



Established 1930

Distributors of new & used workshop Equipment

S780

R1050 X 56MM

SHEETMETAL ROLLS

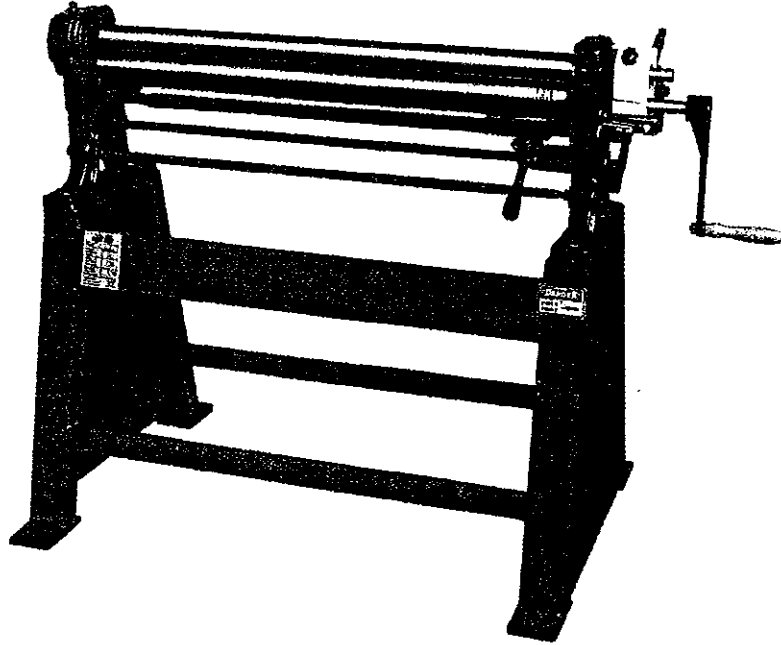
MANUAL

4-01-2003



sahinler
METAL MAKİNE ENDÜSTRİ A.Ş.

USER'S MANUAL
MODEL R
3 ROLLS MANUAL
PLATE BENDING MACHINE



Izmir Yolu 22.km Mümin Gençođlu Cad. 16285 BURSA / TURKEY

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ŞAHİNLER
METAL MAKİNE ENDÜSTRİ A.Ş.



CE DECLARATION

We as

ŞAHİNLER METAL MAKİNE END. A.Ş.
İzmir Yolu 22.km
Mümin Gençoğlu Caddesi
Bursa / TÜRKİYE

confirm that the machine

MODEL R 1050 x 56

Serial Number :
Production Year :

complies with

EC MACHINES DIRECTIVE 98 / 37 / EWG / CEE
replaced with **EC-Directives 91 / 368 / EWG and**
93 / 44 / EWG and
93 / 68 / CEE
EC-Low Voltage 73 / 23 / EWG
EC - Noise Level Directives 86 / 188 / EWG

and the machine also harmonized with the standards

DIN EN 60204 Part 1

Name : Orhan ŞAHİN
Position : General Director

BURSA, on

1.SAFETY

1.1 SAFETY NOTES

The THREE ROLL BENDING MACHINE is supplied with necessary guards to protect from injuries by Worm-type Gearbox and other gears.The only other area which needs to be carefully monitored during use is the rotational area of the rolls.Also abuses and misuses should cause following problems:

- Serious Injury of the user
- Serious damage to the machine

All persons who is in charge of the machine should carefully read and fully understand this manual for the benefit of themselves.

This is for your safety!

Beware!

Never try to bend very hard or fragile material on the machine(e.g. hard steel, glass) it may explode and cause serious injury to the user and to the machine.

Any modification on the machine without written confirmation from the manufacturer is strictly forbidden as such changes in machine can cause unintended damages and injuries.

All orders and advises in this machine should be strictly obeyed for a safe working environment.

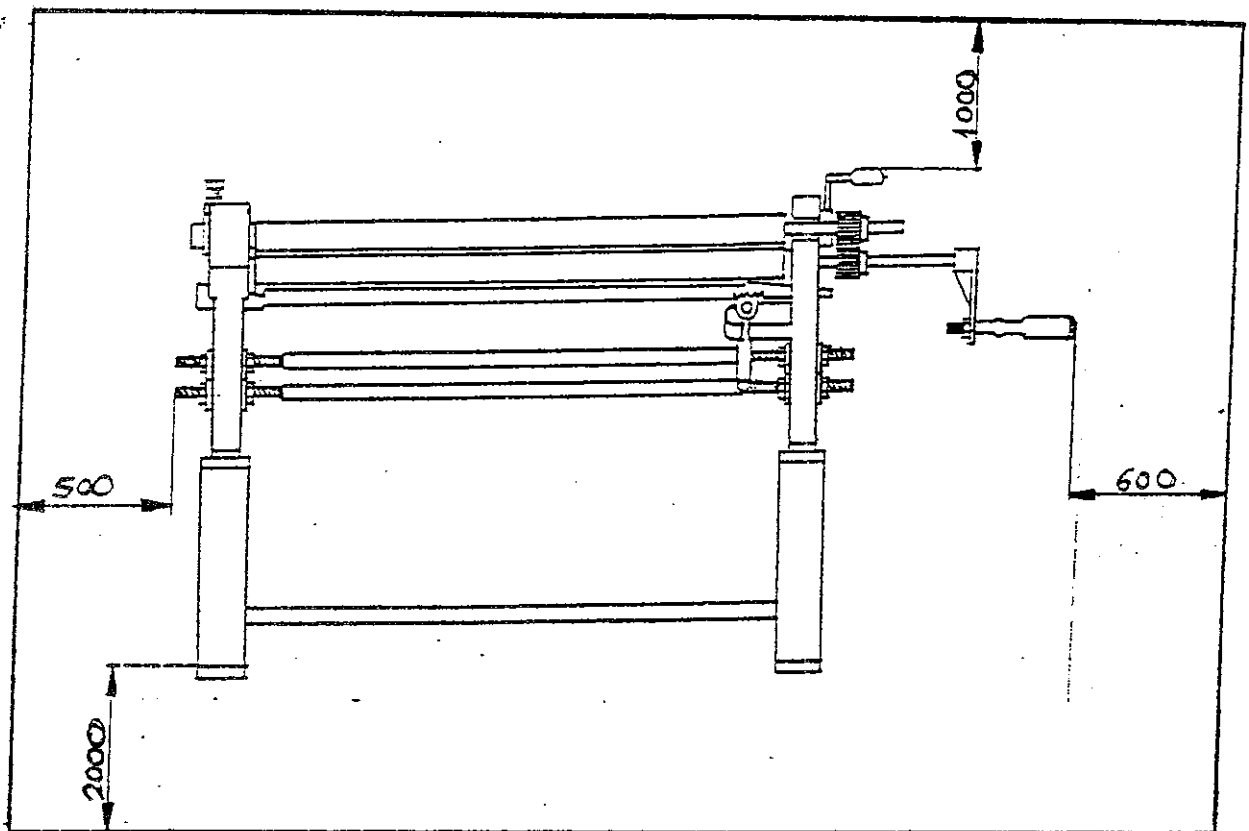
1.2. SUITABLE WORKING DIRECTIONS

Primary Operations of the machine :Sheet Plate Bending and Sheet Plate Conical Bending.

Conical bending is not suitable for serial manufacturing.

1.3. WORKING AREA OF THE MACHINE

Before setting up the machine check the dimensions on the diagram below.



1.4. EQUIPMENT DANGER

When load or unloading the machine, if you use another carrying connection, the protection arrangement and user equipment can be used position.

1.5. NOISE

The Noise level for this machine is strictly under 70 db.

1.6. DANGER ZONES

The rolling area of the machine is the most dangerous area as it can not be guarded. Only the user himself is responsible for his safety. Even the danger here is not very significant and avoidable following points must be done in case of any emergency.

-Never remove any guards before completely stopping the machine.

1.7. WORKING AREA

The user must be careful for third persons entering the operation area of the machine. Material should be feeded only from the front of the machine.

No material should be feeded if the machine is running.

1.8. PERSONNEL

Personnel under age of 16 years to operate the machine is strictly forbidden.

The Operator of the machine should carefully read this manual and understand the dangers he might be in if he misuses or abuses the machine. If any part of this manual is unreadable or illegible please contact the dealer and manufacturer.

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

1.9. PERSONNEL PROTECTION

No special protection equipment is needed during the normal operation of the machine . only hand gloves are recommended to avoid minor cuts in the hand which may be caused by the material.

1.10. PROTECTION ON SETUP (LOOK FOUNDATION PLAN)

The machine must be firmly and rigidly bolted to the ground. An unsteady machine have the risk of over-dropping and may cause serious personnel injury and can even be fatal. Also while setting up the machine you must place it so that all caution signs on the machine is visible and readable. All emergency stops must be easily accessible.

1.11. IMPORTANT POINTS

The machine must be used by qualified and technical personnel at all times.

All modifications and changes on the machine without the written confirmation of manufacturer is forbidden and if such a case occurs all responsibilities of the manufacturer will be out of consideration.

Any such modification is also breaking of European Norms and Laws.

The machine can be stored and used in closed areas however beware not to put it near any explosive , flammable or in any way dangerous articles.

In case of any use of non-original spares or accessories and in case of injuries then , the manufacturer will not be responsible of such claims.

Beware of third persons entering the operation area of the machine.

Beware of any obstacles entering the operation area of the machine.

If any damage occurs on the machine whether it is visible or hearable stop the machine and inform your dealer or manufacturer.

2.PROTECT (COVER) ARRANGMENT

The protecting arrangements of THE MACHINE showing in the following pages.
Here is the check list for protect arrangement.

PLEASE CONTROL THIS PROTECT ARRANGMENT

- Before working everytime
- 1 time a week
- After every repair

Control this list too

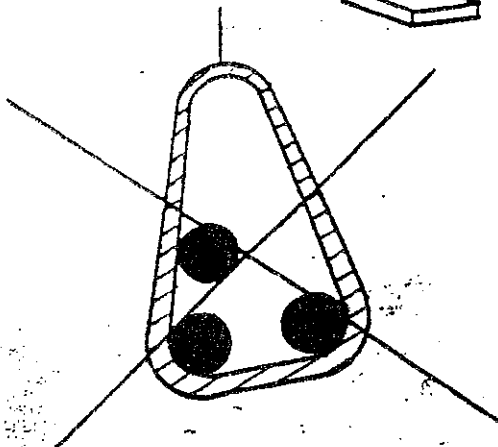
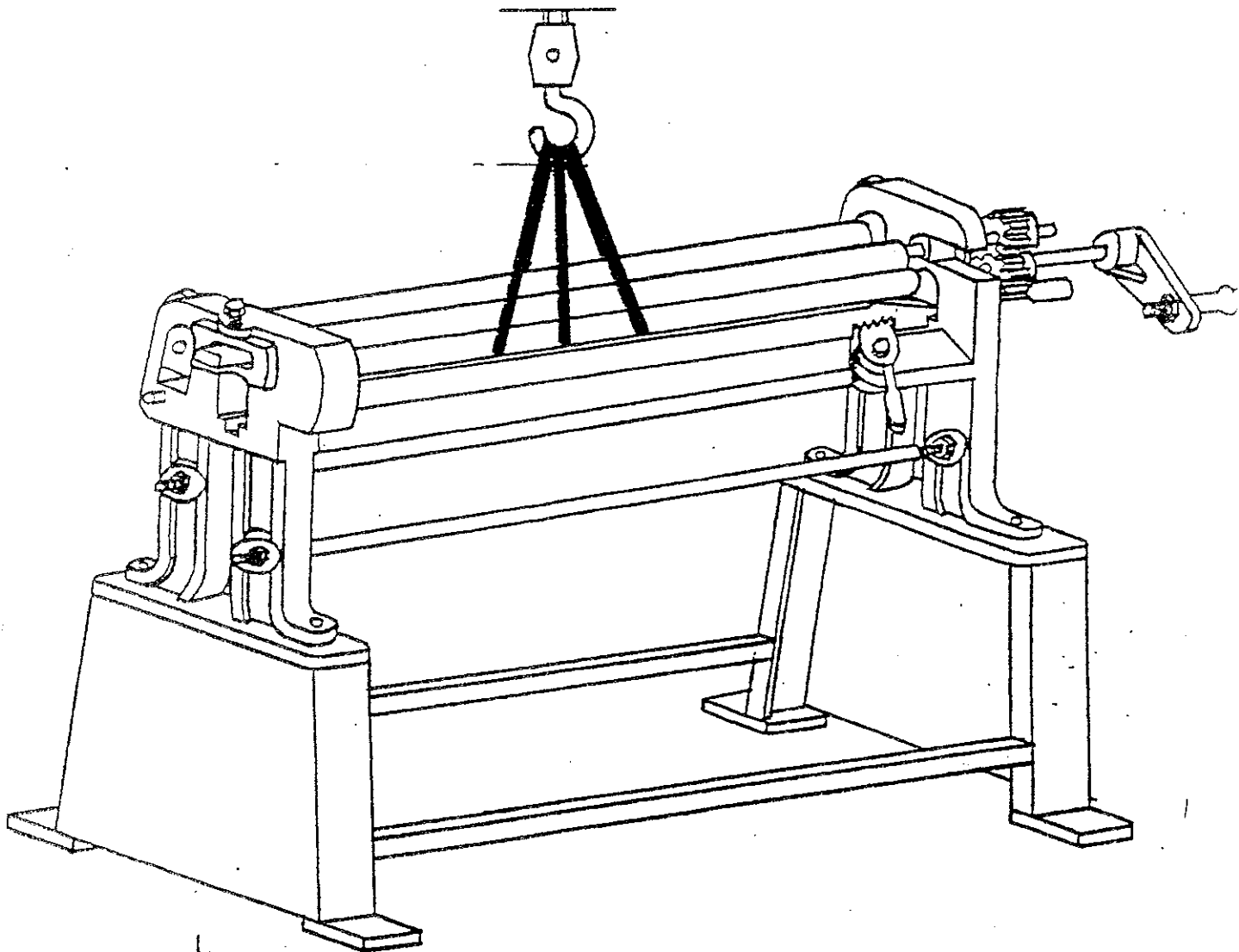
- Written directions
- Written situations
- Written functions
- To fixing these

Please supply all of these controls before working the machine. When you see anything wrong while working , please stop the mechine urgently and supply the thing which is wrong. Don't change the protecting directions anytime.

3. SETTING UP

3.1. Carrying and Hauling

The following scetch must be used while the machine is transported with a crane. Any damages occuring during transportation will not be covered by our varranty.



3.2. OPENING THE PACKAGE

If any visible damage exist on the machine when you receive the machine immediately inform the dealer or manufacturer. Also never forget to state the visible damage on transport documents.

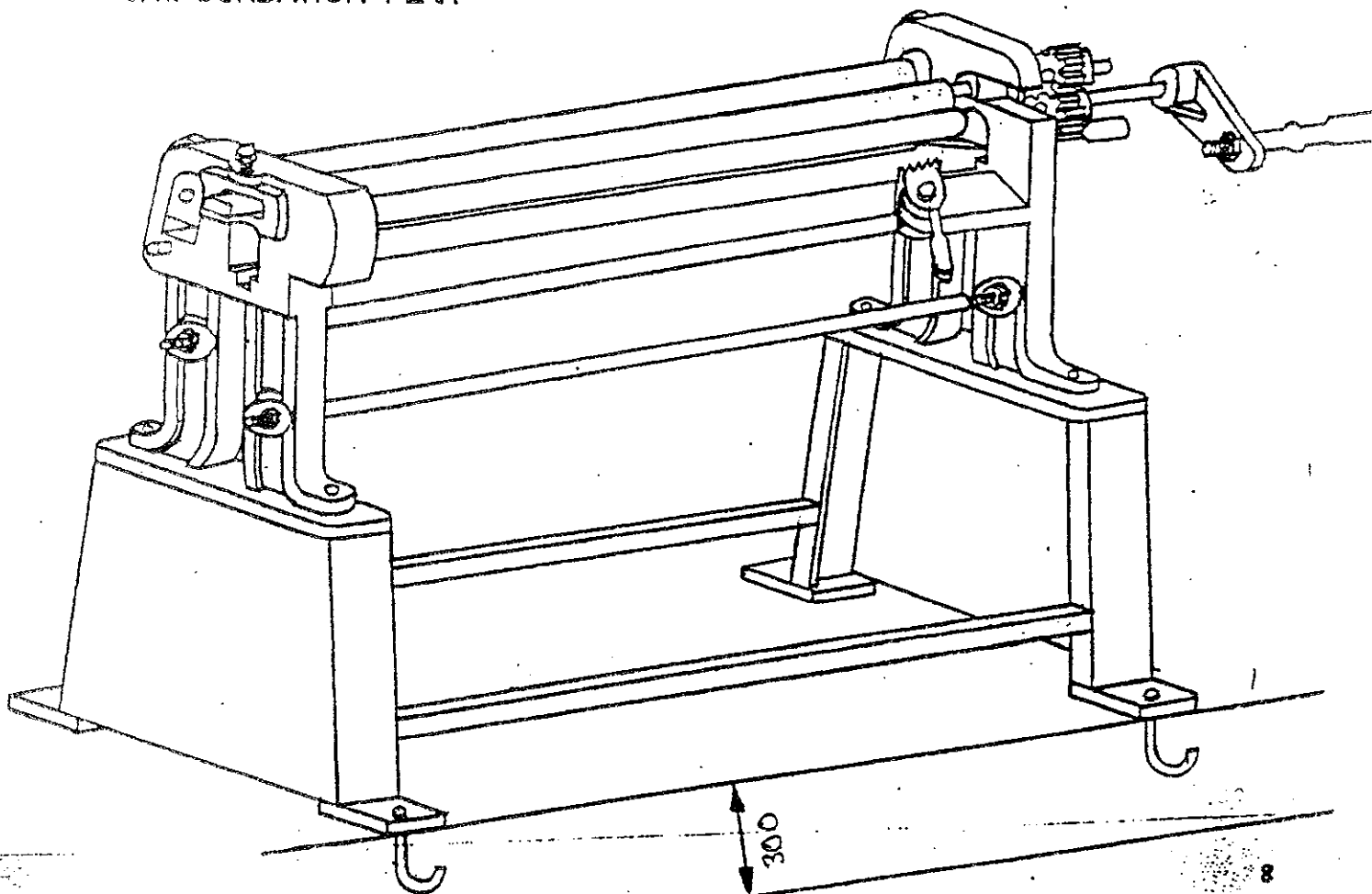
The packing material is completely safe and do not consist any environmentally dangerous articles. However they must be kept out of reach of children as some nylon products in packing may cause suffocation if used as a toy etc.

3.3. SETTING UP

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.

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

3.4. FOUNDATION PLAN



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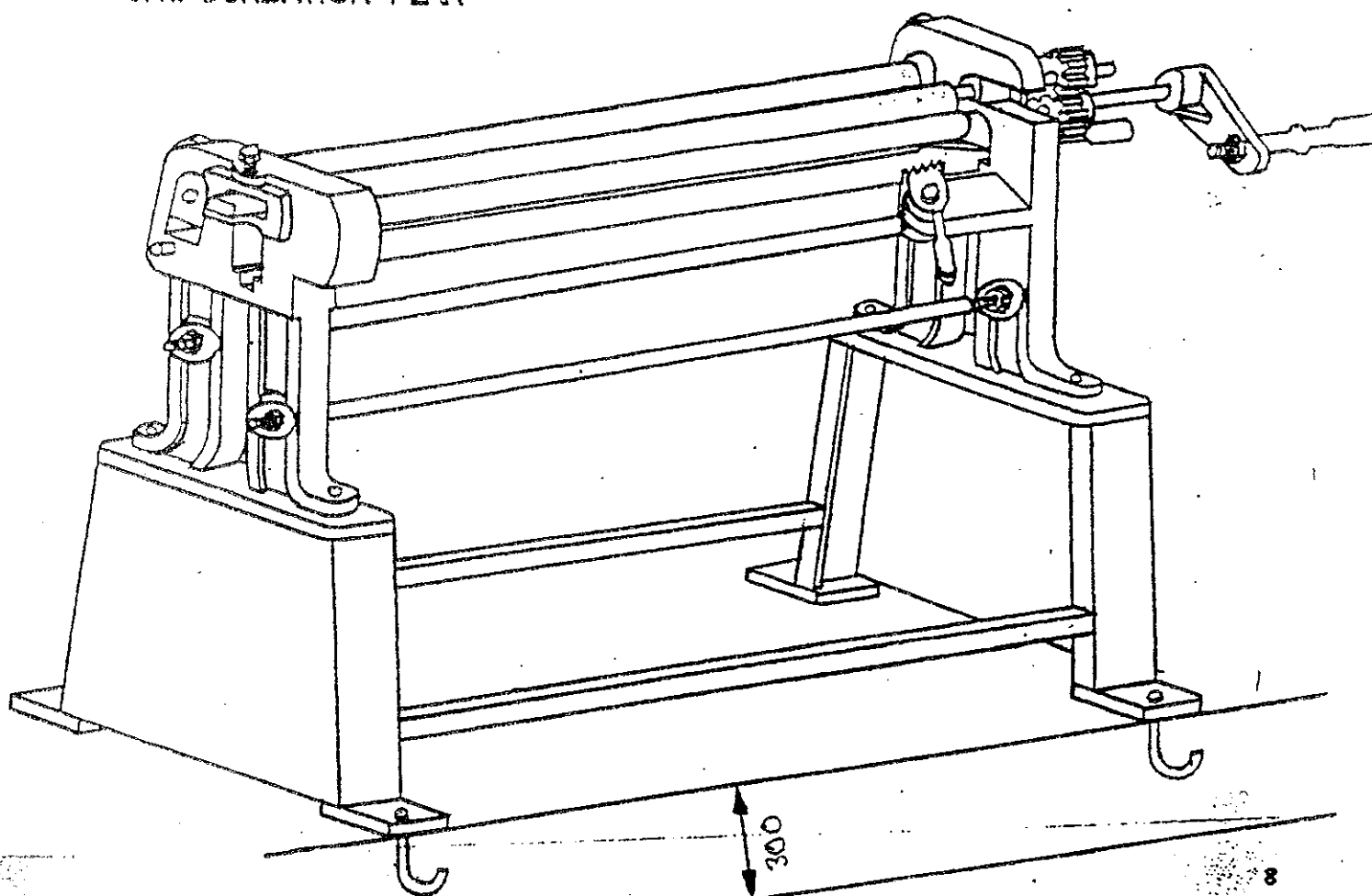
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3.3. SETTING UP

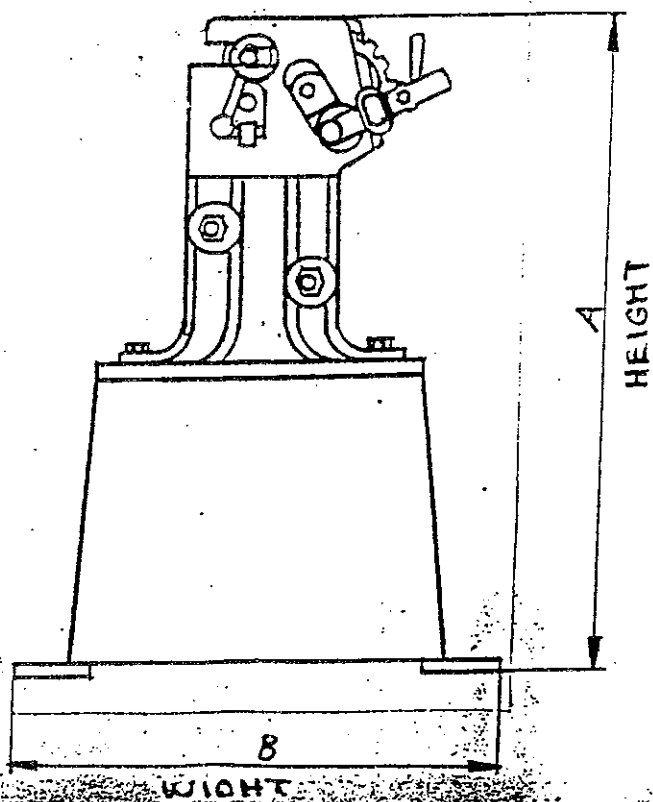
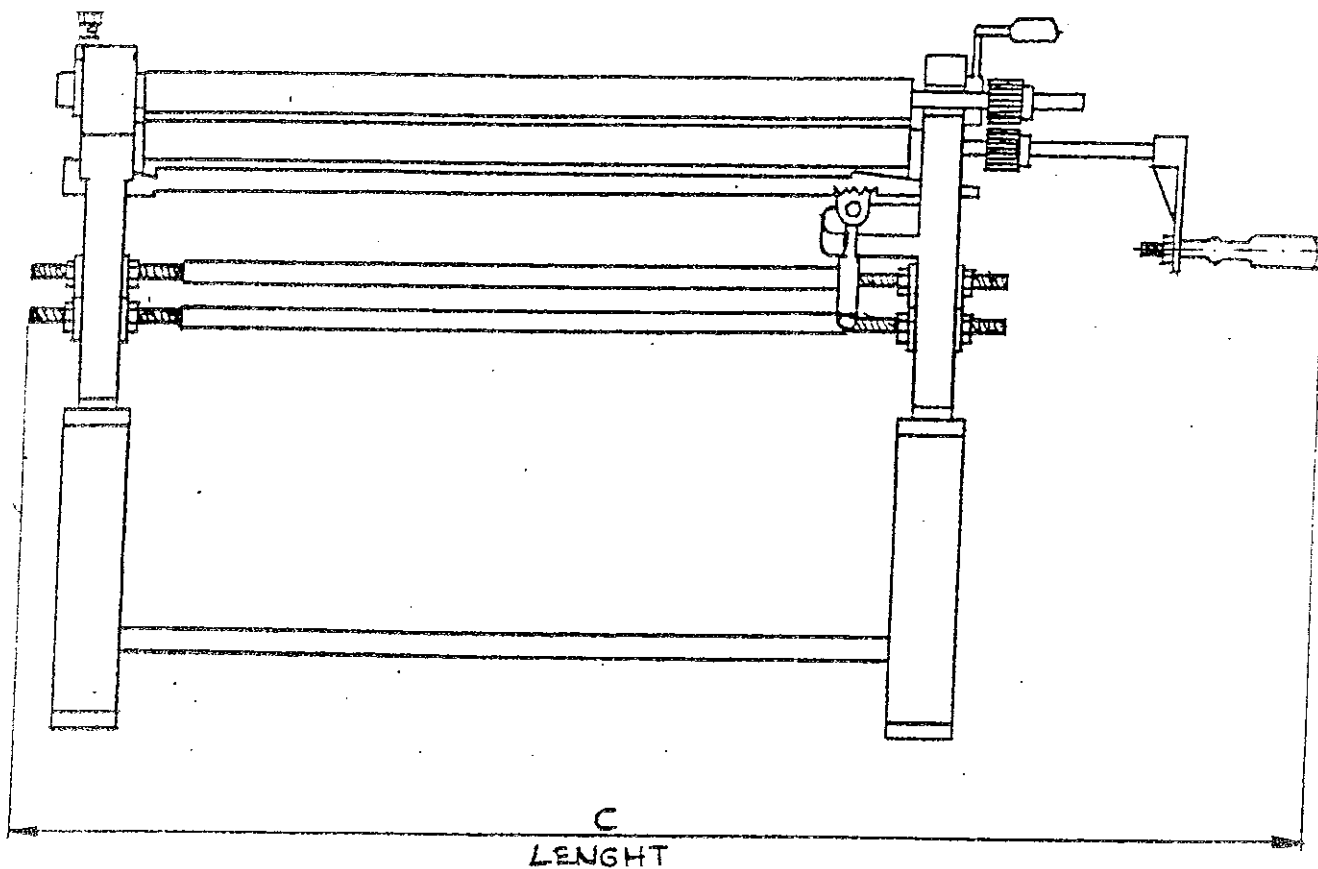
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3.4. FOUNDATION PLAN



4.1 MACHINE DIMENSIONS



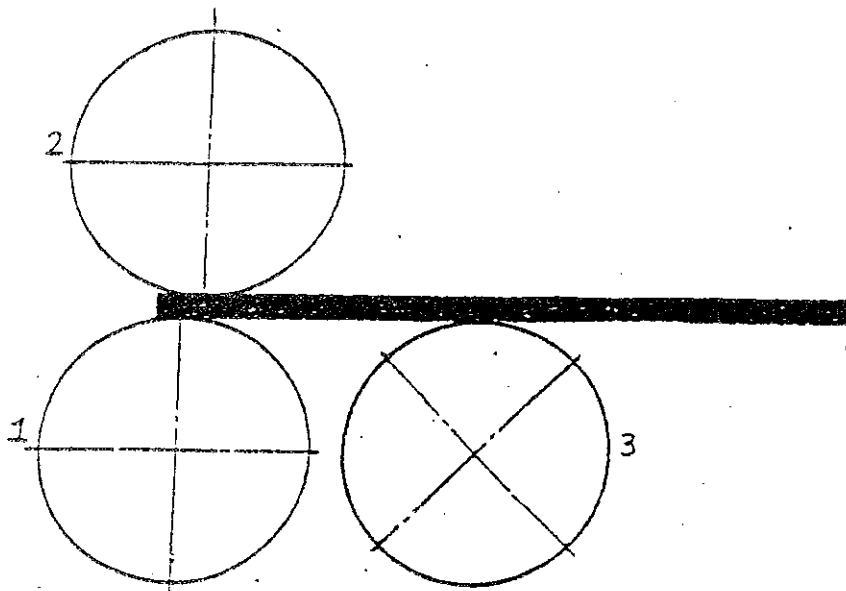
5.1. SHEET BENDING POSITION

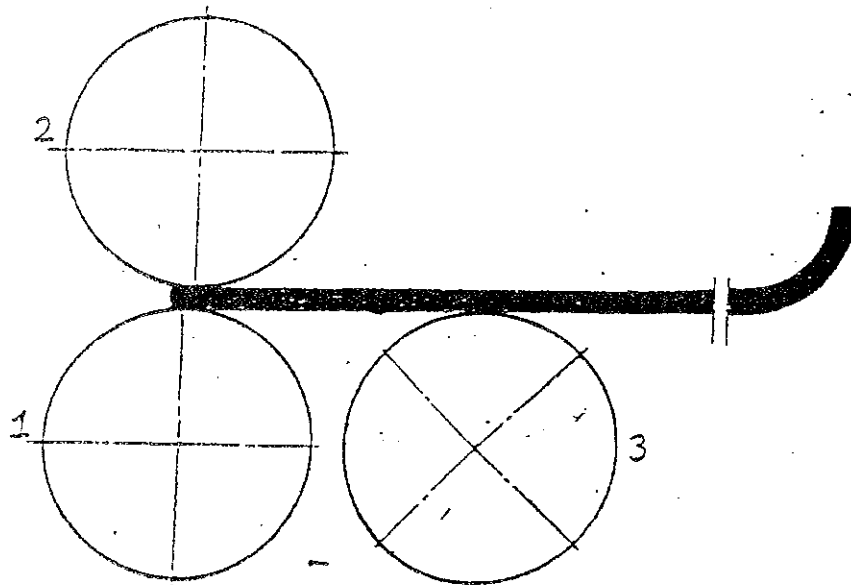
The sheet bending operation consists of three parts

- a) Pre-bending
- b) Changing the sheet and bending the end of the sheet
- c) Bending and roll bending

a) Pre-bending Operation

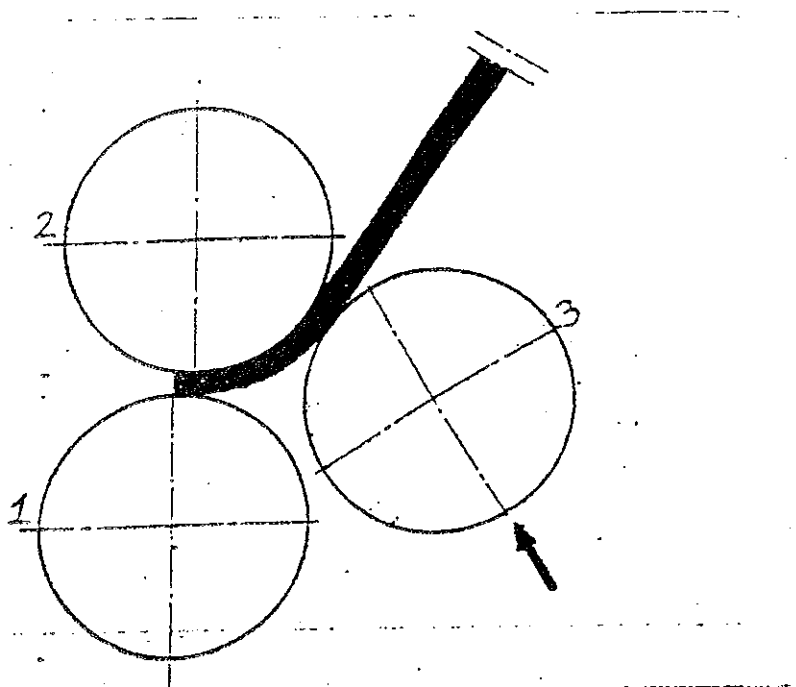
- 1) 3th roll must be at down position
- 2) 1st roll ,should be used exantric bar, it must be at down position
- 3) Sheet must be replaced on the down rolls as shown in the figure
- 4) Bending roll must be at up position

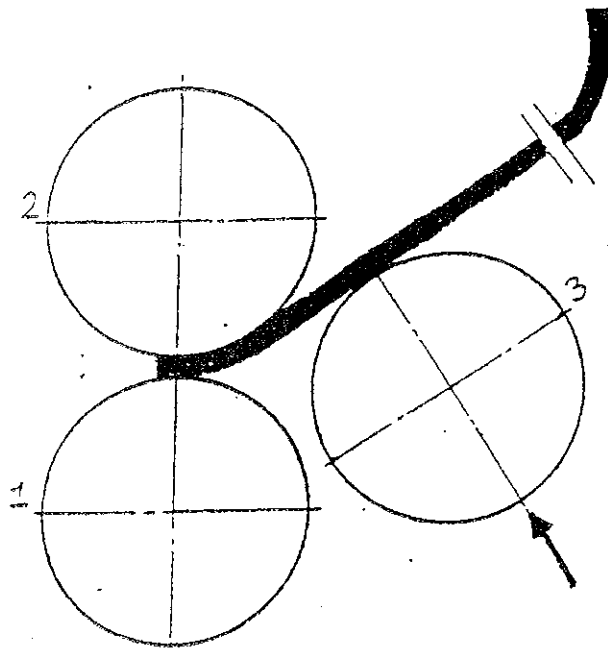




b) Last Bending

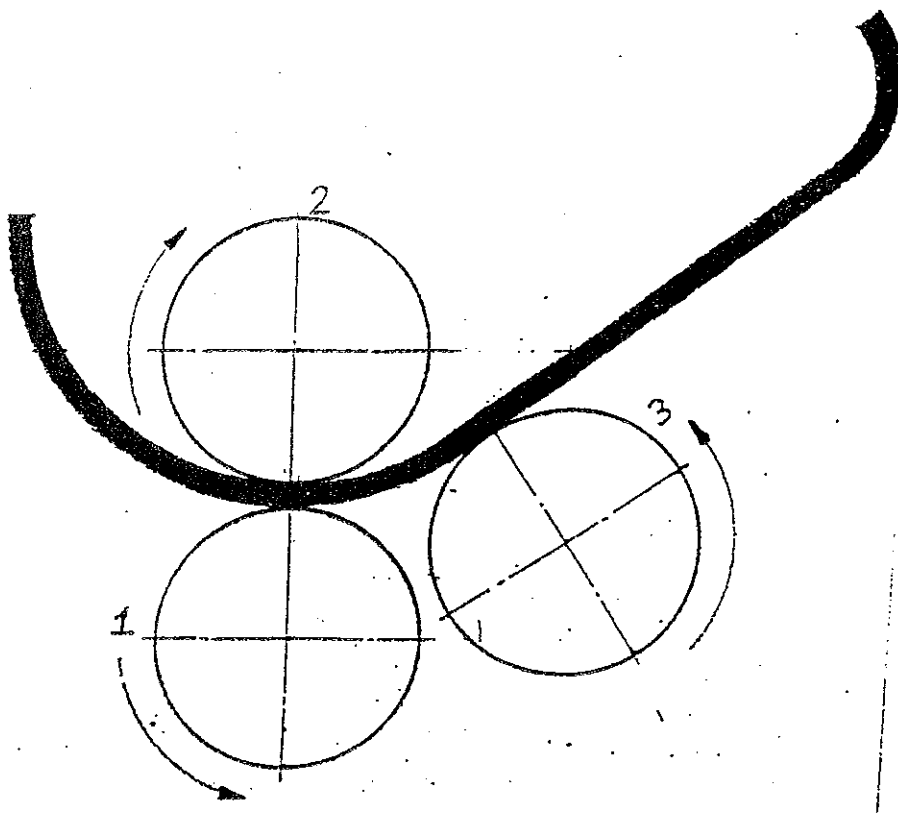
1) Change the sheet, and do the same things at pre-bending

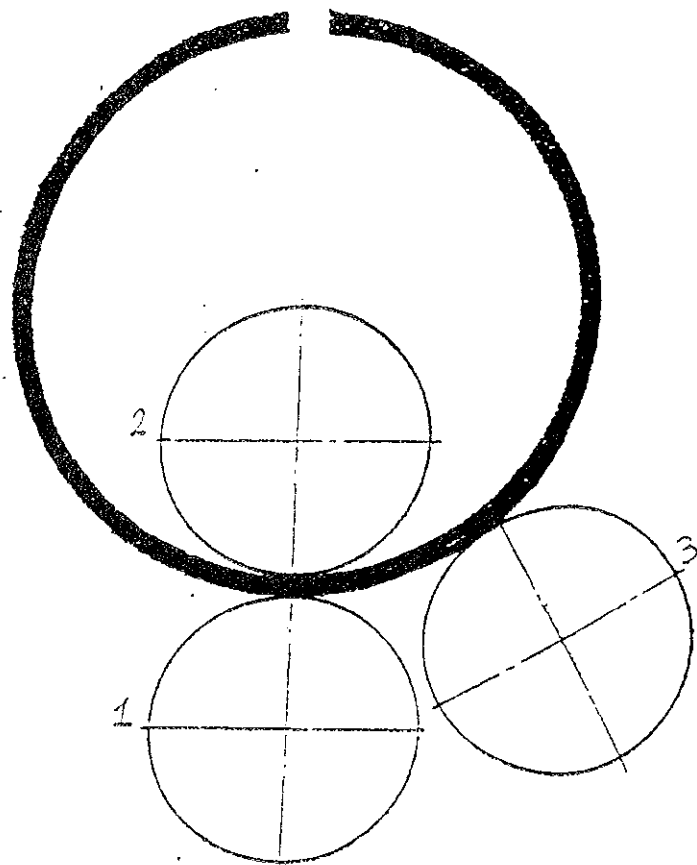




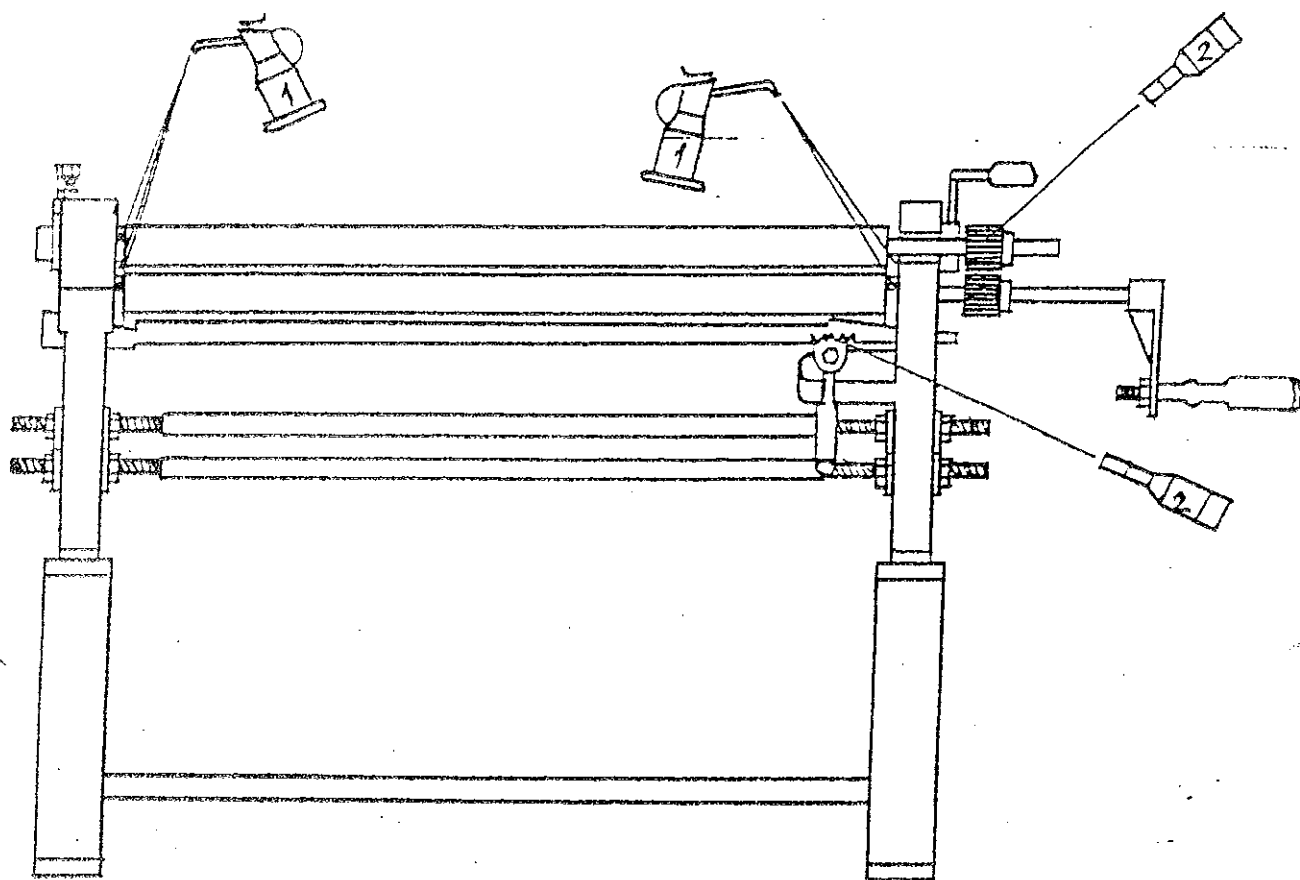
c) Bending and Cylinder Bending

Start to roll the sheet and bend it since it comes as a cylinder figure as shown at the picture.



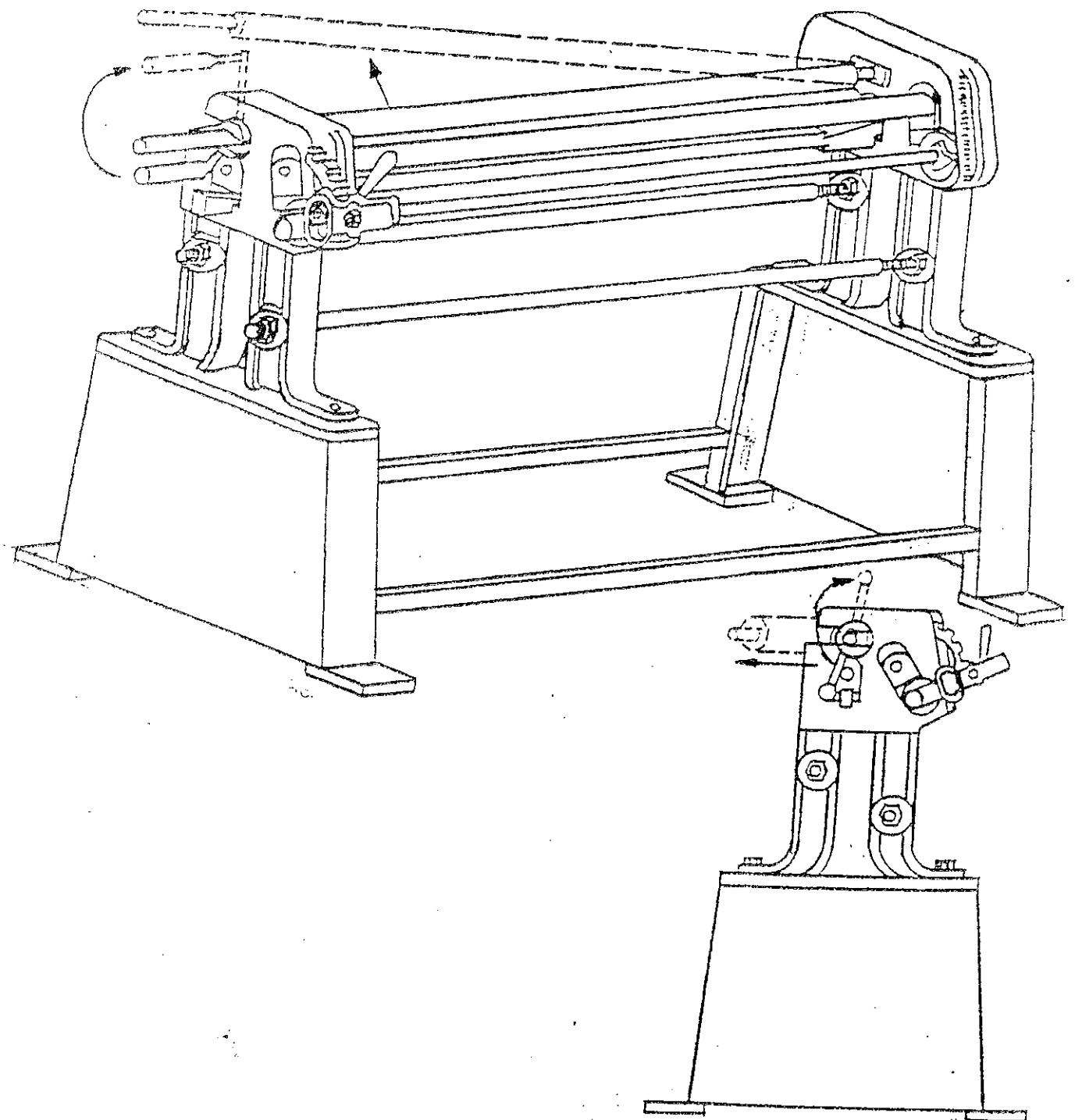


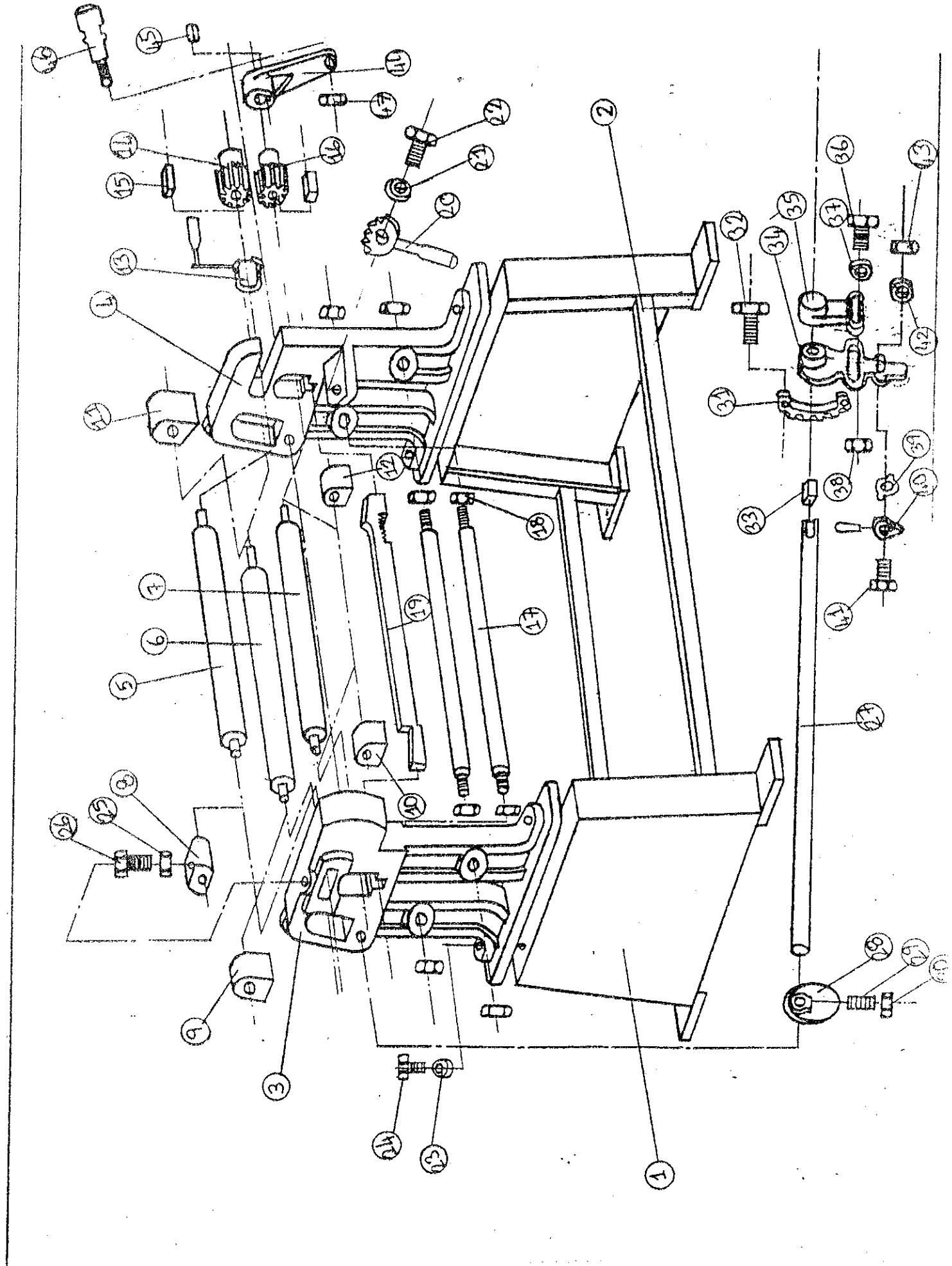
6.LUBRICATION PLAN



1. LINA
2. SAE 30

7. OPENING TOP ROLL







PARTS LIST

Assembly No	Part Identification
1	Frame leg
2	Support bar
3	Main frame
4	Main frame
5	Top roll
6	Idle roll
7	Bottom roll
8	Top roll bushing
9	Idle roll bushing
10	Bottom roll bushing
11	Idle roll bushing
12	Bottom roll bushing
13	Top roll removal lever
14	Top roll gear
15	Pin
16	Bottom roll gear
17	Support shaft
18	Nut
19	Bottom roll leverage pin
20	Bottom roll movement lever
21	Nut
22	Bolt
23	Nut
24	Bolt
25	Centering nut
26	Centering bolt
27	Idle roll movement shaft
28	Idle movement bushing
29	Idle movement bushing bolt
30	Nut
31	Pinion
32	Pinion bolt
33	Pin
34	Idle roll lever
35	Idle roll lever part
36	Bolt
37	Nut
38	Nut
39	Nut
40	Rack
41	Rack bolt
42	Nut
43	Bolt
44	Lever
45	Lever pin
46	Manuel power hand lever
47	Hand lever bolt