

ROTARY MACHINE

MODEL RM18

Assembly & Operating Instructions

DESCRIPTION

Rotary machine is hand operated and will form sheet metal up to 18 Gauge thickness mild steel (or equivalent). The Rotary machine is constructed of cast iron and steel ensuring minimum deflection of the workpiece during forming operations. Six die sets are included, allowing the following operations to be performed: wiring, edging, ogee bead, single bead, and elbow edging.

SAVE THIS MANUAL

You will need this manual for the safety instructions, operating procedures, Maintenance procedures, trouble shooting, parts list, and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep both this manual and your invoice in a safe dry place for future reference.

READ ALL INSTRUCTIONS BEFORE USING THIS TOOL!

- 1. KEEP WORK AREA CLEAN.** Cluttered areas invite injuries.
- 2. OBSERVE WORK AREA CONDITIONS.** Do not use tools in damp, wet, or poorly lit locations. Don't expose to rain. Keep work areas well lit. Do not use electrically powered equipment in the presence of flammable gases or liquids.
- 3. KEEP CHILDREN AWAY.** Children must never be allowed in the work area. Don't let them handle the benders.
- 4. STORE IDLE EQUIPMENT.** When not in use, tools must be locked up in a dry location without rust. Always lock up tools and keep out of reach of children.
- 5. DO NOT FORCE THE ROTARY MACHINE.** It will do the job better and more safely at the rate for which it was intended.
- 6. DO NOT OVERREACH.** Keep proper footing and balance at all times.
- 7. MAINTAIN TOOLS WITH CARE.** Keep tools clean for better and safer performance. Keep handles dry, clean, and free from oil and grease.
- 8. STAY ALERT.** Watch what you are doing. Do not operate any machinery when you are tired.
- 9. CHECK FOR DAMAGED PARTS.** Before using any tool, any part that appears damaged should be carefully checked to determine that it would operate properly and perform its intended function. Check for alignment and binding of moving parts, any broken parts or mounting fixtures, and any other condition

that may affect proper operation. Any part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.

10. REPLACEMENT PARTS AND ACCESSORIES. When servicing, use only identical replacement parts. Only use accessories intended for use with this tool.

11. DO NOT OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS. Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

12. Check for shipping damage. If damage has occurred, a claim must be filed with carrier. Check for completeness. Immediately report missing parts to dealer.

IMPORTANT: Rotary machine and dies are coated with a protectant. To ensure proper fit and operation, remove coating. Coating is easily removed with mild solvents, such as mineral spirits, and a soft cloth. Avoid getting cleaning solution on paint or any of the rubber or plastic parts. Solvents may deteriorate these finishes. Use soap and water on paint, plastic or rubber components. After cleaning, cover all exposed surfaces with a light coating of oil.

WARNING: Never use highly Non-flammable solvents are recommended to avoid possible fire hazard.

SPECIFICATIONS ROTARY MACHINE

Maximum thickness	18GA mild steel
Throat depth	15"
Overall dimension	68×20×10
Weight	25kg

INSTALLATION

Machine should be installed on a level surface with proper lighting. Machine is to be bench mounted. Be sure to provide clearance for crank arm rotation. Area around machine should be clear of scraps, oil or dirt. Apply a suitable non-skid material to floor.

OPERATION

1. Select the die set required for the operation to be performed.
2. Place spacers, dies and retaining nuts onto the driving and driven shafts
Tighten the retaining nuts with wrench provided.
3. Adjust the position of the upper die according to thickness of the workpiece by using the adjusting handle.

MAINTENANCE

LUBRICATION

1. All exposed iron surfaces should be coated with light oil to prevent rusting. Use a multi-purpose or bearing grease for lubrication.
2. The adjusting block should be greased.
3. Oil the driving shaft through the oil ports monthly.

PARTS LIST

Part	Description	Qty	Part	Description	Qty
1	Head screw M10	2	16	Copper bushing	2
2	Washer	2	17	Gear	2
3	Hex screw	4	18	Square screw	1
4	Concave wheel	1	19	Handle	1
5	Screw	1	20	Handle lever	1
6	Washer	2	21	Concave wheel II	1
7	Head screw M12	4	22	Cam II	1
8	Cam	1	23	Cam III	1
9	Hex screw m6	2	24	Concave wheel III	1
10	Bushing	2	25	Roll dies I-1	1
11	Main spindle	1	26	Roll dies I-2	1
12	Driven shaft	1	27	Roll dies II-1	1
13	Vertical bracket	1	28	Roll dies II-2	1
14	Washer	4	29	Roll dies III-1	1
15	Supporting block	4	30	Roll dies III-2	1

