



Established 1930
Distributors of new & used workshop Equipment

S564 PB-820

HAND FOLDER

PANBRAKE 2500- X 2

OPERATION MANUAL

02-11-2001

S564 _____ 2/11/06

PANBRAKE PB820 2500 X 2

WS2×2500BE

HAND FOLDER

OPERATION MANUAL

MANUFACTURE DATE _____

SERIAL No _____

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OPERATION MANUAL

HAND FOLDER

Total P5

NoP2

1.INTRODUCE

Dear Customer

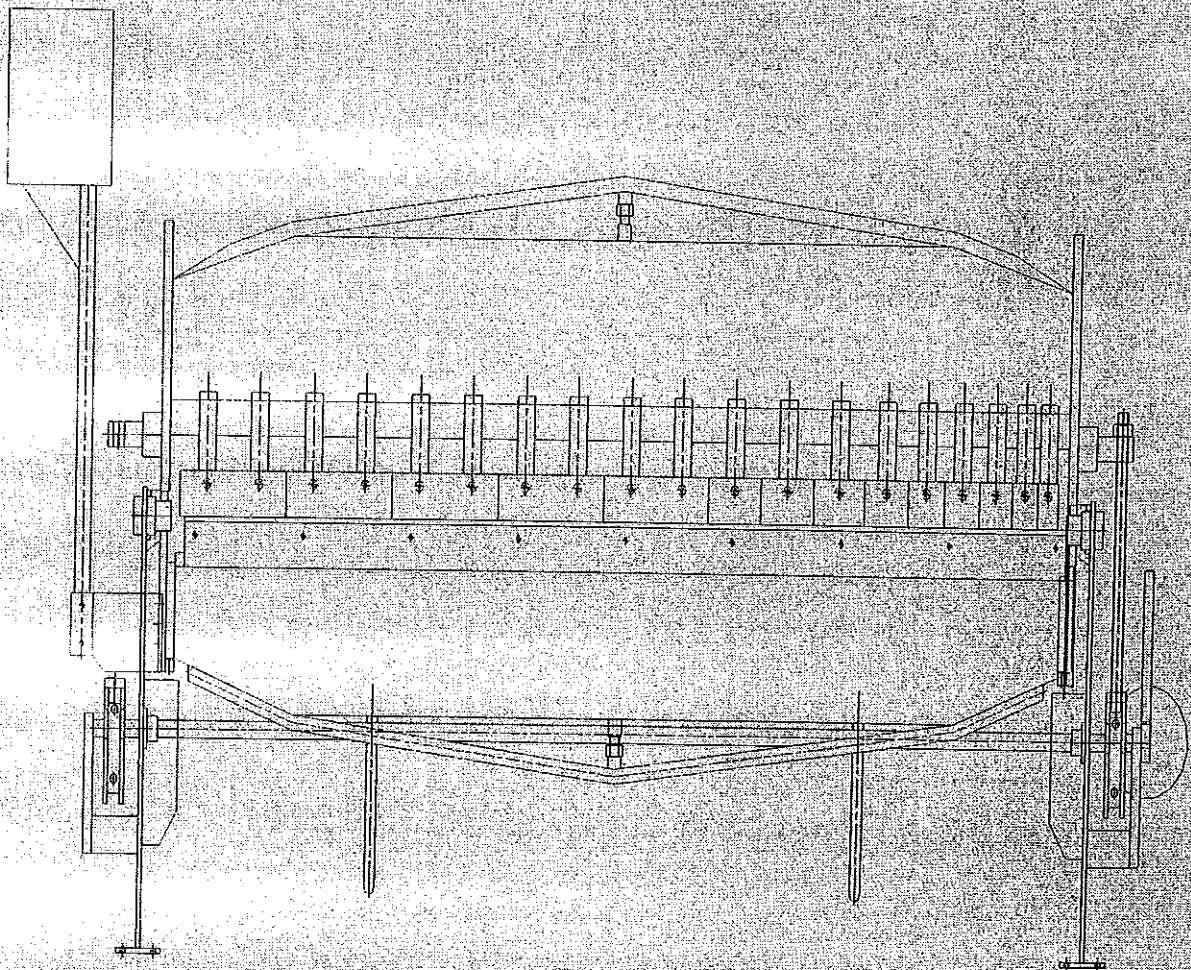
Firstly thank you for using JF machine!

The JF company is special manufacture metal machine factory. Main product: Duct Pittsburgh lock machine、Duct flange machine、Notching machine、Folder machine、Shear machine、Tennyng & wiring machine、Grooving bending machine、Three roller bending machine and different roll forming machine and so on.

The operation manual is to tell you how to install, operate and maintain JF machine file. It is very important to tell operator to maintain and operate machine in right way. The JF company gives your good way to operate machine.

If you need more information or special condition while operate machine, please contract us. (Please give us manufacture date, serial No)

In future, if the machine has been changed or its technology improved and be designed, JF company can't apprise you. JF company is very sorry.



OPERATION MANUAL

HAND FOLDER

Total P5

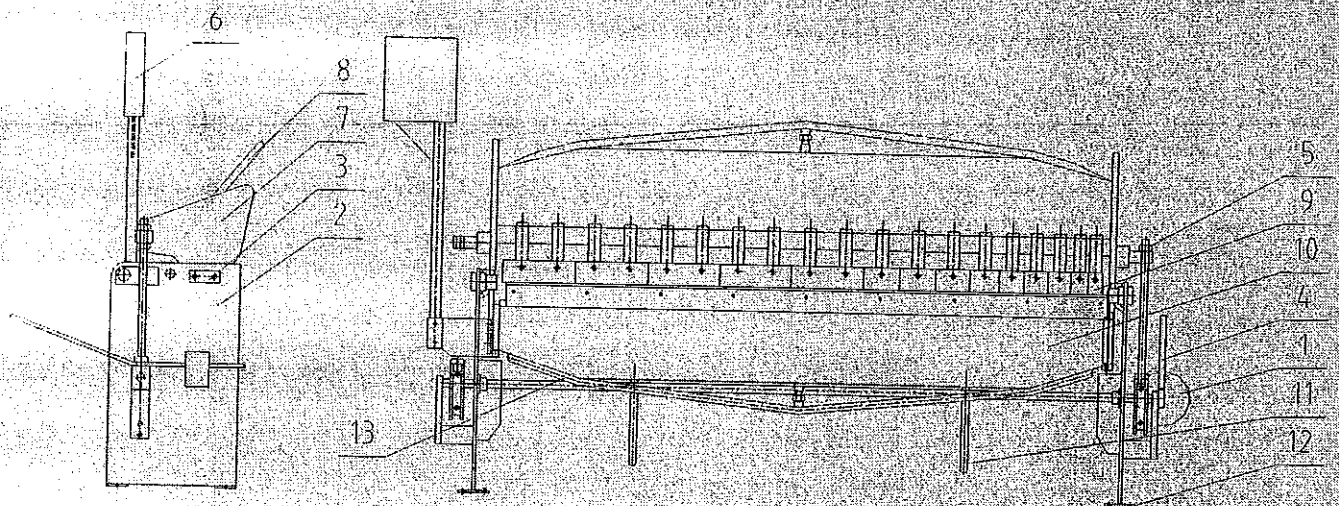
№P3

2. Use and Function

The WS2×2500BE Hand Folder is widely used for the folding and turning of armor plate, stainless steel and non-ferrous metal of less than two point five meters long with a thickness of one point five millimeter. It can be found in the manufacture of stainless steel kitchen equipment, metal furniture, lamps, hardware, air conditioning equipment and box sections for buses and so on.

The machine is fully worked by hand, and has lock gear. It can produce large quantities of work pieces of settled angle and specific shape.

The machine adopts lower blade settled and upper blade press. Then make use of the theory of table-flap turning over to process folding. The work pieces and tools aren't opposite movement and strike during the whole course so as to the surface of the work pieces are bright and clean. It's especially suitable for exigent work pieces.



3. Structure and adjusting instruction

1. Small balance hammers
2. Side block
3. adjusting slide block
4. press hand gap of upper beam
5. adjusting nut of upper beam
6. big balance hammer
7. upper beam
8. Strength steel of upward
9. upper clamber
10. table-flap
11. folding hand gap
12. Baseboard
13. strength steel of downward

OPERATION MANUAL

HAND FOLDER

Total P5

№P4

The machine consists of upper beam, lower beam and table-flap. The blade was adjusted rotative center when leave factory. Before using, client could adjust the blade according to the machine specification and thickness.

The adjustable part of the series of products are as follows:

1. The tolerance between the upper clamber and the folding blade.

Adjust the right and left slide block 3 so as to adjusting the tolerance of the upper beam and folding plate. The $S=1.3t$ (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.

2. Adjusting the prestress and straightness

The upper beam, lower beam and the supporting structure of the folding plate are distributing two sides. When folding work pieces, it appears stated flexibility leading the straight line angle of the work pieces get direct affect and when the two side right angles are correct but the center angles are incorrect. In order to prevent this affection, the machine could make the upper beam, lower beam and folding plate have direct prestress and the machine center can be adjusted to a height of 0.5mm to guarantee the work piece quality by nut A. (see fig two and three)

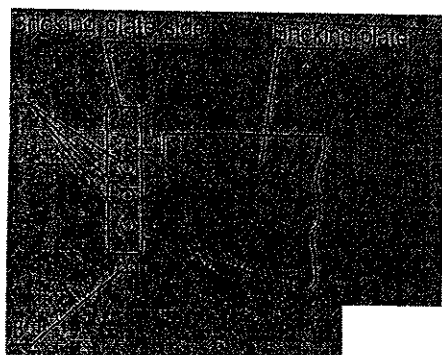


FIG 2

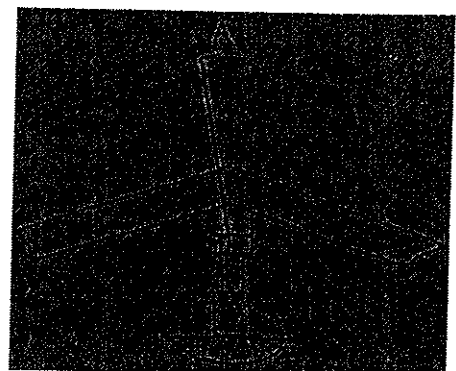


FIG 3

4. Operation

The machine is easy to operate, when using, adjust the upward beam and the braking 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.

The machine use 45 degree clamber which adopts divided blade. Users can assemble different length of the clamber to bent box sections in different measure. For example as follows.

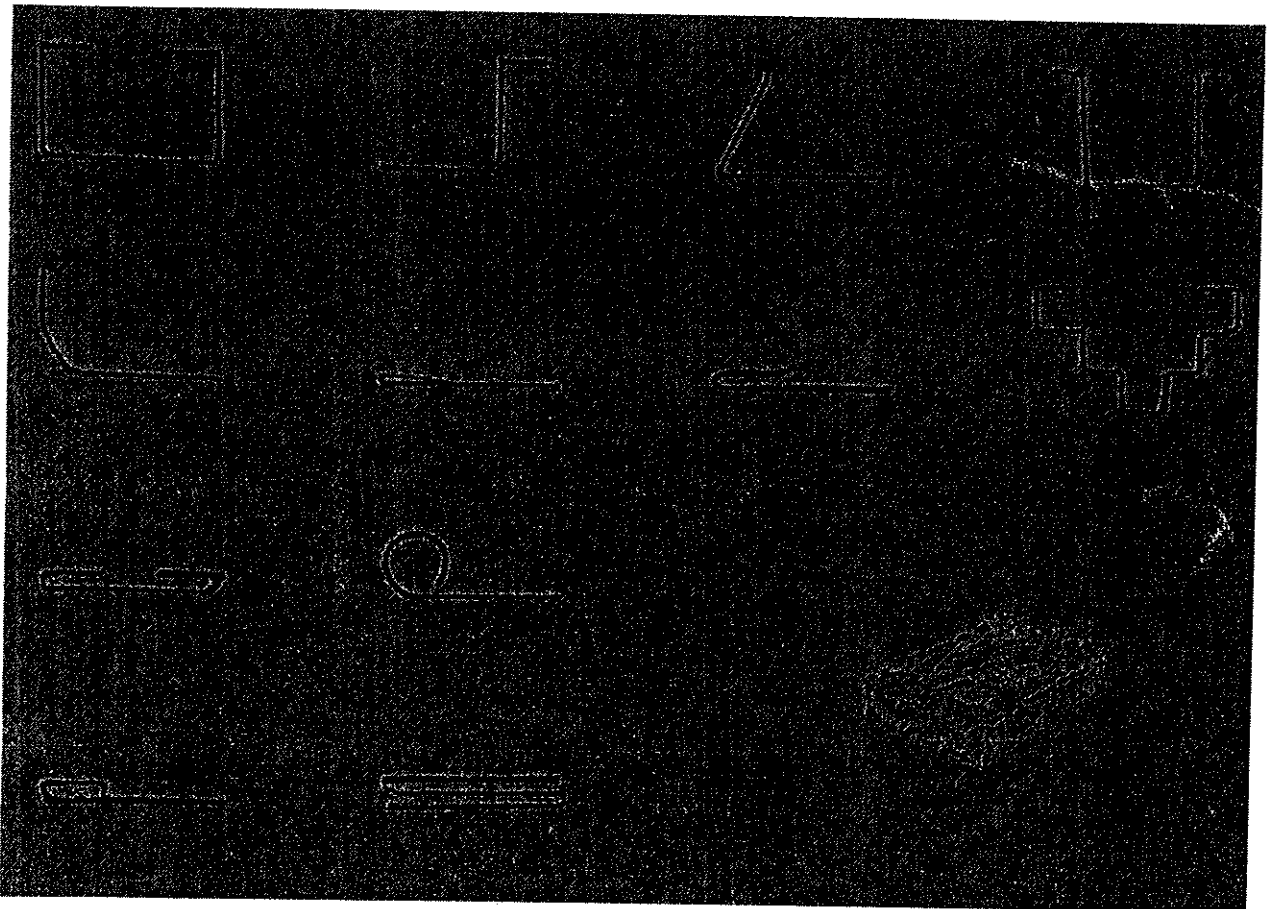


FIG 4

5. Logically use and maintain

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

Quality Certificate

WS-2×2500BE

N O.	Inspection program and measure	Standard requirement	Confo rmity	Non- confo rmity	sign
1	Paint	The painted surface should be smooth, glossy, with neither grains and burrs nor obvious roughness, blistering and blanching			
		The processing surface should not be stumbling, notchy and rusty			
		The handwriting that on all the nameplates is legible, upright and fast.			
		The immobility is exact , acclinic and deflective			
2	Noisy	There is no any anarchy, scream or other noisy that is made by improper assembly			
	Cleanness	Keep the machine clean, make sure there is no paint, dust, scrap iron or other impurity both inside and outside the machine			
			Allow	Fact	Sign
4	Geometrical precision	In the level ,the error among the impacted beam, worktable and mould is less than 0.15mm	0.15		
		The angle tolerance between the vertical joint of the mould of the folding beam and the worktable is no more than $\pm 1^\circ$	$\pm 1^\circ$		
5	Working precision	The straight line angle of the steel folding is above 1000mm,the length is less than 1mm	1mm		
		The angle tolerance is above 1000mm,the angle is no more than 2°	2°		
		The radii tolerance is above 1000mm,the radii is less than 1mm	1mm		

The machine was checked out, and we agree to sale.

Main checker:

Date :

WS2×2500BE HAND FOLDER

Packing list

No.	Model	Name	Quantity	Description
one	WS-2×2500	Hand folder		

Accessories and Tools

No.	Model	Name	Quantity	Description
one	five	hexagon ring spanner	One piece	
two	six	hexagon ring spanner	One piece	
three	eight	hexagon ring spanner	One piece	
four	ten	hexagon ring spanner	One piece	
five	Seventeen to nineteen	non-adjustable wrench	One piece	

WS2 × 2500BE
HAND FOLDER

Quality Certification

Model WS2X 2500BE

SERIAL No _____

MANUFACTURED Date: _____

THIS MACHINE HAS PASSED ITS FINAL QUALITY AUDIT

Inspector: 

Date: 2006.08

PLANT SAFETY PROGRAMME

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Stock Code: S564

Description: Panbrake Model: PB-820 2500 X 2 Brand: HAFCO

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
This program is based upon the Australian Worksafe Standard for Plant(NOHSC:1010-1994)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies (Recommended for Purchase / Buyer / User)
B	CRUSHING	LOW	Secure & support work material on table etc. Ensure machine is bolted down.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material offcuts.
F	STRIKING	MEDIUM	Ensure the area around the counter weight is kept clear.
Plant Safety Program to be read in conjunction with manufactures instructions			



ABN 96 000 286 957

"THE JUNCTION" 2 WINDSOR ROAD, NORTHMEAD NSW 2152
Phone (02) 9890 9111 Fax (02) 9890 3888

Authorised and signed by: _____
Safety officer: _____

Manager: 

Date: Mar-02