



STRETCHER-SHRINKER OPERATION MANUAL



WARNING

Read and understand all instructions before using this tool. The operator must follow basic precautions to reduce the risk of personal injury and/or damage to the equipment.

HAZARD DEFINITIONS

Please familiarize yourself with the hazard notices found in this manual. A notice is an alert that there is a possibility of property damage, injury or loss of life if certain instructions are not followed.

DANGER! This notice indicates an immediate and specific hazard that will result in severe personal injury or loss of life if the proper precautions are not taken.

WARNING! This notice indicates a specific hazard or unsafe practice that could result in severe personal injury or loss of life if the proper precautions are not taken.

CAUTION! This notice indicates a potentially hazardous situation that may result in minor or moderate injury if proper practices are not taken.

NOTICE! This notice indicates that a specific hazard or unsafe practice will result in equipment or property damage, but not personal injury.

WORK AREA

1. Operate in a safe work environment, Keep your work area clean, well-lit and free of distractions. Place lights so you are not working in a shadow.
2. Keep anyone not wearing the appropriate safety equipment away from the work area.
3. Store unused tools properly in a safe and dry location to prevent rust or damage. Lock tools away and keep out of the reach of children.

Usage

1. This machine is suitable for sheet metal fabricators who need customized processing, such as curve-shaped metal straps, trim, and flanges for car body repair, and other sheet metal work.

2. Main technical specification

Model	SS-18
Capacity of mild Steel	18 Gauge (1.2 mm)
Capacity of aluminum	16 Gauge (1.5 mm)
Capacity of stainless steel	20 Gauge (1 mm)
Throat depth (in./mm)	1" (25.4mm)
Packing Size (L x W x H)	17-23/32" x 4-23/32" x 7-7/8"
	450 mm x 120 mm x 200 mm
Net Weight	11 lbs (5 kg)
Shipping Weight	13.2 lbs (6 kg)

3. Installation and caution

3.1 Installation

3.1.1 Please check whether the part of this machine are fully equipped and not damaged according to the parts list or part figure.

3.1.2 Please leave plenty room around the machine for your easy operating, in order to avoid injury.

3.1.3 Please remove the anti-rust grease on processing surfaces and some parts included kerosene.

3.1.4 At the mounting location, center punch two points 2-1/2" apart, and drill two 3/8" diameter holes at these locations.'

3.1.5 Secure this machine to the workbench or special stand with two 3/8"-16 bolts or cap screws of appropriate length to ensure that the fasteners thread into the casting at least 1/2".

3.1.6 When you need to setup the dies. A) Raise the handle, loosen the four retaining knobs, un-clip the die retainer from the press- sure anvil, and slide the die assembly from the casting. B) On the dies, grasp the die retainer clip and pull the upper jaw from the sheet metal die housing. The rest of the die will come apart easily. Do not lose any springs. C) Clean any old grease, or metal shavings, or debris off of the tool and dies, and lightly oil. D) Use a guide to arrange the die parts in the correct order and reassemble.



3.2 Caution

3.2.1 Please read the manual before operation and make yourself understand its structure and principle completely.

3.2.2 Please don't operate the material width and thickness than table list max. range.

3.2.3 Please don't touch the dies during operation.

4. Operation

4.1 Inserting a piece of metal in either the shrinker or stretcher die and pulling down on the handle to compress or expand the metal at various locations along the length of the metal strip creating the bend or shape needed.

4.2 Select the required die for your task, loosen the four screws and insert the die. A) Using the stretcher die, a curve in metal is created by expanding the outside radius of the curve. B) Using the shrinker die, a curve in metal is created by compressing the inside radius of a curve.

4.3 During the bending process when you work along the strip of metal, to control the clamping pressure to make curves with smooth arc, the lever stop is adjusted with a 4mm hex wrench to allow the clamping lever to stop at the same location every time the lever is pulled down.

5. Maintenance

5.1 Lubricate the rotating parts of the machine every day.

5.2 When the machine is not in use, please protect the long handle will not be touched.

6. Parts list

Part#	description	qty
1	Body	1
2	Pressure arm	1
3	Fulcrum arm	1
4	Lever w/handle	1
5	Pressure arm pin	1
6	Fulcrum arm pin	1
7	Rivet	4
8	Compression spring	1
9	Rivet	2
10	Scr 8-32 x 1	1

Part#	description	qty
11	Die retainer	1
12	Upper shrinker block w/jaws	1
13	Lower shrinker jaw set	1
14	Compression spring	2
15	Lower shrinker block	1
16	Upper shrinker block w/jaws	1
17	Lower stretcher jaw set	1
18	Lower stretcher block	1
19	Scr 8-32 x 5/8	1

7. Assembly diagram

