



Rotary Machine -22GA



**Before Operating Your Tools,
Please Read This Instruction Carefully**



**ITEM NO.61-251-140
MODEL NO . #RN1540**

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PROOF OF PURCHASE

Please keep your dated proof of purchase for warranty and servicing purposes.

REPLACEMENT PARTS

Replacement parts for this tool are available at our authorized service centers across Canada. For servicing, contact or return or return to the retailer where you purchased your product along with your proof of purchase. Please use the 10 digit part numbers listed in this manual for all part orders where applicable/

LIMITED TOOL WARRANTY

KING CANADA makes every effort to ensure that this product meets high quality and durability standards. KING CANADA warrants to the original retail consumer a 1-year limited warranty as of the date the product was purchased at retail and that each product is free from defects in materials. Warranty does not apply to defects due directly or indirectly to misuse, abuse negligence or accidents, repairs or alterations and lack of maintenance. KING CANADA shall in no event be liable for death, injuries to persons or property or for incidental, special or consequential damages arising from the use of our products. To take advantage of this warranty, the product or part must be returned for examination by the retailer. Shipping and handling charges may apply. If a defect is found, KING CANADA will either repair or replace the product.

IMPORTANT:

If this machine is damaged due to feeding materials that are a thicker gauge steel than 22 ga, the warranty will be Null and void.

GENERAL CONSTRUCTION

This versatile machine with interchangeable rolls is a combination of quality construction and many exclusive features to ensure fast, precise performance. The machine is fabricated from steel sheet and the gears are machine-cut and enclosed in the body of the machine.

The rolls are mounted in dry-type replaceable bearings.

The rigidity of construction ensures the minimum of deflection to maintain a highest standard of work. The ROLL DIE (1) installed on the front of this machine is assembled/ disassembled with a special screw driver.

The set screws are loosened for either moving the PLATE WIDTH STOP (6) or the STOP GAUGE (5) to the proper position to suit each size of the work piece. The adjustment is rather simple and convenient.

The OPERATING HANDLE (8) is utilized to roll the roll die, while the ROLL DIE CONTROL (3) and DIE CENTER CONTROL (7) are designed to adjust the depth from the upper shaft.

In order to maintain a more accurate job, the DIE CENTER CONTROL (7) is set to adjust the close fit of the upper and lower shafts.

◆ ROLLERS

Rollers can be interchanged very easily. The roller retaining nut is recessed into the face of each roller. A special key is supplied for unlocking the retaining nut.

◆ OPERATION INSTRUCTIONS

Refer to illustration on the next page.

The rotary machine has multi-applications in sheet metal operation, such as bending, turning, closing, etc.

Please operate your machine following these procedures:

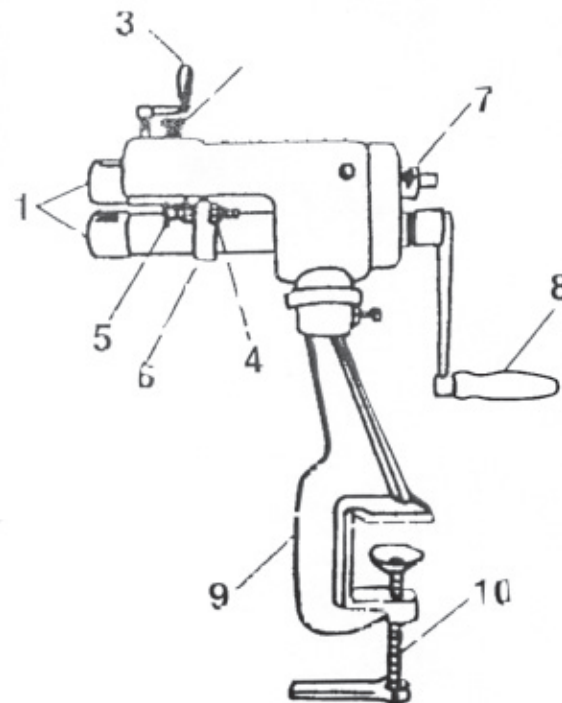
1. Select the right ROLL DIE (1) and use a special screw driver to assemble it on the machine.
2. Lower the upper shaft with the ROLL DIE CONTROL (3). Then turn the DIE CENTER CONTROL (7), according to the thickness of the work-piece, to allow an accurate fit of roll die.
3. Adjust the PLATE WIDTH STOP (6) or the STOP GAUGE (5) to fit the size of the work piece.
4. After all the above is done, the ROLL DIE CONTROL (3) must be turned to allow the upper and lower ROLL DIE (1) to slightly press on the metal sheet. While slowly turning the OPERATING HANDLE (8), rotate further the ROLL DIE CONTROL (3) to obtain the required shape.

◆ CAUTION IN USE

1. All parts must be inspected and screws must be tightened before operating.
2. It is strictly forbidden to form metal sheet thicker than the designed capacity (22GA) of the machine.
3. Clean the machine and oil with grease after operation.

◆ ADJUSTMENT OF SHAFT

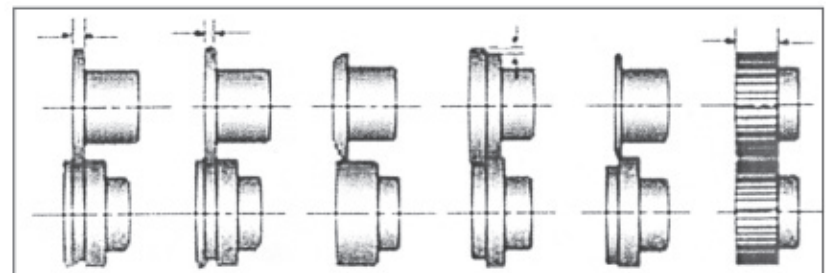
1. The rotary machine allows an extremely fine and horizontal adjustment of the upper shaft to fit various rollers, including the double operations, or which the precision is absolutely essential.
2. The vertical adjustment of the upper shaft is made with the roll die control on top of the body.



1. Roll Die
2. Spring & Shaft Adjusting Bolt
3. Roll Die Control
4. Adjusting Screw
5. Stop Gauge
6. Plate Width Stop
7. Die Center Control
8. Operating handle
9. Base
- Clip bolt

◆ STANDARD EQUIPMENT ROLLS

Refer to illustration below



BENDING TURNING CLOSING JOGGING FLANGING CRIMPING

PARTS LIST

No.	Qty.	Description
1	1	Base
2	1	Stop
3	2	Body
4	1	Die Mounting Plate
5	1	Vise Drive Screw
6	1	Vise Handle
7	1	Vise Face
9	2	Hex Key Bolt
10	1	Gauge Shaft
11	1	Gauge Shaft
12	1	Gauge Locking Screw
13	1	Angle Die
14	2	Hey Key Bolt
15	1	Set Screw
16	1	Bending block Face Plate
17	1	Hey Key Bolt
18	1	Hey Key Bolt
19	1	Spring Pin
20	2	Hey Key Bolt
21	1	Bending Block Locking Plate
22	1	Bending Block Wheel
23	1	Bending Block Shaft
24	1	Bending Block
25	3	Spring Pin
26	1	Hey Key bolt
27	1	Handle
27	1	Round Die Mounting Shaft
29	1	Round Die
30	1	Spring Forming Die "B"
31	1	Spring Forming Die "A"
32	1	Spring Forming Die Mounting Disc

PARTS DRAWING

