

Operating Manual for Metal Ring Bending Machine

手动弯环机使用说明书

一、安装：

装上运输时拆下的手轮手柄，将机器放置平稳，应考虑到做大环时的使用空间。

一、Installing

Place the machine at a steady location, and make space for using when making rings in large size.

And then install the hand wheel and handle which are disassembled during transportation.

二、试运行：

本机电源为三相 380V，操作倒顺开关，使机器运转，摇动手轮，检查各部位是否灵活。

二、Commissioning

The power of the machine is three-phase 380V. Please operate the two direction switch for running the machine. Swing the hand wheel and check the flexibility of machine parts.

三、开机前的准备：

- 1、选定的平条必须符合金属环要求。
- 2、当封面较宽时，请将备用模片换上，使加工出的金属环更加平整。

三、Preparation before starting machine

- 1、Select metal strips which are suitable to make metal ring.
- 2、When the seal face is wider, Please use the standby mold to make the metal ring more smooth.

四、操作步骤:

四、operation steps

1、确定两个主动轮的位置，封面较宽时距离拉开加大，较窄时拉近一点，同时注意对称度，调整好之后拧紧螺母固定。

1、Locate the two driving wheels. Increase the distance between two wheels when the seal face is wide. Close the wheels when the seal face is narrow. Pay attention to the symmetry when adjusting the distance. And tighten nut after adjusting.

2、将平条放入槽内，移动被动轮，使平条单边受力，则平条会成圆弧状走出，平条要从头走到尾部再移动被动板调节尺寸大小，**请不要中途移动被动轮**，平条可反向进行弯环操作。

2、Put a metal strip into the groove and move the driven wheel. Force on one side of metal strip and a arc-shaped strip will go out. The metal strip should go through the end before moving the passive plate to adjust the size. Do not move the driven wheel during the operation. And the metal strips are able to be bent in reverse.

3、测量弯出的环的尺寸，当接近所需尺寸时（ $\pm 5\text{mm}$ ），将料取出至焊接平台，剪掉料头（开始和尾部不规则部份），测量尺寸，在接头处将环剪下。

3、Measure the size of bent ring and take out the material to welding platform when the size is close to required dimensions ($\pm 5\text{mm}$). Cut the irregular parts at the top and end of bent ring. Measure the size and cut down the ring at the connection.

4、焊接：将剪下的环头尾相接进行焊接，建议使用氩弧焊，焊接应充分，不应有漏焊、缺口等，两面均需焊接，然后打磨平整完成操作。

4、Welding: Weld the top and end of the cut ring together. We recommend to use argon-arc welding. It should be welded fully without any solder skips and gap. Both sides of the ring should be welded, and then polished smoothly.