine and follow transport instructions in the manual to safely handle the machine.

Sheet Bending Position

Figure 1

Top roll and lower roll in a flat position.

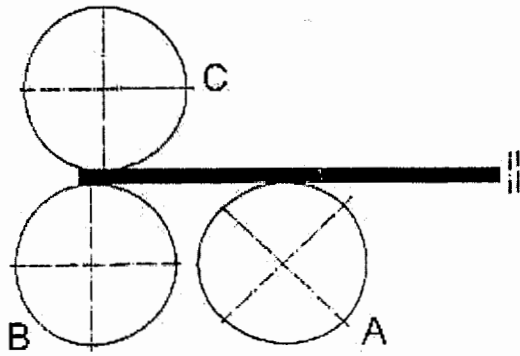


Figure 1

Figure 2

Move the back roll up to complete the pre-bending

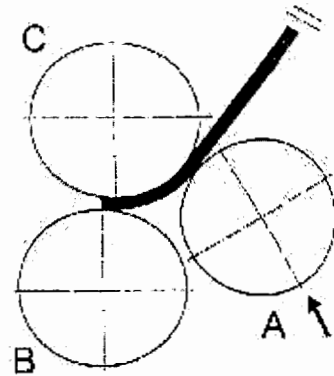


Figure 2

Figure 3

Reverse the sheet and place for second pre-bending.

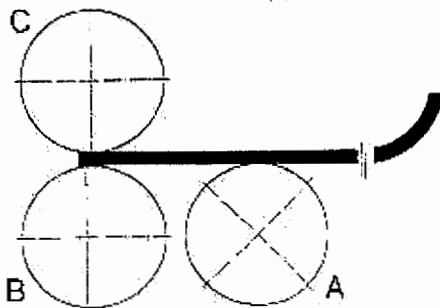


Figure 3

Figure 4

Move the back roll up to complete Pre-bending

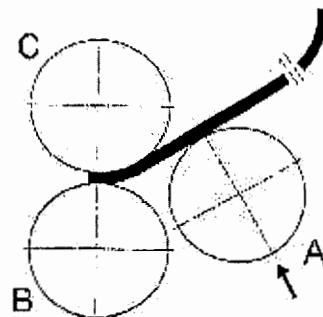


Figure 4

Figure 5

Roll until required diameter is achieved.

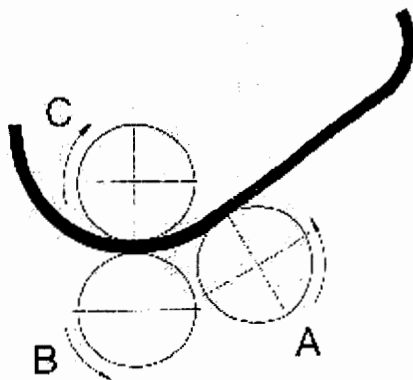


Figure 5

Figure 6

Finish operation shown as below.

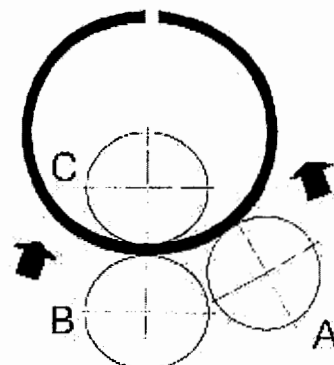


Figure 6

CONICAL BENDING

Conical bending is more difficult than normal bending. So machine capacity must be reduced to %30 - %50 to determine conical bending capacity of the machine. Also machine must be prepared for conical bending operation as shown.

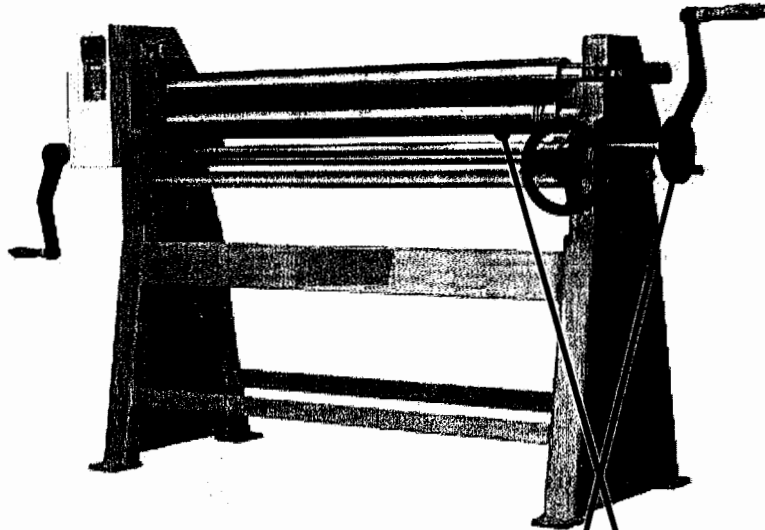


Figure-1

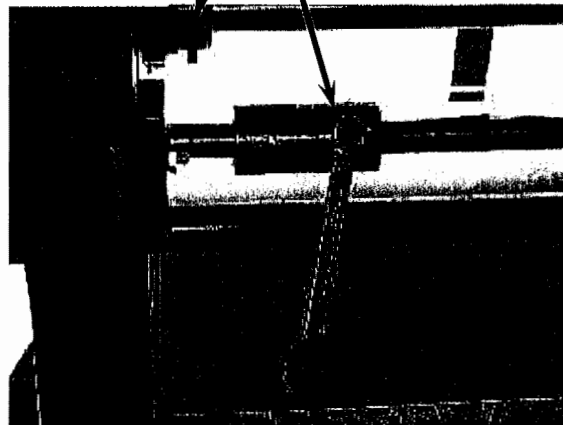


Figure-2



Note: When bending conical the overall max. thickness capacity decreases by 30 - 50 %

Figure -1

Move both lower roll and back roll to the lowest position as shown above

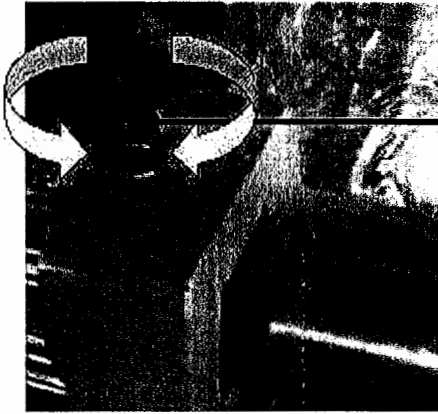
Figure-2

Remove couplings by a hand tool on the drop end side so that only that side of the rolls will move when you use the handwheels. When you move the handwheels the rolls will move only in one side so that you can make conical bending. You can now put the material by the conical bending device and start bending



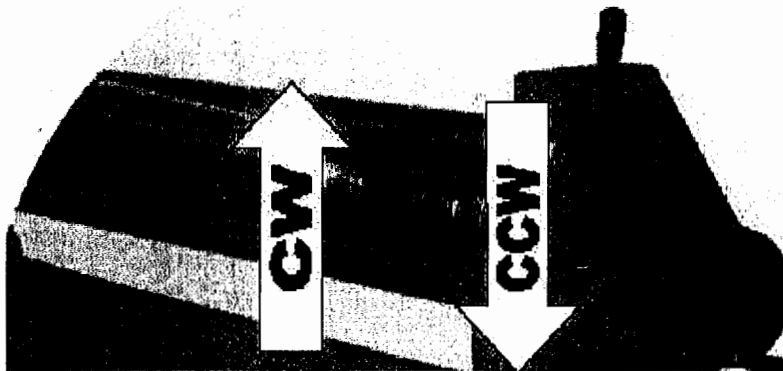
Counter Balance System ;

There is a counter balance bolt located on top of the top roll bushing. This is to prevent the top roll from inclining down too much, when opened.



Balance bolt

- Tighten CW to counter more.
- Loosen CCW to decrease counter force.



MAINTENANCE

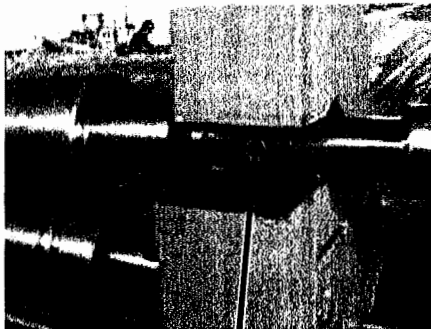
PERIODIC CONTROLS

The rolls of the machine must **NEVER** be greased or lubricated. Because, then the rolls will slip the material and will not bend. Always keep the rolls clean and free from grease or any lubricant. Also make sure that the material is free from grease and dirt.

These points must be greased periodically at least once a month or more if daily usage exceeds 8 hours a day. Note that some of these points are actually inside the machine cover and the front cover must be removed in order to reach them. Any standard commercial grease can be used for lubrication.

NUMBER	PERIOD	WHAT TO DO
1- Moving Parts	Once a month	Grease
2- Bushing	Twice a month	Oil

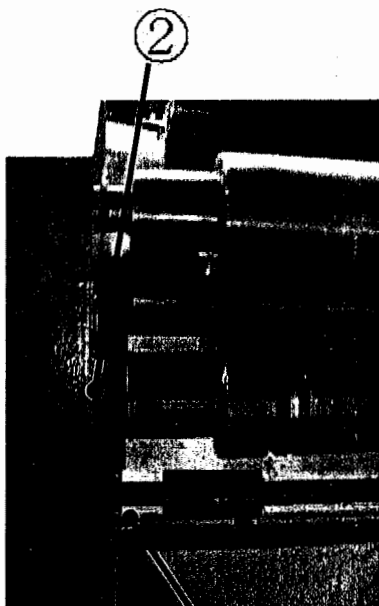
The reduction gearbox of the machine is inside the front cover and is maintenance free. Only you should control it periodically and tighten the bolts fixing it to motor and to the frame, if necessary.



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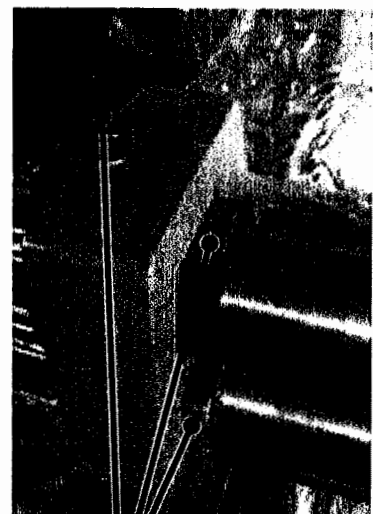


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