

# R.R. BRAMLEY & CO. LTD.

ESTABLISHED 1921

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## OPERATING INSTRUCTIONS & PARTS LIST

# 600mm BOX & PAN FOLDER



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Thank you for purchasing this High Quality Box & Pan Sheet Metal Folder.

This Machine has been constructed from High Grade Steel, which combines to give good strength and long life.

All machining has been carried out on the latest computer controlled machinery to exacting standards.

With care and regular lubrication your new machine will provide years of efficient service.

### **BEFORE USE:**

The Machine has had rust preventative applied to all exposed parts. This should be thoroughly cleansed and replaced as required, with a thin smear of light machine oil. Securely fasten to a stable work bench.

### **ASSEMBLY:**

YOUR Machine has been packed in partially disassembled condition and should be assembled as follows;

- (1) Remove unit from box and securely fasten to a solid work bench.
- (2) The clamping handle has to be assembled to the machine. This is done removing the two loose screws in the eccentric located on the side of the base of the machine. Re-fasten the screws through the holes in the handle back into the eccentric. If necessary for operator convenience, the handle may be assembled to either end of the machine.
- (3) The bending handle is next to be assembled. This is simply bolted to the rear face of the bending plate with the two bolts that will be found loosely fitted in the holes provided.

## **ADJUSTMENT:**

Your Machine is supplied with two sets of eccentric adjusting cams and these are used to make minor adjustments required for differing material thicknesses.

These two sets (i.e. both ends of bender) serve two separate purposes, but will need to be adjusted in unison with each other.

The hex cam adjustment located at the rear of the unit is provided to allow the Blade Carrier and blade assembly to be moved forward and backwards.

The second hex cam adjustment is located at the top of the finger support frame which holds the folding fingers. To adjust this cam it is first required to loosen the retaining bolt. This adjustment is provided to allow easy adjustment for varying thickness of material and is rotated either clockwise or anticlockwise as desired.

By correctly adjusting these cams the machine can be set up to bend material from very thin shims up to 20 gauge mild steel or slightly heavier gauge aluminium sheet.

As everyone's requirements are different, the machines are supplied with adjustments to bend approximately .025" thick material.

## **OPERATION:**

Your Bender is supplied with a complete set of Box & Pan Fingers. The Box & Pan Fingers can be used in many differing positions required.

The material being bent is inserted between the machine base and the Clamp Blade. The Clamp handle is then rotated forward and backward to ensure the material is securely fastened.

It is then a simple exercise to raise the bending handle (16) until the desired angle of bend has been achieved.

