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S253 PB-416H

WS SYSTEM HAND FOLDER

OPERATION & PARTS MANUAL

07-02-2006

Model WS System Hand Folder

Operation Manual

Machine No.

Serial No.

Manufactured Date

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	Total P7	No. P 1

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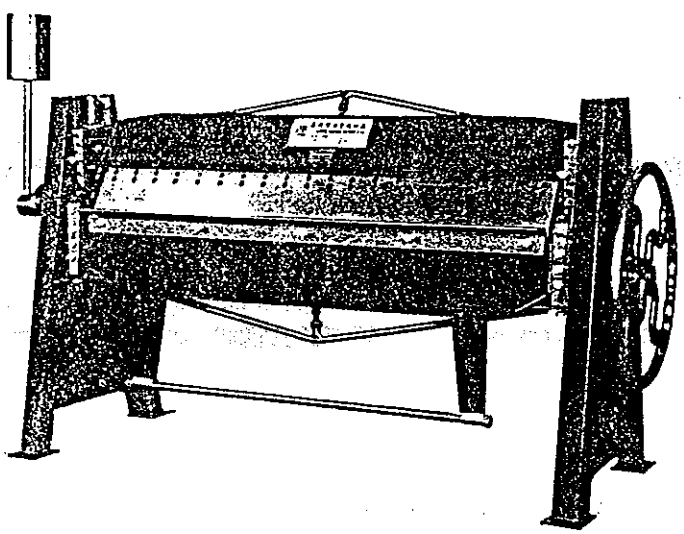
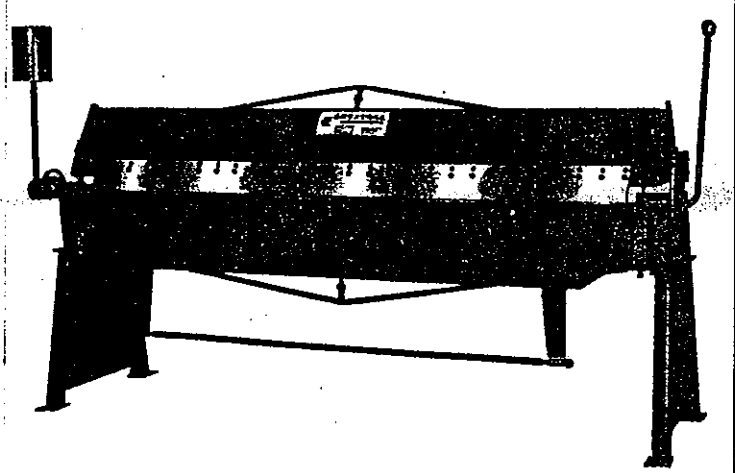
Introduction

The WS Hand Folder is used for sheet metal forming. It is designed using advanced technology from the USA and Japan. It is suitable for the forming of mild and stainless steel and inconjuction with a variety of other products manufactured by such as the Pittsburgh Lock machine that ducting can be produced.

The WS hand folder can be found in many manufacturing industries such as Lamp, Kitchen manufacturing and the box sections for buses





Use and Operating Features.

The WS Hand Folder is used for the bending and forming of mild And stainless steel of less then 2.5mtr with a thickness of 2.5mm also Coated steel plate. It can be found in the manufacture of stainless Steel kitchen equipment, metal furniture, lamps, HVAC and air conditioning Equipment.

The Hand Folder can be used for making special shapes and Angles and has a fixed position adjustment control. The machine has Individual removable upper moulds for bending different lengths.

There is comparatively little movement and pound giving a Smooth bend with little distortion. The operation of the machine is with A hand wheel or level via a bevel gear and cam locking system, which Is easy to operate, service and adjust.

The operation of the machine requires that the upper Blade clamps The material while the lower braking board is brought into the closed Position to fold the plate.

Operation manual

Model WS system Hand folder

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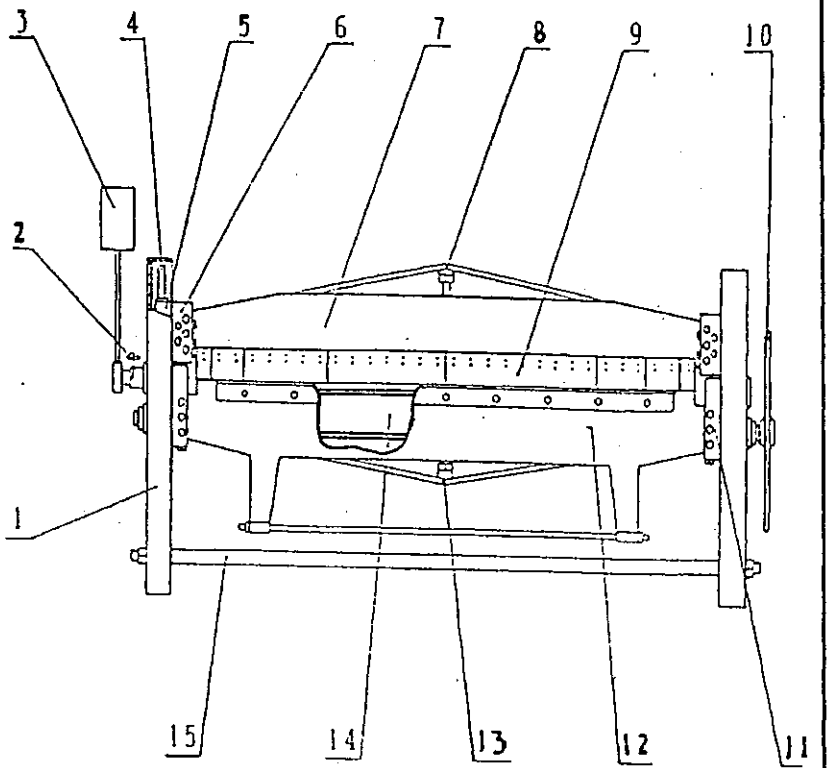
Main technical data and specification

Bevel gear locking structure

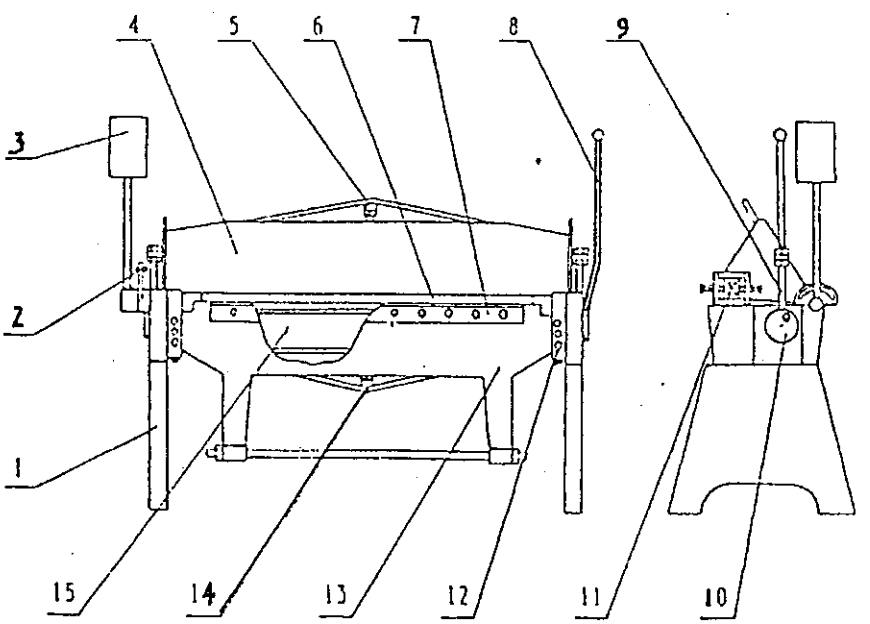
Model	Max. Bending thickness	Max Bending width	Min Folding Angle	Weight Kg	Dimension (L×W×H)	Tool
WS1.5×1000A	1.5	1025	35°	200	1300×600×1500	Complete blade
WS1.5×1000B	1.5	1025	60°	200	1300×600×1500	Disport blade
WS1.5×1280A	1.5	1280	35°	320	1650×600×1500	Complete blade
WS1.5×1300B	1.5	1300	60°	320	1650×600×1500	Disport blade
WS1.5×1500A	1.5	1540	35°	360	1900×600×1500	Complete blade
WS1.5×1500B	1.5	1500	60°	360	1900×600×1500	Disport blade
WS1.2×2000A	1.2	2050	35°	450	2350×600×1500	Complete blade
WS1.2×2000B	1.2	2050	60°	450	2350×600×1500	Disport blade
WS1.5×2000A	1.5	2050	35°	550	2350×600×1500	Complete blade
WS1.5×2000B	1.5	2050	60°	550	2350×600×1500	Disport blade
WS1.5×750BC	1.5	750	55°	180	1000×500×1300	Disport blade
WS1.5×750AC	1.5	750	35°	180	1000×500×1300	Complete blade
WS1.5×1000BC	1.5	1020	55°	200	1250×600×1300	Disport blade
WS1.5×1000AC	1.5	1020	35°	200	1250×600×1300	Complete blade
WS1.5×1300BC	1.5	1300	55°	250	1600×600×1300	Disport blade
WS1.5×1280AC	1.5	1280	35°	250	1600×600×1300	Complete blade
WS1.5×1500BC	1.5	1500	55°	320	1850×600×1300	Disport blade
WS1.5×1500AC	1.5	1500	35°	320	1850×600×1300	Complete blade
WS1.2×2000BC	1.2	2050	55°	410	2350×600×1300	Disport blade
WS1.2×2000AC	1.2	2050	35°	410	2350×600×1300	Complete blade
WS1.5×2000BC	1.5	2050	55°	510	2350×600×1300	Disport blade
WS1.5×2000AC	1.5	2050	35°	510	2350×600×1300	Complete blade
Cam locking structure						
WS2× ×1280	2.0	1280	55°	480	1800×600×1500	Disport blade
WS2.5×1300	2.5	1300	55°	680	1800×600×1500	Disport blade
WS2×1500	2.0	1500	55°	750	1800×600×1500	Disport blade
WS2.0×2000	2.0	2020	55°	950	2700×950×1700	Disport blade
WS2.5×2000	2.5	2000	55°	1200	2900×950×1500	Disport blade
WS1.5×2500	1.5	2500	55°	1100	3200×950×1500	Disport blade
WS2×2500	2	2500	55°	1500	3400×950×1500	Disport blade

3. Construction and Adjustment.



1. Side plate 2. Angle locating plate 3. Balance hammer 4. Screw 5. Slide 6. Adjusting plate 7. Upper beam 8. Strength block of upper beam 9. Press blade 10. Hand wheel 11. Braking board seat 12. Braking board 13. Strength block of downward beam 14. Downward beam 15. Frame locating shaft

Fig No 1. (a) Bevel gear locking structure



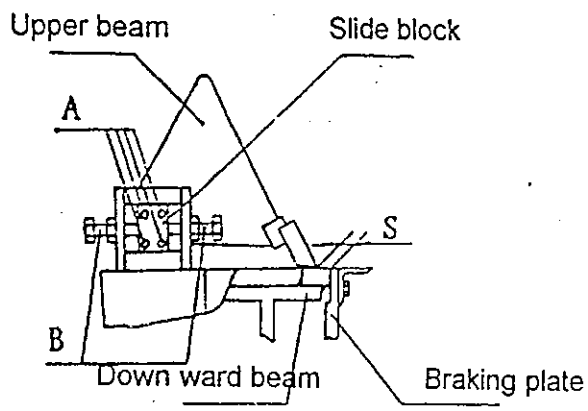
1. Side plate 2. Angle locating plate 3. Balance hammer 4. Upper beam 5. Strength steel of upward beam 6. Press blade 8.Cam bar 9. Cam pole 10. Cam 11. Adjusting slide bock 12. Braking plate seat 13. Braking plate 14. Strength steel of downward 15. Downward beam

Fig No 1. (b) Cam locking structure

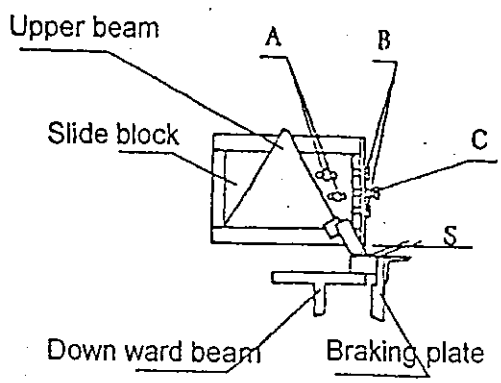
The operating design of the machine is a upper beam with a fixed down beam and a lower moveable beam which acts as a breaking structure when bending.

1. Adjusting the clearance S.

Loosen the securing screw A between the slide and the upward beam. Adjust screw B or C. The S=t (t=plate thickness).make the upward and downward blade parallel. After adjusting retighten bolt A. If S is too small the blade could be damaged during operation.



a. Cam locking folder



b. Bevel gear locking folder

Fig 2.

2. Adjusting the upward beam in the vertical direction. (Bevel gear locking machine).

If the error is on the vertical between the upward and downward beam. Loosen the left or right cover bolt, turn the square nut up or down to raise or lower the upper beam. When adjusted relock the cover bolt.

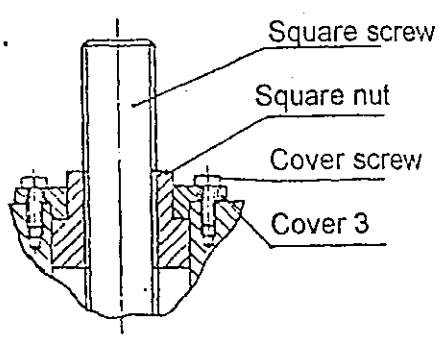
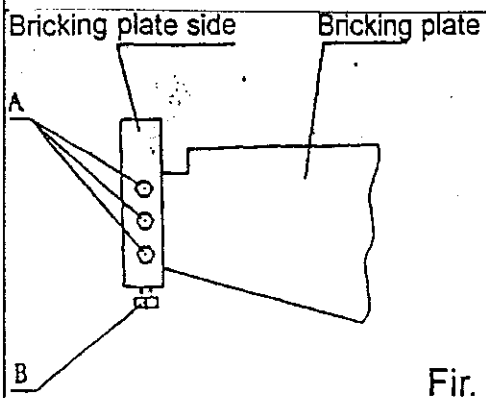


Fig No 3.

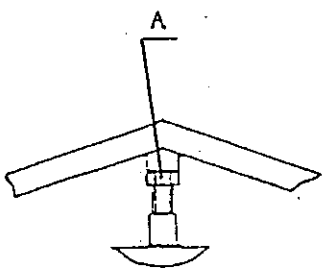
3. Adjusting the braking plate. Fig No 4.

Loosen the securing bolts on the two sides of the braking plate. Adjust the two end bolts B to bring the braking plate into the horizontal position. Lock bolts A to secure the blade.

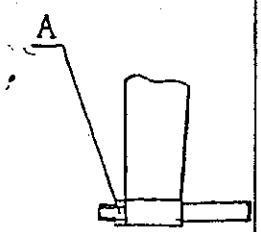


Fir. 4

Fir. 7



Fir. 5



Fir. 6

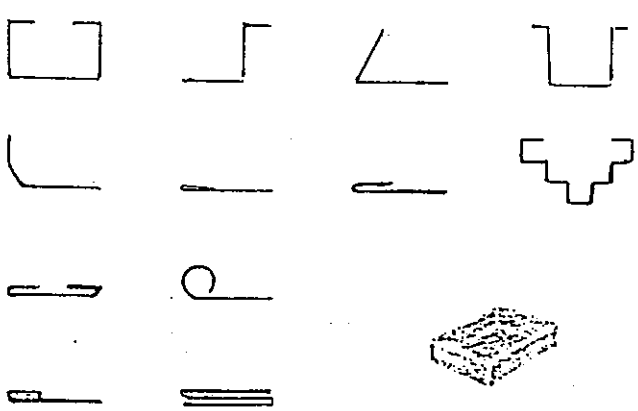
4. Adjusting the pretension and the leveling of the braking slide.

The bearing point of the upward beam and the braking is at the end. . when the machine folds the work piece and its found to be distorted. It is possible that the two side right angle are correct but the center angle Is incorrect.

The center angle can be adjusted by nut A. increasing the upper Beam, breaking plate pretension, See Fig No5. The machine center can Be adjusted to a height of 0.5mm to guarantee the work piece quality.

4. Operation and USE.

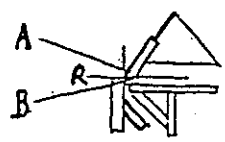
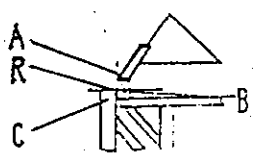
When using, adjust the Upward beam and the Breaking plate grip Between the upward And downward beam. Adjust the angle locating Plate wheel to the required Angle. the work piece will Be bent to the correct angle.



5. Maintainance.

- Ensure that the machine is cleaned and oiled every day.
- Check that the blade is set to the correct specification.
- Use full length of the blade to give uniform wear.
- Stand back from the balance hammer to avoid injury.
- Check and oil bearing every week.
- Secure the machine to a flat working surface.

Model WS hand Folder	Quality Certification	Total Page9
Max Plate Thickness	Max Plate Width	
Machine No.		

No.	Item Checked	Diagram	Standard	Actual
1	Tolerance between the down beam B and blade A.		0.10 / 1000	0.08 / 1000
2	Concentricity of the down, upper beam and joining plate.		0.20 / 1000	0.18 / 1000
3	Hand wheel turning system. Operational			
4	Testing Plate	Thickness: 0.1～0.9mm 1～1.5mm 1.6～2mm	0.3. 0.5. 0.8.	0.2 0.6 0.8

This machine has passed its final quality audit

Quality Control Inspector.

Signiture zhai yafei

Date 06.1.4