

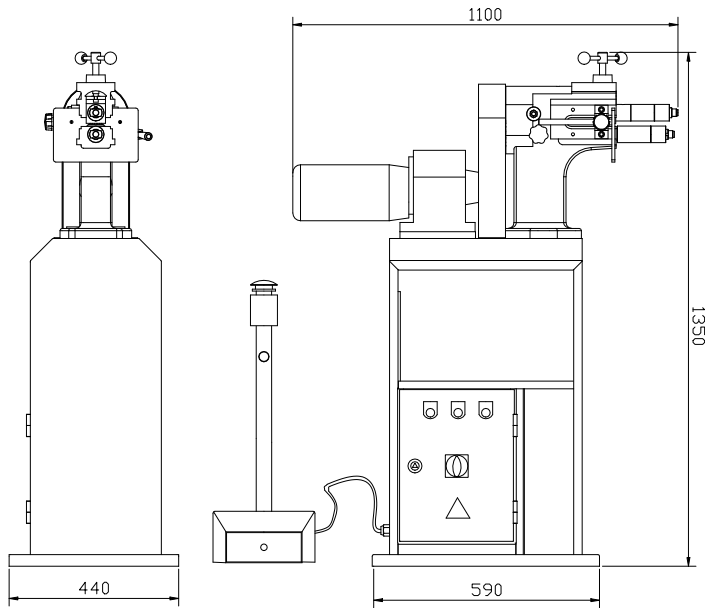
# BEAD BENDING MACHINE

Model: ETB12



INSTRUCTION MANUAL

## I . Appearance of the machine



## II. Main specification

- 1) max.thickness:1.2mm
- 2) motor power:0.75kW rotating speed:1400rpm
- 3) cylinder speed:32rpm
- 4) Net weight:120kgs

### Function and construction:

- 1) This kind of machine can be used to manufacture round tube, plate beading and connecting. It can press plate into certain ridge, thus strengthening the rigidity of tube, metal plate and pipe, or raising the connection function. Nice appearance and easy operation.
- 2) This kind of machine is consist of power section, transmission part, working part, adjusting part, stand, lubrication maintenance part.

Power section: motor, reducer

Transmission part: reducer gear wheel, big gear wheel, transmission gear, upper roller shaft, lower roller shaft.

The main movement of this machine is the circumnutation of upper and lower roller: motor drive reducer, reducer drive reducer gear wheel、big gear wheel、transmission gear, thus the rotating speed of the upper and lower roller is the same and convoluting opposite direction.

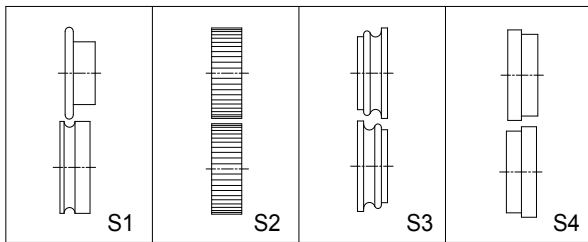
Working part: upper roller, lower roller

Adjusting part:

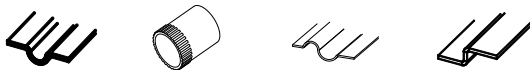
- 1) front and rear sliding control of lower roller shaft
- 2) rise or fall the upper roller shaft, adjusting the clearance between upper roller and lower roller according with the thickness of sheetmetal.

3)Turning the locking handle,moving the lower shaft front or rear,adjusting the distance between limited plate and upper/lower roller according with the position of ridge.

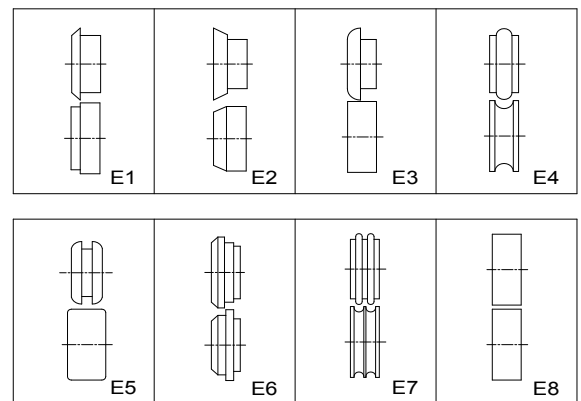
### 3. STANDARD ROLLERS:



Workpiece shape respectively:



### EXTRA ROLLERS:



### III. Safety warnings:

Machinery general safety warnings:

- For safety,machine must be set up,used and serviced properly.
- Read,understand and follow instructions in the operator's and parts manual which is shipped with your machine.

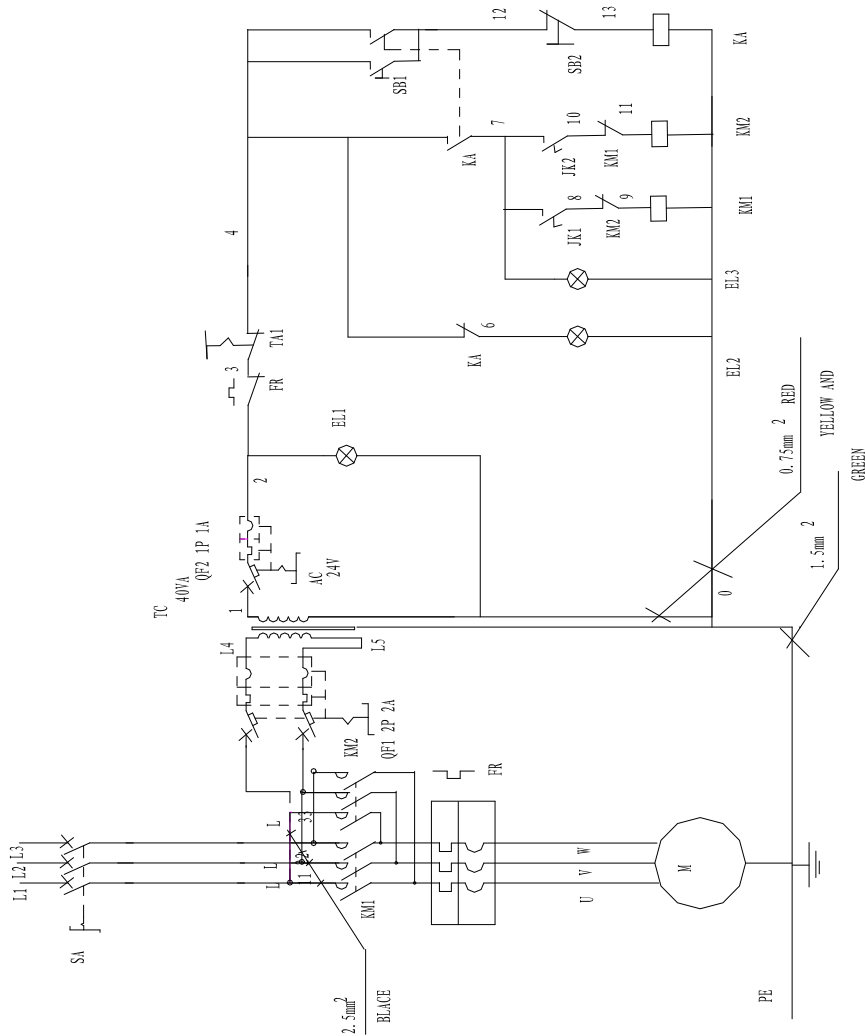
When setting up machine:

- Always avoid using machine in damp or poorly lighted work areas.
  - Always be sure machine is securely anchored to the floor.
  - Always keep machine guards in place.
  - Always put start switch in "OFF"position before plugging in machine
1. Always wear protective eye guard when operating machinery.
  2. Wear proper apparel. No loose clothing or jewelry which can get caught in moving parts.Rubber soled foot wear is recommended for best footing.
  3. Never leave the machine running while unattended.Machine shall be shut off whenever it is not in operation.
  4. Never brush away chips while the machine is in operation.
  5. Keep work area clean.Cluttered areas invite accidents.
  6. Use only recommended accessories and follow manufacturers instruction pertaining to them.
  7. All visitors should be kept at a safe distance from the work area. Make workshop completely safe by using padlocks, master switches, or by removing starter keys.

### IV. ELECTRICAL PARTS

On-off control working principle: when stepping on the foot pedal switch, the motor will drive the roller run;when leaving the foot pedal switch, machine will power off and stop running.

# ELECTRIC DRAWING:



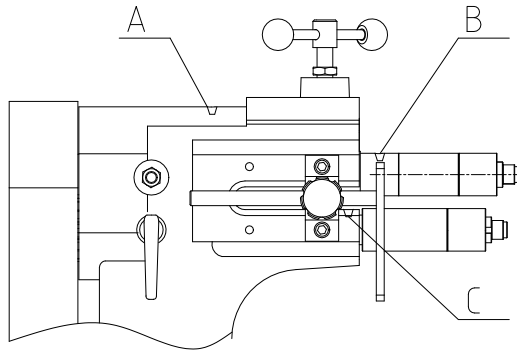
## Electronic component:

No.	NAME	CODE NAME	TYPE AND SPECIFICATION	QTY
1	MAIN MOTOR	M	400V,50HZ,3PH	1
2	MAIN SWITCH	SA	JDF11-25	1
3	CONTACTOR	KM	CN-6 AC24V	2
4	HEAT RELAY	FR	RHN-5M 2.4-3.6A	1
5	CIRQUIT BREAKER	QF	DZ47-63 1P 1A 2P 2A	1
6	TRANSFORMER	TC	JBK5-60VA 230/24V 50/60HZ	1
7	EMERGENCY STOP	TA	XB2+BX542	1
8	STARTUP SWITCH	SB1	LA800E-EFL3161 AC24V	1
9	STOP SWITCH	SB2	LA800E-EFL4261 AC24V	1
10	POWER SHOW LAMP	EL	XB2-BVB3C AC24V	1
11	RELAY	KA	HH52P-FL	1
12	PEDAL SWITCH	JK1	SFMS-1	1

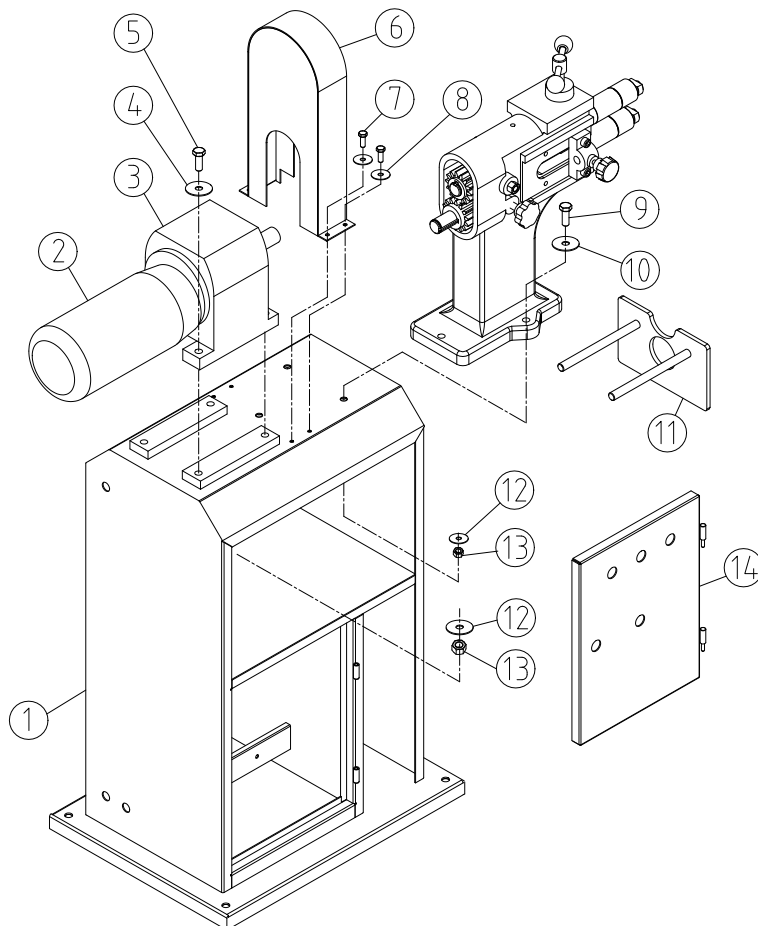
## V. Lubricating and maintenance

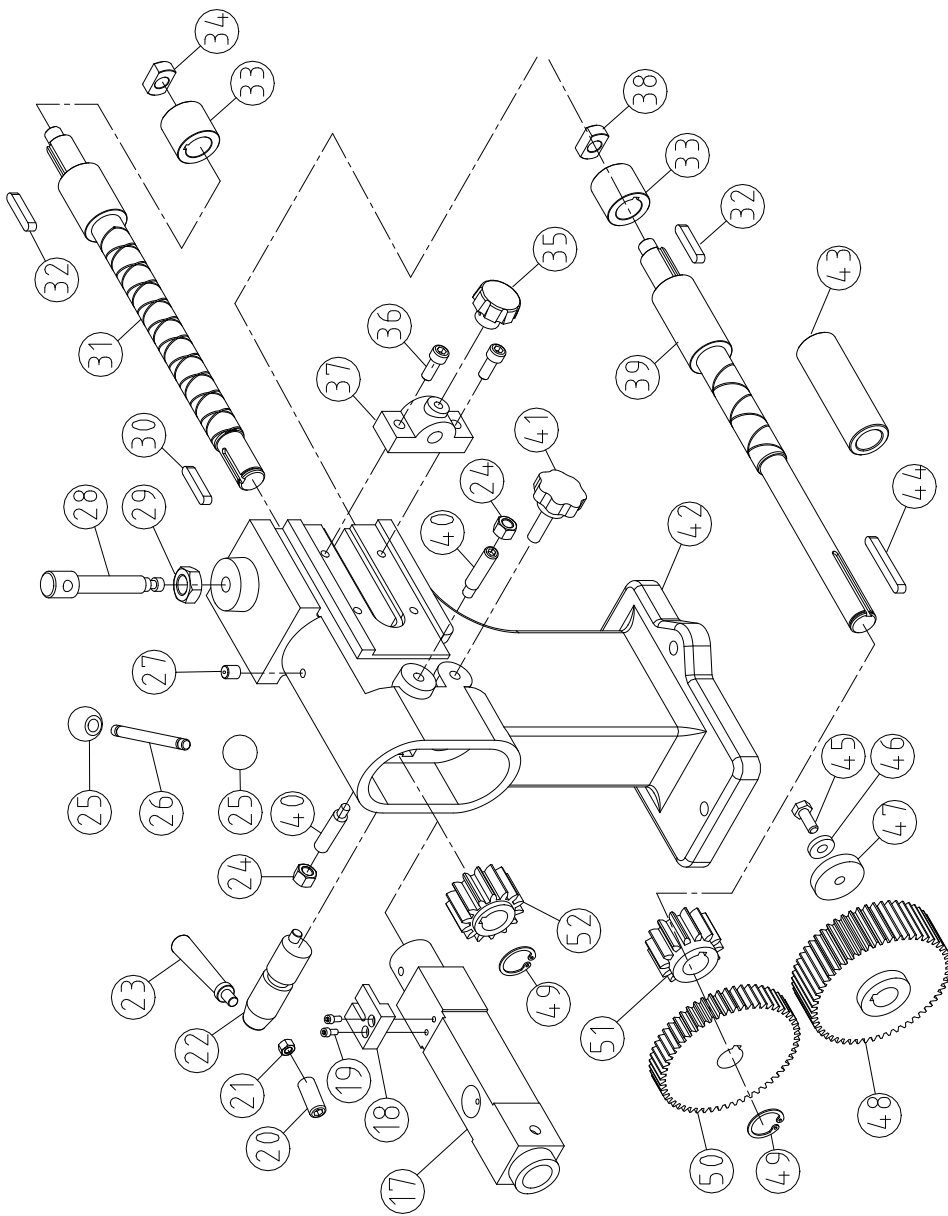
This kind of machine is single-lubricating, every time when using please oil 30# lubrication from part A&B on following diagram.

1. Please oil lubrication on all needed parts every week;
2. Please check electrical connection and earthing system every month;
3. Every time when using please check roller profile extrusions, if broken please replace.
4. Please keep working face and working environment clean and clear



## VI. Exploded drawing





## Parts list

Serial No.	Description	Q'ty	Serial No.	Description	Q'ty
1	Base	1	27	Oil cup 8	1
2	Motor	1	28	Screw rod	1
3	Reducer	1	29	Screw M16	1
4	Washer 12	4	30	Flat key 6X40	1
5	Bolt M12X65	4	31	Upper shaft	1
6	Safety guard	1	32	Flat key 6X45	2
7	Bolt M6X12	4	33	Sleeve	2
8	Washer 6	4	34	Pressure cover	1
9	Bolt M12X50	4	35	Star-handle M10X20	2
10	Washer 12	4	36	Bolt M10X30	4
11	Bracket	1	37	Shaft seat	2
12	Washer 12	8	38	Pressure cover	1
13	Screw M12	8	39	Lower shaft	1
14	Cover of electric box	1	40	Bolt	1
15	Switch board	1	41	Adjusting handle M12X32	1
16	Pedal switch	1	42	Body	1
17	Upper Shaft Seat	1	43	Lower sleeve	1
18	Snap-gauge	1	44	Flat key 6X80	1
19	Bolt M6X20	2	45	Bolt M8X30	1
20	Bolt M8X30	1	46	Washer 8	1
21	Screw M8	1	47	Pressure cover	1
22	Adjusting shaft	1	48	Gear	1
23	Handle	1	49	Ring 26	2
24	Screw M12	2	50	Big gear	1
25	Handle ball M10	2	51	Lower gear	1
26	Handle	1	52	Upper gear	1

## VII. PACKING LIST

Ser no.	Model	Description	QTY	Mark
01	ETB12	BEAD BENDING MACHINE	1	
02		Rollers	4 sets	
03		Wrench	1	
04		Oil cup	1	
05		INSTRUCTION MANUAL	1	





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