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ROLLS MACHINE

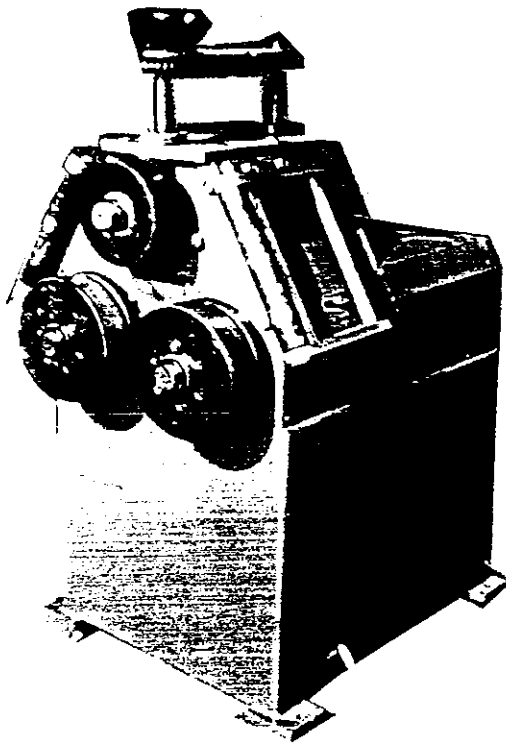
PARTS MANUAL

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Operation Manual of Our Angle bending rolls Machine



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1.Product Introduction :

With the rapid development of construction , decoration , hardware , light industry and chemistry , the traditional manual way to work out hardware products , neither in quantity nor in quality , can meet the need of our society nowadays . Accordingly , we have designed and manufactured a series of hardware-processing machines . As a combination of merits from the same type machines in the world , our product can satisfy you with its advanced-built structure , wide-fitting use , stable performance and its convenience to handle .

What we have to do when operating this vertical tube-and-angle bending rolls machine is to change the rolling wheels . Therefore , we can process different kinds of iron or steel material (steel tube / pipe , round steel , angle steel or channel steel) by curving or rolling them round . To meet the various needs in process (e.g. big or small material) , we have two types of this machine for your choice , i.e. WB500 and WB750. You are guaranteed of the quality . Using believes and your kindly order is welcome .

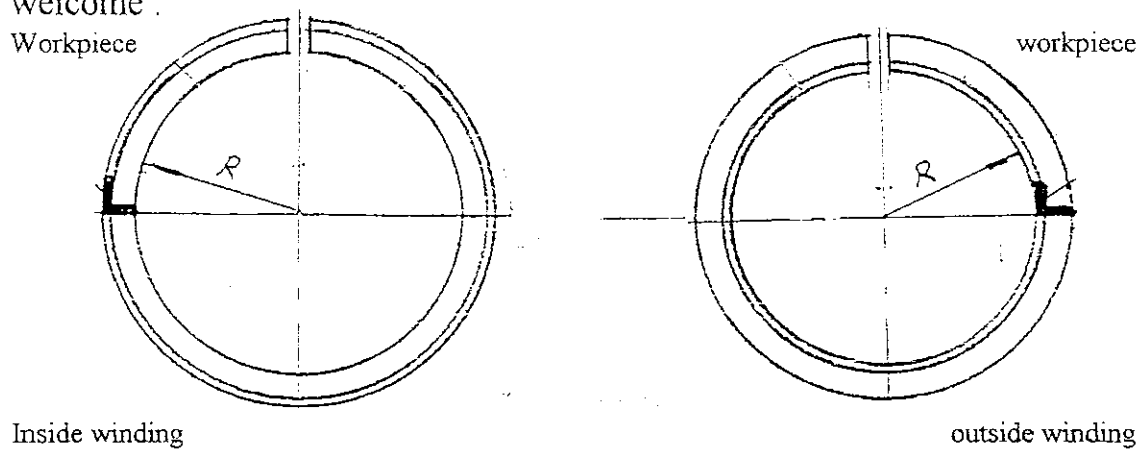


Figure 1 : angle steel's inside & outside winding

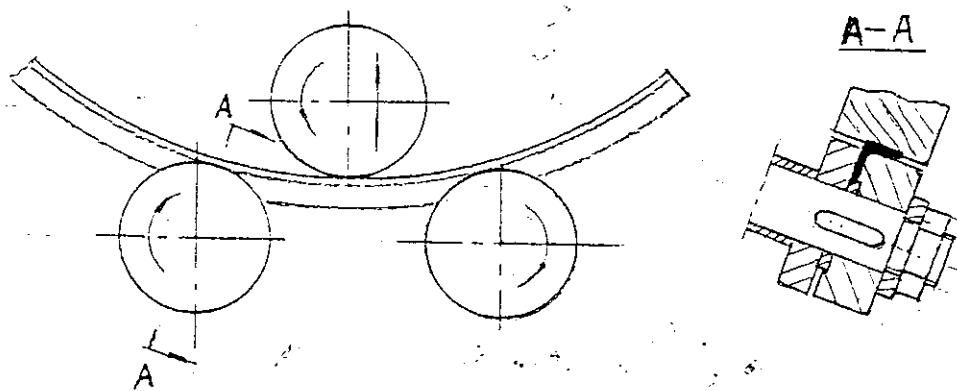


Figure 2 : sketch map shows the shaping of steel material

2. Technical Data :

(1).Main Technical Data :

Item \ Type	WB 500	WB 750
Capacity	L 40 x 40	L 60 x 60
Min. Circular-winding	400	500
Diameter rolling Line speed (m/min)	6.2	5.9
Norms of motor	380 V 1430 r.p.m 3 kW	380 V 1430 r.p.m 4 kW
Contour size (L.W.H)	700 x 750 x1250	750 x 800 x 1350
Weight (kg)	500	600

(2).Strength limits (reference index)

Type \ Item	Steel-shaping standard	Min. circular winding radius	Curving model
WB 500	L40 x 40	450	outside winding
	L 40 x40	420	inside winding
	Φ 42 seamless steel tube	400	
WB 750	L60 x 60	650	outside winding
	L60 x 60	620	inside winding
	Φ 65 seamless steel tube	600	

3. Structure :

- (1). Machine stand : it is fitted up with angle steel and steel plate welded together ; on the right side of it there fixed an electric switch (see Figure 3).
- (2). Transmission mechanism : it is composed of one motor , Group A triangle belt , Group A worm gear and worm , and a Group A gear wheel .
- (3). Working installation : it is made of two towing wheels , one pressing wheel and two spacing collars .
- (4). Operation installation : it concludes two things: one is the package of leading screw and slide block which controls the pressing wheel's up-and-down movement ; the other is a pedal electric switch which controls the directions the towing wheels turn .

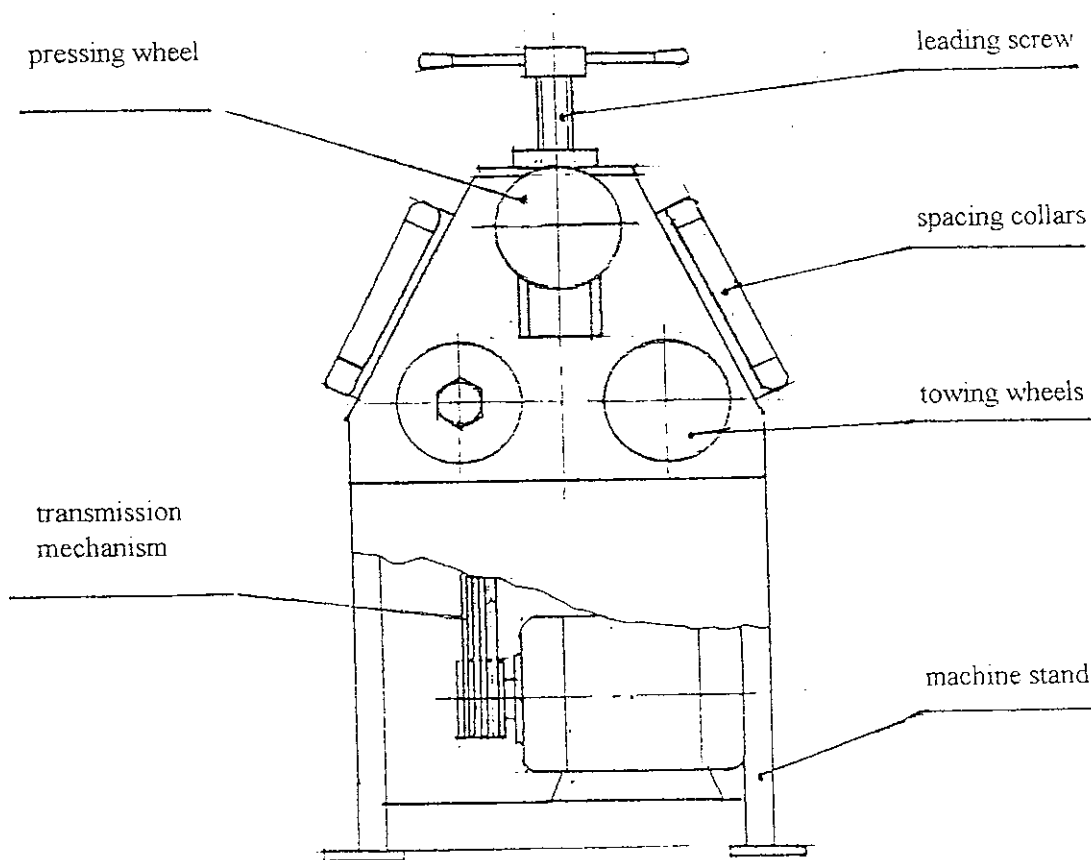


Figure 3 : structure sketch

4. Ways to operate and things to take care :

- (1) Adjust the position of the spacing collars according to the needed circular-winding diameter.
- (2) Fix the towing wheels and the pressing wheel which should rightly suit to different kinds of material you are going to shape .
- (3) Switch on the power , then , let it run idling for several times . Don't stop the machine until you are sure it is functioning normally.
- (4) Before fixing the workpiece , clean the surface of it and don't have any ironsheet or sand remain on it .
- (5) Now the workpiece is fixed . Next to do is to handle the leading screw and slide block to move the pressing wheel down , and at the same time press the workpiece down properly.
- (6) Begin the circular-winding by exchanging the clockwise and anticlockwise movement to turn the towing wheels . After the whole workpiece has been shaped to the relevant curvature , move down the pressing wheel once more (the down-movement of the pressing wheel each time should be proper , never too much , especially for those big workpieces), and then turn the towing wheels again to roll it round for the second time . Repeat the same operation procedure until the workpiece reaches its curved radius .

Note : In the process of being curved , the workpiece will have a straight side about 80mm long remained at both ends . So , if the workpiece should be shaped into a whole circle , technological treatment must be dealt with very carefully .

- (7) When processing angle iron of varied standards , we must use some fitting spacers , so as to guarantee that when the rolling wheels are at work , there should remain a proper clearance between the workpiece and the wheels .

When outside-winding , one rightangle side of the workpiece is inserted in the grooves of the two towing wheels . The groove width can be adjusted by spacers (which are attached to the machine) . While inside-winding , one of the workpiece's right-angle sides is also inserted in the groove of the pressing wheel , and the adjustment of the groove width is just the same .

- (8) The standard of the material to be shaped cannot exceed the maximum limitation in order not to have the machine run overloaded .
- (9) When the machine is at work processing a workpiece , no head or hands are allowed to reach the forbidden region , for it is dangerous .

- (10) The maintenance of the machine must not be done until the machine stops and the power is switched off .

5. Maintenance :

- (1) Examine regularly the tightness degree of the triangle belt , and make some proper adjustment when necessary .
- (2) Examine regularly the lubricating oil chamber in the decelerator of worm gear and worm to add the lubricating oil in time .
- (3) Add regularly some lubricating grease to the gears and the bearings . Don't stain any oil on the surface of the pressing wheel and the towing wheels .
- (4) The leading screw , the slide block and the slide way should be always kept clean . Keep any dirt such as iron sheet from remaining on them , and add lubricating oil to them frequently .

6. Parts attached to the machine :

Attached to the machine is a set of rolling wheels (a pressing wheel and two towing wheels) . As usual , we offer rolling-wheels for winding angle iron . If a customer prefers the rolling wheels for shaping some other kinds of material , he can demand so . But only one set of rolling wheels are provided .

If more sets of rolling wheels are demanded , then the payment for these wheels is absolutely necessary .

7. Service for repair :

- (1) We provide our clients with free service to repair the machine within half a year from the day the product is sold . But this service is carried out only on the condition that the breakdown is not artificial or man-made .
- (2) If there is anything wrong with the machine in use, we will offer to repair it any time .