



GEAR DRIVEN RING ROLLER 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 bending small rod and round steel bar, and others.
2. Main technical specification

Model	PR-3	
Capacity	Round steel	1/4" (6mm)
	Flat steel	1" x 3/16" (25mm x 4.5mm)
Ring Size Rang	Max: 3", Min: 1"	
Handle	13-1/2" (340mm)	
Packing Size	11-13/16" x 7-5/64" x 7-5/64" 300 mm x 180 mm x 180 mm	
Net Weight	13.9 lbs (6.3kg)	
Shipping Weight	15.4 lbs (7kg)	

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 This machine should be mounted on workbench or specific stand (not supplied)

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

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

3.1.5 ASSEMBLY

Step 1: Slide the connector (#19) onto the DRIVE SHAFT II (#17). Make sure the holes line up. See Figure 1.

Step 2: Slide the HANDLE (#15) into the holes of the CONNECTOR and DRIVE SHAFT II.

Step 3: Attach the CONNECTOR to the DRIVE SHAFT II using the TAPER PIN (#20)

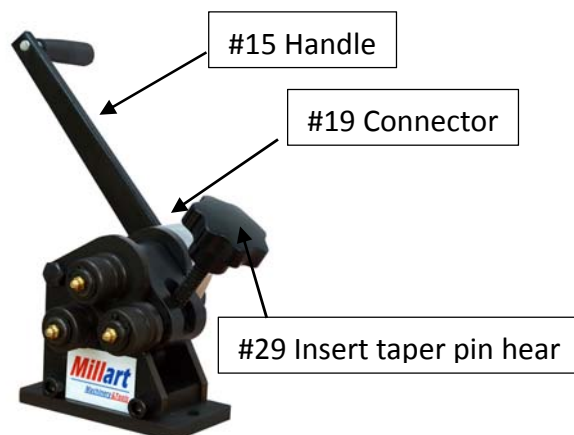


Figure 1



Figure 2

Step 4: Set the unit on the workbench at the desired location.

Step 5: Make sure that you can operate the handle comfortably.

Step 6: Mark the workbench through the two holes in the BASE (#25) of the unit. See Figure 2

Step 7: Remove the unit.

Step 8: Drill holes through the workbench at the marked locations.

Step 9: Mount the unit using two bolts, lockwashers, washers, and nuts (in that order) sold separately.

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 size than table list max. range.

3.2.3 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 or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.

3.2.4 Please don't touch the gear driven during operation.

3.2.5 Do not operate tool if under the influence of alcohol or drugs.

3.2.6 Don't overreach. Keep proper footing and balance at all times.

4. Operation

4.1 Determine the size ring you wish to obtain.

4.2 Move the ADJUSTABLE WHEEL (#16) up or down (as desired) by turning the KNOB (#29). See Figure 3.

4.3 To obtain 1" rings, the ADJUSTABLE WHEEL must be in its uppermost position.

4.4 To obtain 2" rings, the ADJUSTABLE WHEEL must be in the middle position.

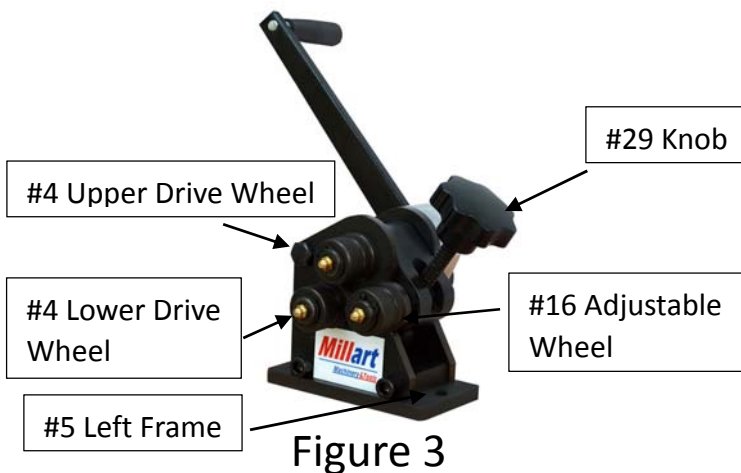
4.5: To obtain larger rings, the ADJUSTABLE WHEEL must be in the lowest position.

4.6: Insert the stock between the upper DRIVE WHEEL (#4) and both the ADJUSTABLE WHEEL and lower DRIVE WHEEL.

4.7: Turn the Knob clockwise to clamp the stock between the WHEELS.

4.8: Rotate the HANDLE (#15) counterclockwise to process the ring.

4.9: To remove completed rings, turn the KNOB counterclockwise to loosen the clamping action.



5. Maintenance

5.1 Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories.

5.2 Keep handles dry, clean, and free from oil and grease.

5.3 The three lubrication points are the DRIVE SHAFT I (#9), DRIVE SHAFT II (#17) and the ADJUSTABLE SHAFT (#18). Grease using the ZERK FITTINGS (#1). See Figure 4.

6. Parts list

Part#	description	qty
1	M8 x 1 Zerk Fitting	3
2	#10 C-Ring	5
2A	#22 C- Ring	1
3	M10 x 60 Hex Bolt	1
4	Drive Wheel	2
5	Left Frame	1
6	Copper Bushing	2
7	Stand	1
8	Bushing	1
9	Drive Shaft I	1
10	4 X 25 Key	4
11	Ring Frame	1
12	Gear	2
13	Cover	1
14	M6 X 45 Hex Key Screw	1

Part#	description	qty
15	Handle	3
16	Adjustable Wheel	5
17	Drive Shaft II	1
18	Adjustable Shaft	1
19	Connector	2
20	8 x 28 Taper Pin	1
21	M10 x 60 Hex Key Screw	2
22	Shaft (W/hole)	1
23	M10 X 16 Hex Key Screw	1
24	3 x 12 Pin	1
25	Base	4
26	Mounting Plate	1
27	Lead Screw	2
28	M6 x 6 Locking Screw	1
29	Knob	1

7. Assembly diagram

