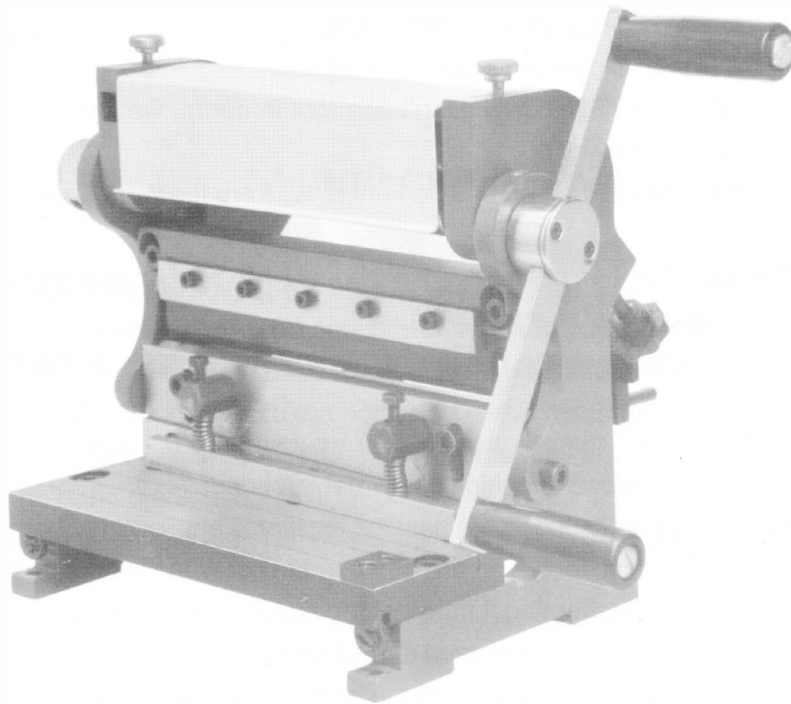


**8" SHEAR, PRESS BRAKE
& SLIP ROLL
3-IN-1/200**



OPERATION MANUAL

SPECIFICATION

Capacity:	1mm thick (20gauge), 200 mm (8") width
Roller:	29mm
Die set sizes:	76.2mm(3"), 63.5mm(2.5"),50.8mm (2"), 25.4mm(1 ")
Weight:	22kg

SAVE THIS MANUAL

You will need this manual for the safety instruction, assembly instruction, operating procedures, parts list, and diagram. Write your invoice number on the inside front cover. Put both your manual and invoice in a safe, dry place for future reference.

IMPORTANT SAFELY PRECAUTIONS

READ ALL INSTRUCTIONS BEFORE USING THIS TOOL.

1. KEEP WORKAREA CLEAN. Cluttered areas invite injuries.
2. CONSIDER WORK AREA CONDITIONS. Don't use tool in damp, wet, or poorly lit locations. Don't expose to rain .keep work area well lit.
3. KEEP CHILDREN AWAY. All children should be kept away from the work area. Don't let them handle tool or extension cords.
4. STORE IDLE EQUIPMENT. When not in use. tool should be locked up in a dry location to inhibit rust. If possible, store in an area out of reach of children.
6. DON'T FORCE TILE TOOL. It will do the job better and more safely at the rate for which it was intended.
6. USE THE RIGHT TOOL. Don't force a small tool or attachment to do the work of a larger industrial tool. Don't use a tool for a purpose for which it was not intended.
1. DRESS PROPERLY. Don't wear loose clothing or jewelry. They can be caught in moving parts. Protective gloves and non-skid footwear are recommended when working. Wear protective hair covering to contain long hair, preventing it from getting caught in machinery.
8. USE EYE PROTECTION. Wear ISO approved impact goggles.
9. SECURE WORK. Use clamps or a vise to hold the work if possible. It's safer than using your hands and it frees both hands to operate the tool.
10. DON'T OVERREACH. Keep proper footing and balance at all times.
11. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for better and safer performance. Follow instruction for lubricating and changing accessories. Inspect tool cords periodically and if damaged, have them repaired by an authorized service facility. Keep handles dry, clean, and free from oil and grease.
12. REMOVE ADJUSTING KEYS AND WRENCHES. Make it a habit to check that keys and adjusting wrenches are removed from the tool or machine work surface before using.
13. STAY ALERT. Watch what you are doing, use common sense. Don't operate any tool when you are tired.
14. CHECK DAMAGED PARTS. Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check

for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and other conditions that may affect its operation. Any part that is damaged should be properly repaired by an authorized service center unless otherwise indicated elsewhere in the instruction manual.

15. **REPLACEMENT PARTS AND ACCESSORIES.** When servicing, use only identical replacement parts. Only use accessories intended for use with this tool. Approved accessories are available from the franchiser.
16. **DO NOT OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.** Read warning labels on prescription to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate machine.
17. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped over.
18. **KEEP GUARDS IN PLACE AND IN WORKING ORDER.** Never operate machine unless all guards are function properly.
19. **NEVER USE A TOOL IF ITS COVER OR ANY BOLTS ARE MISSING.** If the cover or bolts have been removed, replace them prior to use. Maintain all parts in good working order.
20. **DO NOT ATTEMPT TO LIFT OVERLY HEAVY WORK.** Get help when lifting tools and materials that are too heavy for you to do yourself. When appropriate and whenever possible, use a hoist forklift.
21. **CLEAN UP SPILLS LIKELY TO CAUSE SLIPPING.** Keep floor clean and free of all fluids and other spills likely to cause slipping. Check material safety data sheets for proper clean-up procedures.

UNPACKING

When unpacking, you must remove the bolts that are used to mount the machine to the crate. Save these bolts for use when mounting to a workbench. For safe and precise operation, mount your machine to a workbench. Use the bolts that were used to secure the machine to the crate.

NOTE: The handle is shipped mounted to the right side of the machine. If you wish to move the handle to the left side of the machine, proceed with the following instruction.

1. Remove one of the hand crank knob (26).
2. Loosen the Hexagon head bolt (39), remove crank hub end cap (7) and slide the hand crank bar (18) out.
3. Slide the handle arm can be into the opposite side and tighten the Hexagon head bolt (39) and crank hub end cap (7).
4. Attach the hand crank knob (26) to the hand crank bar (18).
5. The handle crank bar can be positioned in the bushing(35) as desired for appropriate torque.

OPERATIONS

Shear:

1. For precision shearing 200mm (length wise). First attach the back measurement assembly (19-22, 39, 42, 43.) to the receiver hole in the back of the crossbeam(3).
2. To adjust the position of the back measurement assembly, first loosen the two knob(42). Move the assembly forward and back. When the desired position is achieved, tighten the knobs.
3. If a precise 90° angle is desired, attach the guide (16) to the right side of the work table (2) using the two hex key screws(58).
4. Using the handle assembly (18&26), raise the upper finger receiver (11) to the highest position.

5. Slide your workplace in-between the braking die and the work surface.
6. Crank down on the handle assembly(18&26) to shear the workpiece.

Pressing:

1. Slide press plate brackets(8) of the press plate assembly(8-1 O, 60) into the receiver holes of the upper finger receiver (11). Not that the holddown plate (1 O) should be facing down.
2. Place the workpiece so that it is centered under the press plate.
3. Crank down using the handle assembly(18&26) to press the workpiece.

Braking:

1. For precision braking 200mm (length wise), first attach the back measurement assembly(19-22, 39, 42, 43.) to the receiver holes in the back of the crossbeam.(3)
2. To adjust the position of the back measurement assembly, first loose the two knobs(42). Move the assembly forward and back. When the desired position if achieved, tighten the knobs.
3. Using the handle assembly (18&26), raise the crossbeam(3) up to its highest position.
4. Insert the workpiece in-between the upper (12) and lower(11) braking dies.
- 5., Crank the handle assembly (18&26) until the proper roll has been achieved. The material should feed itself through the rollers if you crank the handle assembly.

Wire rolling:

1. Use the proper groove in the upper roll bar (32) depending upon the gauge of the wire being rolled.
2. Follow the procedures as listed above in "rolling".

ADJUSTMENTS

Shear alignment:

1. Lower the shear assembly all of the way so that the two shear (23, 60) are even with each ether.
2. If one side of the lower shear is further away from the upper shear than the ether, the work table (2) needs adjustment.
3. Loosen the bolts(17) that secure the work surface to the frames (11).
4. Tighten or loosen either of the adjustment screws(17) on the front underside of the work surface as necessary to make the two shears meet properly.

Upper braking die:

1. The brake finger (12) may become uneven. The best way to correct this problem is to cut a gauge from hard wood. Make sure the gauge is even all of the way across its length.
Raise the crossbeam (3) all of the way.
2. Place the hardwood gauge underneath the dies.
3. Loosen the bolts(53) that hold the upper braking die bracket(13) in place and allow the dies to drop so that they contact the gauge.
4. Tighten the upper braking die bracket bolts.

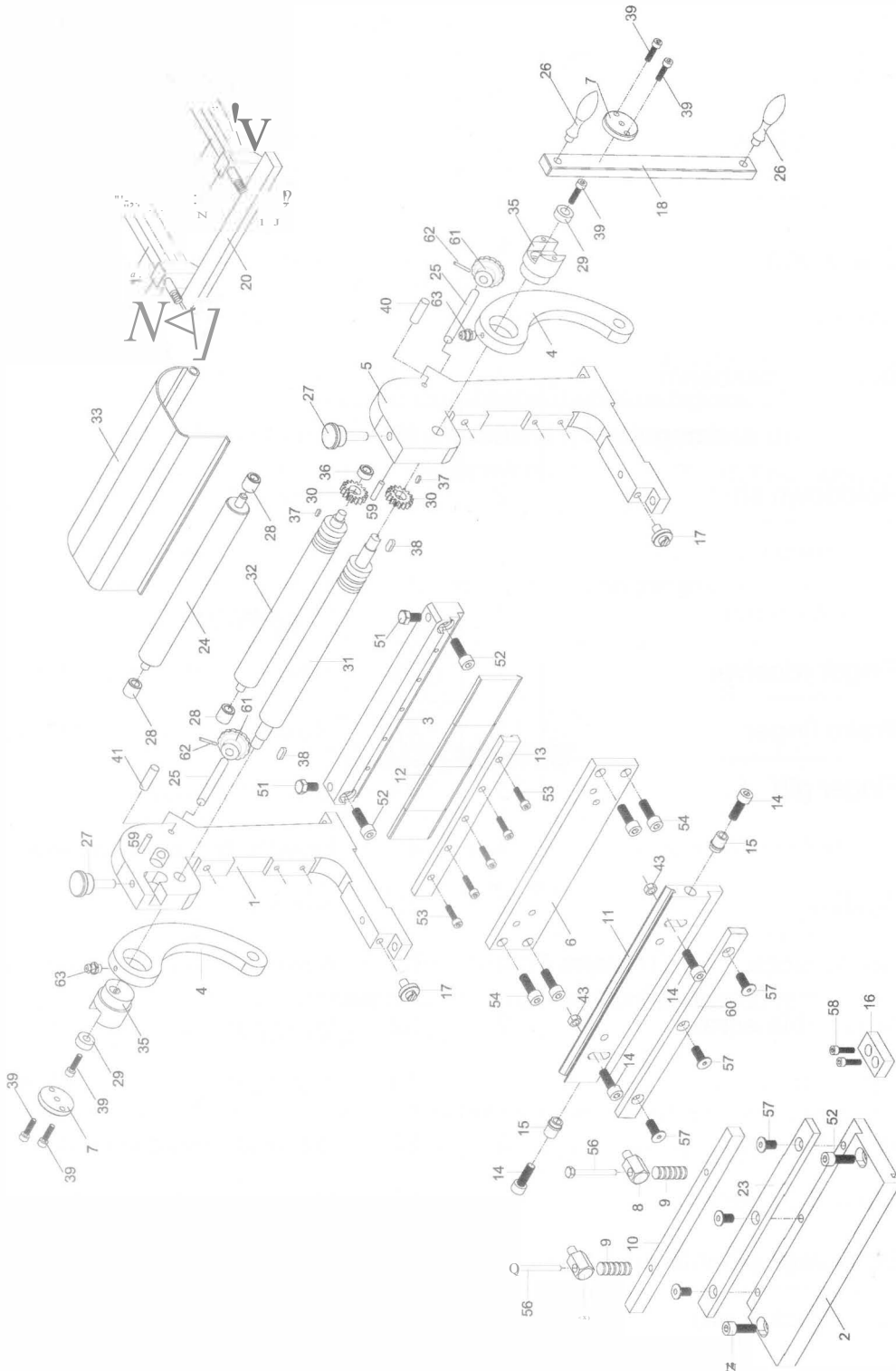
LUBRICATION

Grease the cranking arms(4) as necessary using a grease gun on the provided zerk fittings.

PARTS LIST

Part No	Description	Qty	Part No	Description	Qty
01	Left frame	1	28	Roller bushing $\varnothing 14 \times \varnothing 10 \times 13$	3
02	Working table	1	29	Crank hub retainer	2
03	Top crossbeam	1	30	Small Gear	2
04	Crank arm	2	31	Bottom slip roller	1
05	Right frame	1	32	Top slip roller	1
06	Bottom crossbeam	1	33	Slip roller cover	1
07	Crank hub end cap	2	35	Hand crank hub	2
08	Holddown stud	2	36	Bushing	1
09	Compression spring	2	37	Fiat key 4x6	2
10	Holddown bar	1	38	Fiat key 4x12	2
11	Finger receiver	1	39	Hexagon head bolt M4x10	10
12	Brake finger	1	40	Hexagon head bolt M6x25	1
13	Finger gib	1	41	Slip cover stop pin	1
14	Hex bolt M8X35	4	42	Hexagon head bolt M6X10	2
15	Bushing	2	43	Nut M8	4
16	Guide block	1	51	Hexagon head screw M8x10	2
17	Adjustable screw	2	52	Hexagon head bolt M8x30	4
18	Hand crank bar	1	53	Hexagon head bolt M5x16	5
19	Work stop rod	2	54	Hexagon head bolt M6x16	4
20	Work stop plate	1	56	Hexagon head bolt M6X50	2
21	Stop block (Right)	1	57	Hexagon head bolt M6X16	6
22	Stop block (Left)	1	58	Hexagon head bolt M4X10	2
23	Bottom shear blade	1	59	Slip cover stop pin	2
24	Rear slip roller	1	60	Top shear blade	1
25	Screw rod	2	61	Star knob	2
26	Hand crank knob	2	62	Spring pin	2
27	Knob bolt	2	63	Grease fitting	2

DIAGRAM



Note: This manual is only for your reference. Owing to the continuous improvement of the machine, changes may be made at any time without obligation on notice. Please note the local voltage for operating this machine.