

KAKA[®] Industrial

Specifications

Model.....	SS-18FD
Stock No.	173223
Capacity.....	1.2mm / 18Ga.
Throat depth.....	25.4mm / 1"
Packing size.....	115x46x19 cm
N.W./G.W.	29/32 kg



report missing parts to dealer.

Carefully open crate and unbolt brake from shipping pallet and remove from crate using heavy duty lifting equipment such as an overhead crane.

Warning

The warnings, cautions and instructions discussed in this instructions or situations that could occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

Unpacking

The Shrinker & stretcher is shipped from the manufacture in a carefully packed Carton box. Thoroughly inspect the product upon opening the package. After unpacking the unit, carefully inspect for any damage that may have occurred during transit.

If damage has occurred, shipping damage claims must be filed with the carrier and are the responsibility of the user.

Check for completeness. Immediately

Prepare for Safe Operation

1. Wear appropriate clothing, avoiding loose items and jewelry that could entangle in machine parts.
2. Wear protective hair covering to cover long hair.
3. Wear safety shoes with non-slip soles.
4. Wear safety glasses meeting local standards; regular glasses lack the impact resistance of safety glasses.
5. Be alert and think clearly. Never operate tools when tired, or when taking medications that cause drowsiness.

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READ INSTRUCTIONS

Thoroughly read and understand this manual before using this machine. Save for future reference.



LIFTING HAZARD

•This tool is heavy. Use extreme caution when lifting or setting up. Personal injury and tool damage could occur if tool is dropped.

•Get assistance when moving or lifting to avoid back injury.



PINCH HAZARD

The moving parts of this tool exert great force when operating. Keep fingers and hands away from moving parts to avoid serious injury.



CUT HAZARD

Wear appropriate work gloves and protective clothing. Tubing may have sharp edges which can cause cuts to hands and arms.



EYE INJURY HAZARD

Wear appropriate eye protection. Metal chips can be ejected during the bending process.

Prepare Safe Working Area

1. Keep work area clean. Cluttered work areas invite accidents.
2. Work area should be properly lighted.
3. Keep visitors at a safe distance from work area.
4. Keep children out of workplace. Make workshop childproof. Use padlocks to prevent any unintentional use of tools.
5. Be sure there is sufficient workspace around the tools for work.

Tool Should Be Maintained

1. Consult manual for specific maintaining and adjusting procedures.
2. Keep tool lubricated and clean for safest operation.
3. Adopt a continuous maintenance program to keep your machine in good working condition.
4. Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended function.
5. Check for damaged parts. Check for alignment of moving parts, binding, breakage, and mounting or any other condition that may affect a tool's operation.
6. Any damaged part should be properly repaired or replaced. Do not perform

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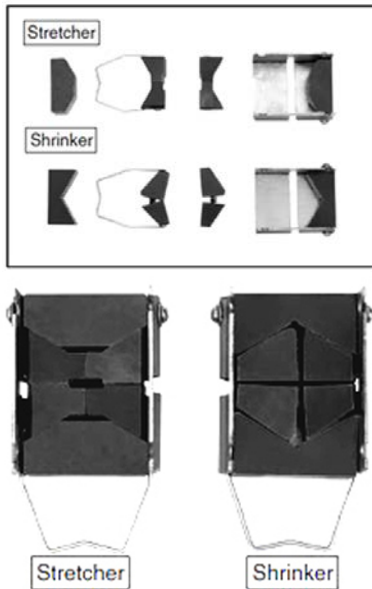
makeshift repairs. (Use parts list provided to order repair parts.)

Installation

1. For portability, the tool may also be clamped into the jaw of a vise.
2. The more rigidly the tool is secured, the easier it is to use.

Operation

Please refer to following figures of shrinker and stretcher dies



Assembled dies.

1. Verify the jaw teeth are free of built-up metal. Clean / lubricate and reinstall the stretcher/shrinker dies.

2. Select the required die for your task, loosen the four thumb screws and insert the die. Using the stretcher die, a curve in metal is created by expanding the outside radius of the curve. Using the shrinker die, a curve in metal is created by compressing the inside radius of a curve. Shown below:

▲ CAUTION

1. The location of stretching or shrinking will show small teeth marks from the jaws and cannot be avoided. To limit the depth of the teeth marks, lighter and more repetitions of bending help considerably.
2. Avoid pressing the jaws together accidentally.
3. To avoid dulling the teeth, NEVER press without a separator between the jaws.
4. Always insert a piece of metal or other material divider between the jaws when not in use.

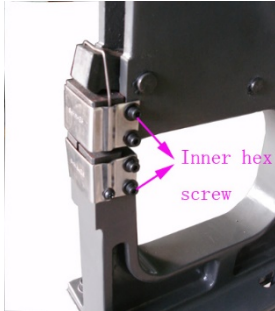
Maintenance

Clean jaws after each use. Vacuuming helps to get the filings out. The recommended method to maintain the shrinker stretcher is to disassemble the jaws and clean as follows:

1. Remove shrinker or stretcher cartridge (cover/jaw assembly) by loosening socket

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head screws. Remove die shown below:



2. Upper jaws and V block (Shrinker) or upper jaws and pressure block (Stretcher) as a single assembly. Be careful to not lose the spring between the jaws.

3. Remove suspension wire.

4. Take notice as to how the shrinker jaws are inserted. A small jaw is opposite a larger jaw, top to bottom.

5. Clean the two upper jaws with a non-hazardous metal cleaner and a file card (brush). Do not use a wire brush or a wire wheel.

6. Always brush in the direction of the teeth (with the grooves).

7. Clean the V block (Shrinker) or pressure block (Stretcher).

8. Re-assemble the upper jaws and set aside.

9. After removing the two machine screws at the lower end of the cover, remove the bottom jaws by lifting out as a single unit with the V block (Shrinker) or pressure

block (Stretcher). Clean all as described previously.

10. Replace jaws. Be careful to locate larger shrinker jaw opposite small shrinker jaw. When replacing the V blocks (Shrinker) or pressure blocks

(Stretcher), chamfered corners face front.

11. Oil jaws lightly when not in use for extended periods.

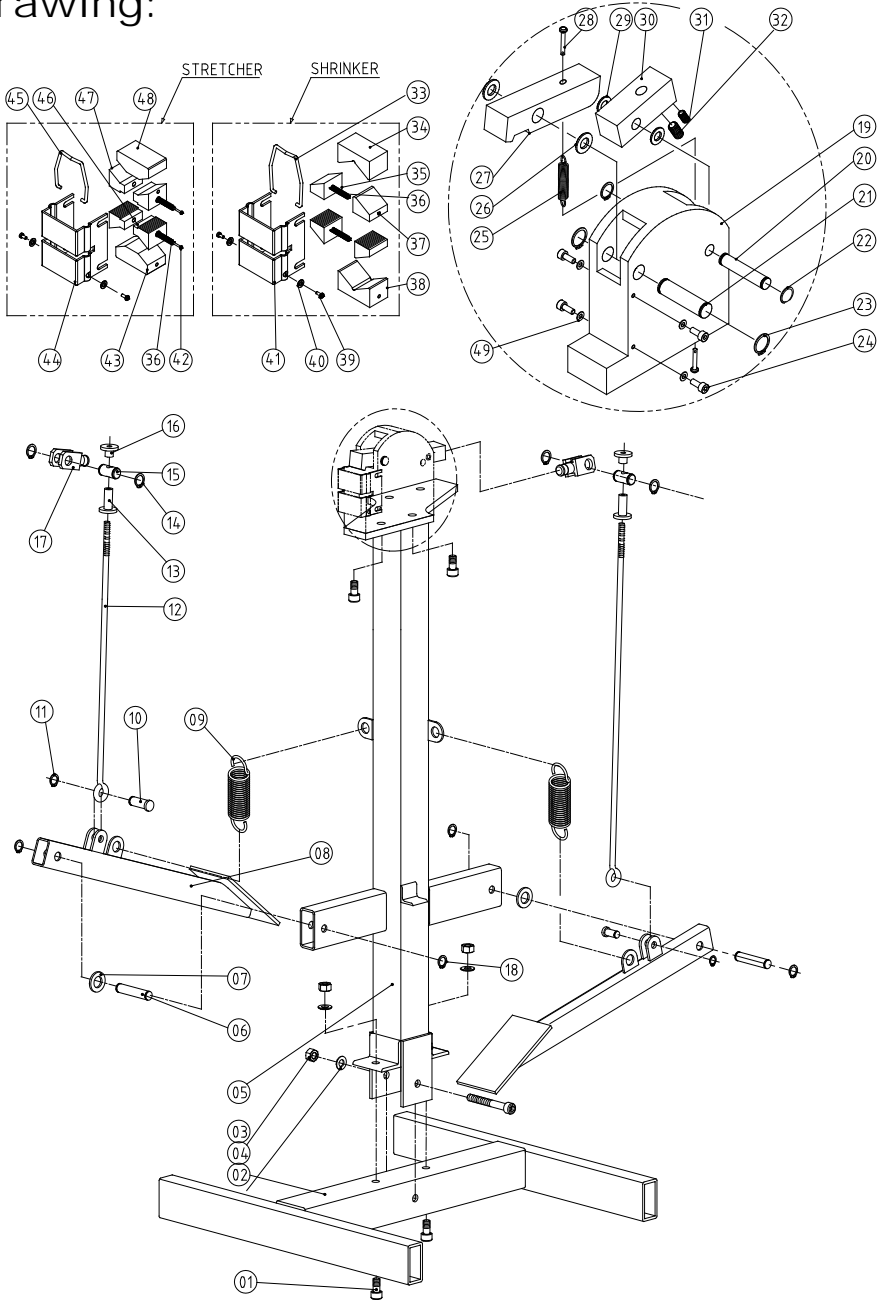
12. For best operating results, clean the jaws after every job.

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Parts List

Ref. No.	Description	Qty	Ref. No.	Description	Qty
1	Inner Hex Screw M10x20	6	26	Washer (not standard hardware)	4
2	Base	1	27	Pressure Arm	2
3	Washer 10mm	8	28	Rivet	4
4	Nut M10	3	29	Washer (not standard hardware)	4
5	Frame	1	30	Back Block	2
6	Pin	2	31	Screw M6x10	2
7	Washer 14mm	2	32	Screw M8x20	2
8	Foot Pedal	2	33	Shrinker Hook	2
9	Spring	2	34	Shrinker Upper V-block	2
10	Pin	2	35	Shrinker Small Jaw	4
11	Washer on Shaft 10mm	2	36	Suspension Spring	8
12	Pull Rod	2	37	Shrinker Big Jaw	4
13	Nut	2	38	Shrinker Lower V-block	2
14	Washer on Shaft 16mm	4	39	Screw M4x10	8
15	Connector	2	40	Washer 4mm	8
16	Nut	2	41	Jaw Cover	2
17	Pin	2	42	Screw M4x35	4
18	Washer on Shaft 13mm	4	43	Stretcher Lower V-block	2
19	Body	2	44	Jaw Cover	2
20	Shaft I	2	45	Stretcher Hook	2
21	Shaft II	2	46	Stretcher Lower Jaw	4
22	Washer on Shaft 10mm	4	47	Stretcher Upper Jaw	4
23	Washer on Shaft 13mm	4	48	Stretcher Upper V-block	2
24	Inner Hex Screw M4x10	8	49	Washer 4mm	4
25	Spring	2			

Drawing:



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If you have any questions about the use of this product, please contact
the nearest one to you as below:

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