

#21741

DIRECTIONS FOR USE OF 30"  
3 IN 1 COMBINATION OF SHEAR,  
BRAKE AND ROLL

(3) When you move, install, clean and adjust the machine tool, you must keep away from the shears.

(4) Put down the protecting cover when you don't use the sliding roll of the roll machine.

(5) Keep your hands from the die when you are working on it.

(6) Operators must be familiar with the structure and function of this machine tool. protecting mask and the other safety devices should be used when you work on it.

(7) Focus your attention on the machine and do not operate when someone are near by the machine.

(8) Any metal plate that thickness and quality goes beyond the scope that the machining demands should be refused to process.

4. Generally, the operating handle was installed on the right side of the machine tool (Left is also acceptable).

5. Back-measure plate (Angle iron)

Back-measure plate is used for shearing and braking, when it is in the place of braking condition. Please screw two long bars into the nut of the concave mould palte, ensure that the bars pass through the front part of the concave mould palte, tighten up the nut and then back-measure palte and concave mould palte can move up and down in company.

When it is in the place of shearing condition, before putting the bars into the positioning plate, screw 2-M12 nut into the positioning plate

and then followed the bar which was fixed by the nut in the end

In these two kinds of position, the circular adjustable knob was installed at the back of angle iron.

6. Adjustment of the braking installation.

(1) Adjustment of the upper die:

Loosen the screw bolt, the upper die will come off the machine.

If you don't want the upper die come off the machine or you willing to install another new mould plate, you can put a piece of hard wood (25 x 25 x 160mm) or the other similar materials on the concave mould plate, turn the handle and raise the concave mould plate until the wooden piece getting in touch with the upper die (form plunger).

After putting up the new die, all the fasten bolts of the die should be tightened up. In some cases, especially the using of narrow die it is necessary to put a piece thin paper between the upper die and the lower die.

(2) Adjustment of the cross beam.

To make the braking work go on smoothly, and to separate the formed metal that between the upper die and the lower die from being blocked, you must adjust the cross beam.

First, you put a steel plate (its width echo the demand of the machine and its thickness is 1mm) on the concave mould plate, then, turn the handle carefully to raise the concave mould plate, loosen the fasten bolt

of the crossbeam when the upper die (form plunger) getting in touch with the processing metal plate, after that, in order to fix the crossbeam, you can adjust the screw which on the crossbeam. At last, tighten up all the fasten screws. During this period, the handle is not fixed to turn and angle of 360 degrees. Brake a piece of metal plate that with same width and thickness on both side of the braking system, their angles should be similar, the job should be excessively braked when you turn the handle and fully brake the job.

#### 7. Adjustment of the shearing installation.

You should adjust the zero-clearance of the upper and the lower cutter.

##### Adjustment lower cutter:

Unload the pressing plate, loosen the fasten screw and the two adjustable screws of the working table. Turn the handle to make the upper cutter near the cutter on the working table. Tighten the fasten screw and the adjustable screw up again, in order to prevent the working table from moving back when the machine is used. Install the pressing plate once again and ensure that it run parallel to the upper cutter.

##### Adjustment of the positioning plate:

During the period of shearing, there will be a powerful strength produced at the middle of the cutter, in order to avoid the clearance that between the upper and lower cutter, you should adjust the central screw that behind the positioning plate. If the adjustment was not suitable, the metal plate will be folded in the middle for the two cutters when shearing is executed.

If the lower cutter and the upper cutters still press close together after the adjustment, two parts must be examined: First, the fasten screw of the lower cutter, you can fully tighten the cutter up, then loosen the screw about  $1/8$  circle, second, the contact face of the concave mould plate and the positioning plate, In most cases, this contact face should be cleaned and lubricated.

#### 8. Adjustment of the rolling installation

This rolling installation can roll straight roll, taper or metal ring with the help of the linear channel roller.

When a job was finished, turn the pin to right, the left side of the roller can be taken off the machine, the job will be taken out with ease.

When you operate the slide roller, you must give enough pressure to the upper for the purpost of suitable import of the job.

Adjust the clearance of the upper roller and the lower roller properly, ensure that the two sides of the roller have the same clearance.

9. When you finished your work, you must clean the machine and spread oil on the surface that not be applied a coat of paint.

### 3. CHIEF TECHNICAL SPECIFICATIONS

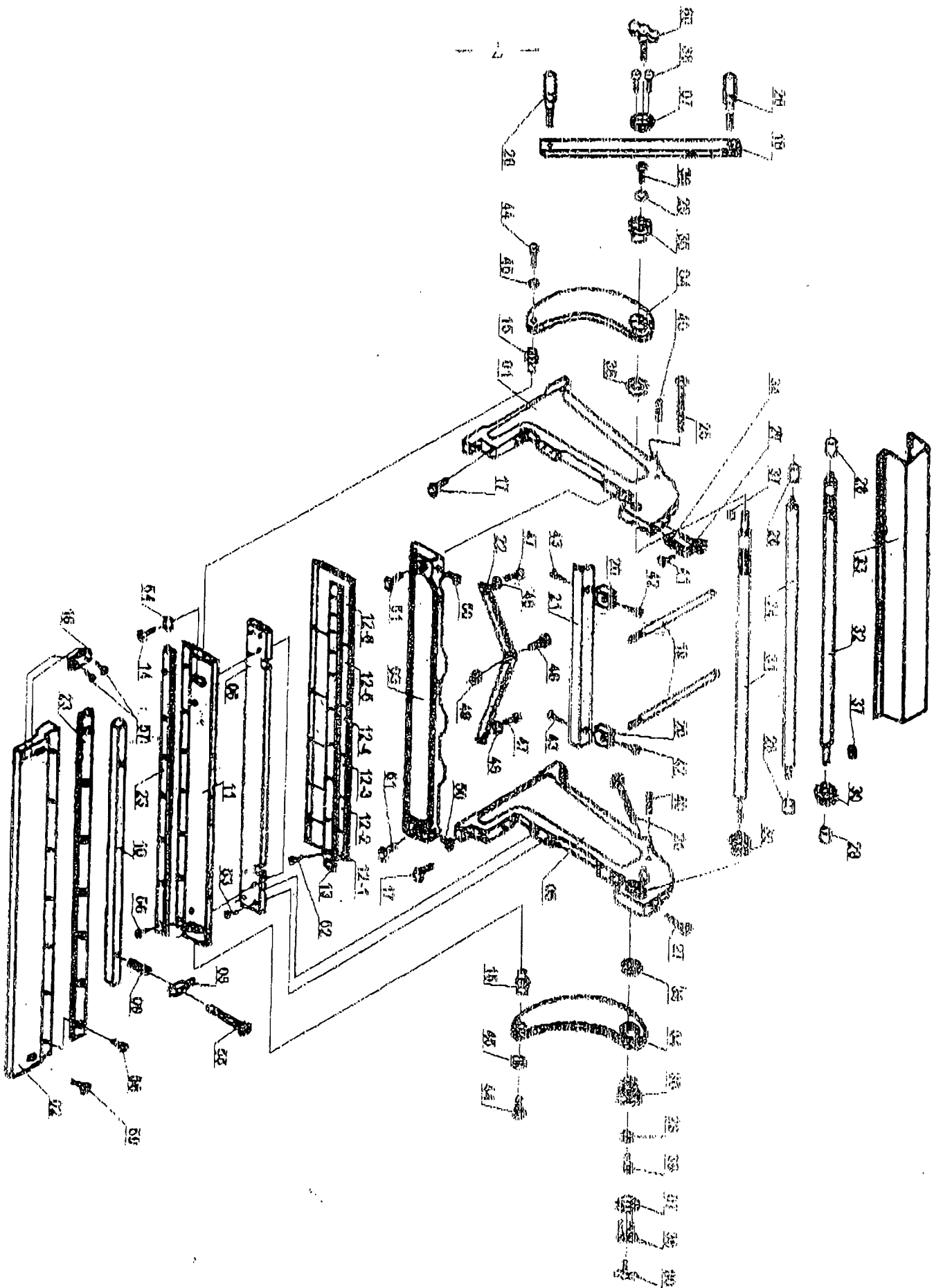
ordinal number	function parameter	30" 3 in 1 combination of shear, brake and roll
1	effective width	30"(762mm)
2	maximum shearing thickness	1 mm low carbon plate
3	maximum shearing thickness	1 mm low carbon plate
4	maximum shearing thickness	1 mm low carbon plate
5	maximum internal diameter of the roll	$\Phi 39$
6	measurement of machine tool(LxWxH)	1080x715x550mm
7	net weight of machine tool	133kg

### 4. LUBRICATION OF THE MACHINE TOOL

Oiling the machine oil into the eccentric mechanism and clearance, once for a day.

### 5. ACCESSORIES OF THE MACHINE TOOL

Allern keys(5mm,6mm,8mm,three kinds in all)with every set of machine tool.



## NUMBER OF DESIGNATION FIGURE

01.	Left wall	24.	Back pressing roll
02.	Workbench	25.	Screw
03.	Crossbeam	26.	Handle jacket
04.	Crank arm	27.	Adjustable bolt
05.	Right wall	28.	Jacket
06.	Bear frame	29.	Press cover
07.	Cover	30.	Gear
08.	Bear frame	31.	Lower pressing roll
09.	Spring	32.	Upper pressing roll
10.	Pressing plate	33.	Protecting cover
11.	Moving cutter plate	34.	Rotation shaft
12.	Upper braking die	35.	Eccentric shaft
13.	Pressing plate	36.	Gasket(Washer)
14.	Bolt	37.	Jacker
15.	Cranking arm rolling wheel	38.	Flat key
16.	Positioner	39.	Hexagon head bolts
17.	Adjustable bolt	40.	Hexagon socket cap head screws
18.	Handle	41.	Hexagon head bolts
19.	Screw	42.	Hexagon socket cap head screws
20.	Positioning piece	43.	Hexagon head bolts
21.	Positioning plate	44.	Hexagon head bolts
22.	Supporting plate	45.	Hexagon socket cap head screws
23.	Cutter	46.	Gasket(Washer)



- 47.Hexagon head bolts
- 48.Hexagon head bolts
- 49.Gasket(Washer)
- 50.Hexagon nuts
- 51.Hexagon head bolts
- 52.Hexagon screws
- 53.Hexagon screws
- 54.Hexagon screws
- 55.Gasket(Washer)
- 56.Hexagon head bolts
- 57.Hexagon screws
- 58.Hexagon screws
- 59.Hexagon screws
- 60.Gasket(Washer)