

S766 PR256 2500x210x6MM

21/12/04

3 Roller Bending Machine.

Model

W₁₁ -6 x 2500.

Operation Manual

Model No. W₁₁ - 6 x 2500

S766

Serial No. 1061701

Manufactured Date: 2004. 7. 19

WARNING

ENSURE T-BAR IS ALWAYS WOUND
FULLY UP DURING NORMAL
OPERATION OR DAMAGE WILL
OCCUR WHEN ROLLS ARE RAISED

INDEX.

1. Machine Construction.
2. Main Technical Specification.
3. Driving Systems..
4. Use and Adjustment,.
5. Electrical Systems.
6. Lubrication.
7. Maintenance and safety.
8. Unpacking and Inspection.
9. Quality Certification.

Operation Manual.

3 Roller Bending Machine

Total P8

No. P2

1. Machine Construction and Use.

The machine is designed to roll flat plate into round or canister shape which in turn can be used for the manufacture of ventilation or sewage pipes also chimneys for the exhausting of air. This type of pipe is especially suited for buildings that have environmental regulations.

The working area required for the bending machine is not large, while its operation is simple. Adjustment for different diameter materials is an easy task to perform. The machine is constructed with welded steel plate to give a rigid working platform in which is housed the drive system for the rollers.

Designed to function by a symmetrical 3-roller unit, which is driven by two motors. The rolling speed is appropriate to the diameter of the plate to be rolled. Transformation of the flat plate into the round is performed without the surface or the tensile quality being affected. The operation and adjustment of the machine is very easy.

2. Technical Specifications.

Model	Max Bending Thickness	Max Bending Width.	Main Motor.	Feeding Motor.	Gear Model.	Break Model.
W ₁₁ -6 x 2500	6mm.	2500.	415V/5.5KW	415V/2.2KW.	ZQ40-2(40: 1).	TJ2-100

Operation Manual

3 Roller Bending Machine

Total P8

No. P3

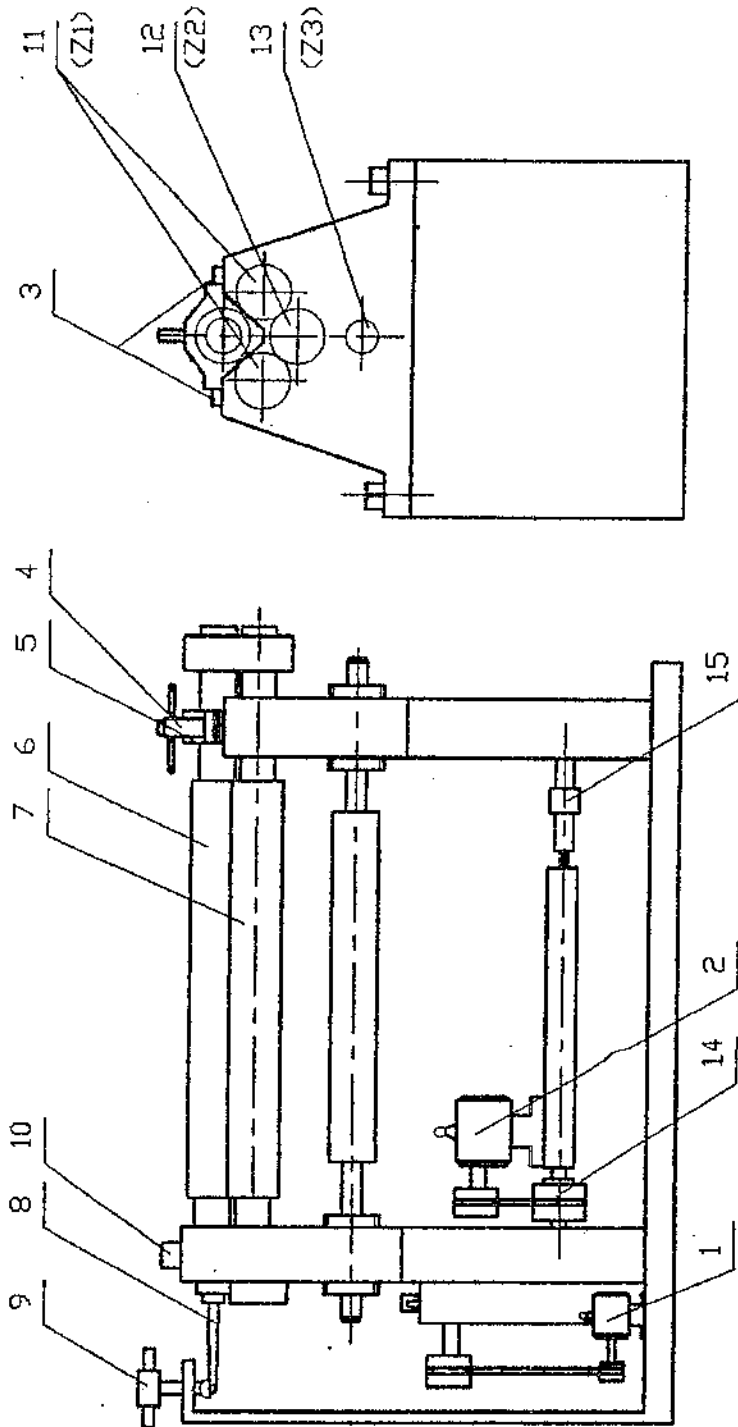


FIG 1.

1. Main motor
2. Up and down motor
3. Oil tank
4. Nut with handle
5. Bearing cover
6. Upper roller
7. Lower roller
8. Ball bush steel
9. Down press stud
10. Slid block
11. Down roller gear Z1
12. Inter grade gear Z2
13. Gear out gear Z3
14. Upper lower drive wheels
15. Coupling.

Operation Manual

3 Roller Bending Machine

Total P8

No. P5

4. Operation and Adjustment.

Operation of the machine.

Place flat steel plate between the upper and lower rollers. Then start the up and down motor 2, the upper roller presses down onto the work piece. Start the main motor 1. The lower roller will start to rotate driving the driving the upper roller.

In steps increase the pressure of the upper roller. The right roller rotates, while the opposite roller turns to give a cylindrical work piece or can shape.

The work piece is on the upper roller 6 Fig 1. to unload the work piece loosen the securing wheel 4 Fig 1. open the upper cover 5 Fig 1 loosen the stud 9 Fig 1 then press the ball bush of the upper roller. Start the up and down motor 2 Fig 1 the upper roller will rise. You can now remove the work piece

When you find the upper and lower rollers are not parallel you need to adjust the rollers. First loosen the left connecting rod four screws 15 Fig 1. rotate wheel 14 Fig 1 by hand in order to adjust the upper roller right end by 0.1mm with every rotation of the drive belt wheel.

5. Electrical System.

The machine uses a three-phase AC motor, which, is able to be rotated and inched by the inching button. The required power supply being 380V 50Z.

Operating Instructions.

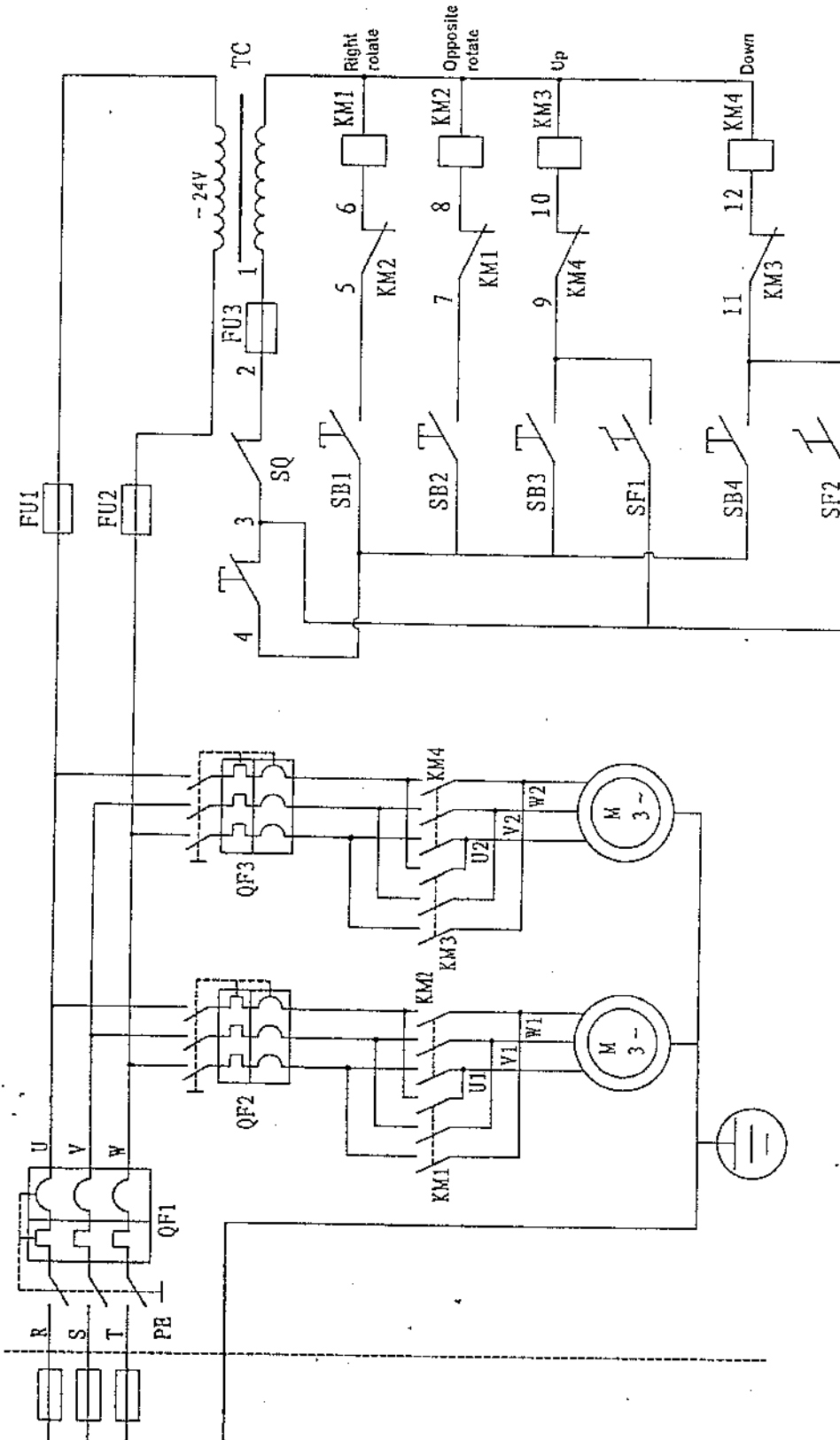
1. Switch on the mains power supply. Power indicator lights on.
2. Push down 1AN. The down roller motor rotates in a forward direction..
3. Push down 2AN. The down roller motor rotates backward.
4. Push down 3AN The upper roller motor, rotates forward and the top roller rises.
5. Push down 4AN. The upper roller motor rotates backwards and the top roller moves downwards.

Operation Manual

3 Roller Bending Machine

Total P8

No. P6



Electric control system diagram Fig 3

Operation Manual

3 Roller Bending Machine

Total P8

No. P7

6. Lubrication.

- 1) Before adjusting the upper rollers up, you should loosen stud 9 see fig 1, then start the motor. When operating the machine, you should open the gearbox oil hole to add lubricating oil up to the full line, you should lubricate the driving gear surface and grease, add oil every month as required.
- 2) Add lubricating oil to the two-sided oil tanks (3) daily.
- 3) Add lubricating oil to the upper roller bearing glass (11) daily.
- 4) Open the upper roller bearing cover (5), add oil daily.

7. Maintenance and Safety.

Maintenance.

- 1) Check all bearing surface for overheating reduce the machines speed, grease and lubricate as required.
- 2) Check the V-belts for being loose, Adjust oir rep[lace if worn or loose.
- 3) Keep all working surfaces clean and free of waste materials.
- 4) Check all electrical connections, the two motors and switches ensuring that the earth connections are good.

Safety.

- 1) Ensure all covers are closed before operating the machine.
- 2) When the machine is not in use it should be isolated from the electrical supply.
- 3) Before adjusting the Upper Roller Up. Loosen stud (see Fig 1 then start the motor.

8. Unpacking and Inspection.

Unpacking.

- a. When unpacking the machine from a shipping container ensure that all lifting is by the use of certified lifting strops.
- b. Ensure that the machine does not tip over on lifting.

Operation Manual.

3 Roller Bending Machine

Total P8

No. P8

- c. Unpacking from a transportation crate, follow the instruction from the packing note. Using the opening points as indicated on the packing crate.

FAILURE TO FOLLOW THESE INSTRUCTIONS COULD LEAD TO DAMAGE OF THE MACHINE.

Inspection.

- a. Inspect all parts before use for damage. Inform ACL Fefeng Machine Company or its agent in the event of any inoperative parts or damage to the machine.
- b. Check all oil reservoirs are full of oil, refilling as required.
- c. Inspect all moving parts for grease or oil, greasing or oiling as needed.

3 Roller Bending Machine

MODELS

W₁₁-6×2500

Quality Certification.

Model No. W₁₁-6×2500

Serial No. 1061701

Date of manufactured. 2004.7.19

This machine has passed its final quality audit.

Inspector:

Date: