

因为机器在运输途中是不允许有液压油，所以需要客户自己准备。

请准备46号抗磨液压油，加入油缸，机器才能启动

(加油至油缸的三分之二的位置即可)

Because hydraulic oil is not allowed during machine transportation, the customer needs to prepare it themselves. Please prepare No. 46 anti-wear hydraulic oil and add it to the cylinder for the machine to start.

(Fill the tank to two-thirds full.)

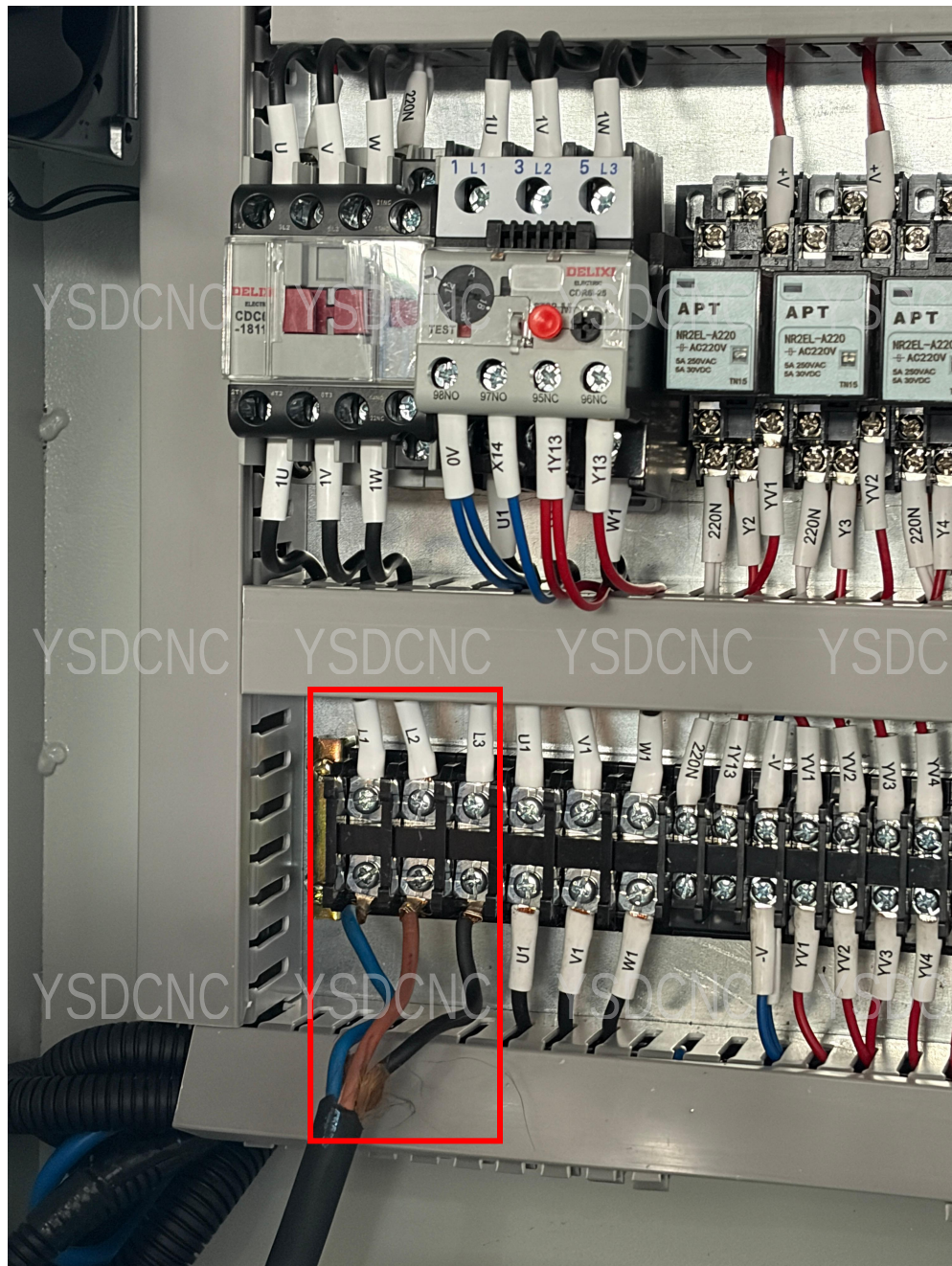




往油缸内加入100升抗磨液压油
加至油表图上箭头指示位置即可

Add 100 liters of anti-wear hydraulic oil to the cylinder, filling it to the level indicated by the arrow on the oil gauge chart below.





- 接入三根线（从工厂的总电源线拉一下，把三根火线接入机器的三根火线的位置）
- 注意：
- 如果线正常连接启动以后，在手动模式时摇动手柄机器无反应，那么可能就是油泵电机的连接线装反了，只需要更换图上的圈出的任意两个线，机器就能正常使用了
- Connect the three wires (run a line from the factory's main power cord and connect the three live wires to the machine's three live wire positions).
- Note: If, after proper connection and startup, the machine does not respond to cranking the handle in manual mode, the oil pump motor connection wires may be reversed. Simply replace any two wires circled in the diagram, and the machine should function normally.



1.接入气管

2.接入脚踏开关

1. Connect the air supply line

2. Connect the foot switch





打开急停开关，按下油泵启动

Release the emergency stop switch and press the button to start the oil pump.



打开手动模式

摇动手柄机器，机器运行有反应代表接线正确

如果机器运行无反应，代表接线错误，需要更换三根火线里的任意两根线

Switch to manual mode.

Crank the handwheel. If the machine responds, the wiring is correct.

If there is no response when cranking, the wiring is incorrect. Swap any two of the three live wires.

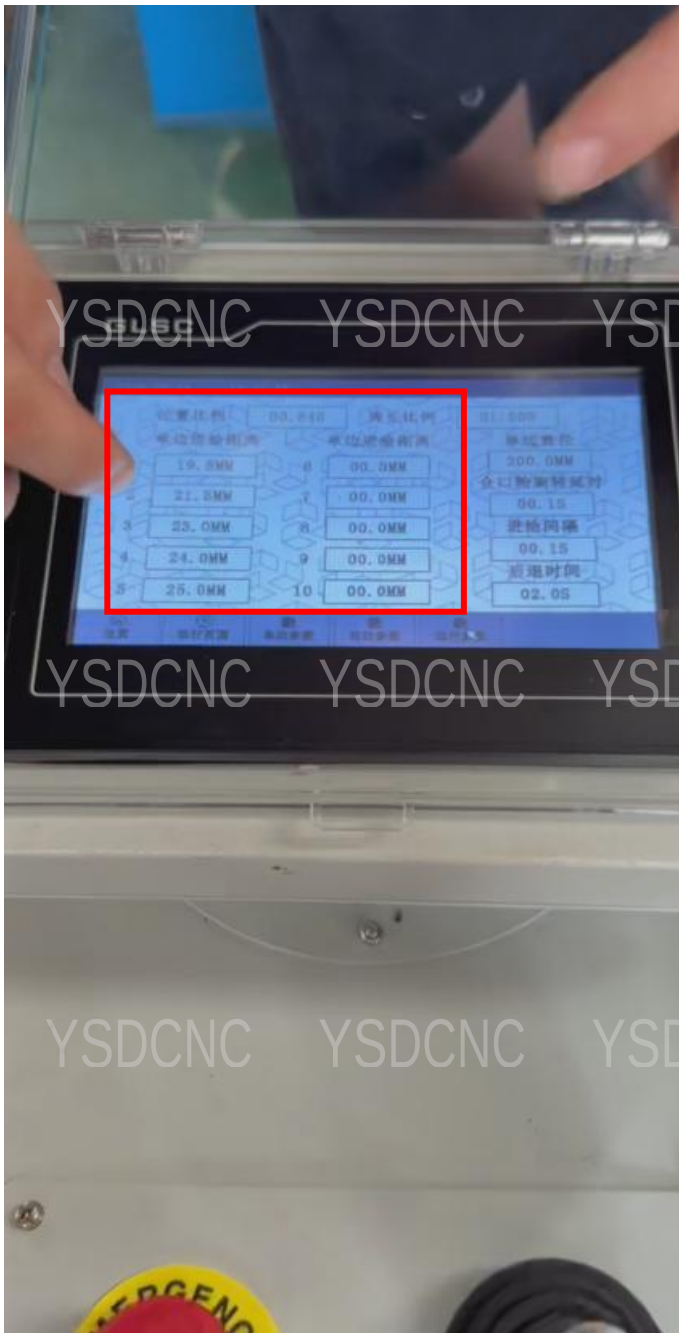


关于如何设置单边参数中的进给距离

- ① 首先打开手动模式，打开单边模式
- ② 拿一个工件放在咬合处，摇动手柄使其咬紧
- ③ 咬紧后查看当前位置的数值是多少，目前显示为“19.8mm”
- ④ 点击单边参数，进入该页面

How to set the feed distance for single-side parameters

- ① Switch to manual mode, then enable single-side mode.
- ② Place a workpiece at the clamping position. Crank the handwheel to clamp it tightly.
- ③ After clamping, check the value of the current position. The displayed value is "19.8 mm".
- ④ Click single-side parameters to enter this page.



把当前位置的数值“19.8mm”填入“1”的方框中，
然后每1mm或者1.5mm的依次往上增加（想要咬合的速度更快可以选择1.5mm）

举例：1的进给距离为“19.8mm”，
那么2的进给距离就是“20.8mm”或者“21.3mm”，
3的进给距离就是“21.8mm”或者“22.8mm”

这样依次增加直到25mm，轮子的最终距离就是25mm，
如右图所示

Input the current position value "19.8 mm" into the box
marked "1".

Then increase the value incrementally by 1 mm or 1.5 mm
each step. Select 1.5 mm for a faster clamping speed.

Example:

Feed distance for step 1: "19.8 mm"

Feed distance for step 2: "20.8 mm" or "21.3 mm"

Feed distance for step 3: "21.8 mm" or "22.8 mm"

Continue increasing in this way until reaching 25 mm. The
final roller distance is 25 mm, as shown in the right figure.

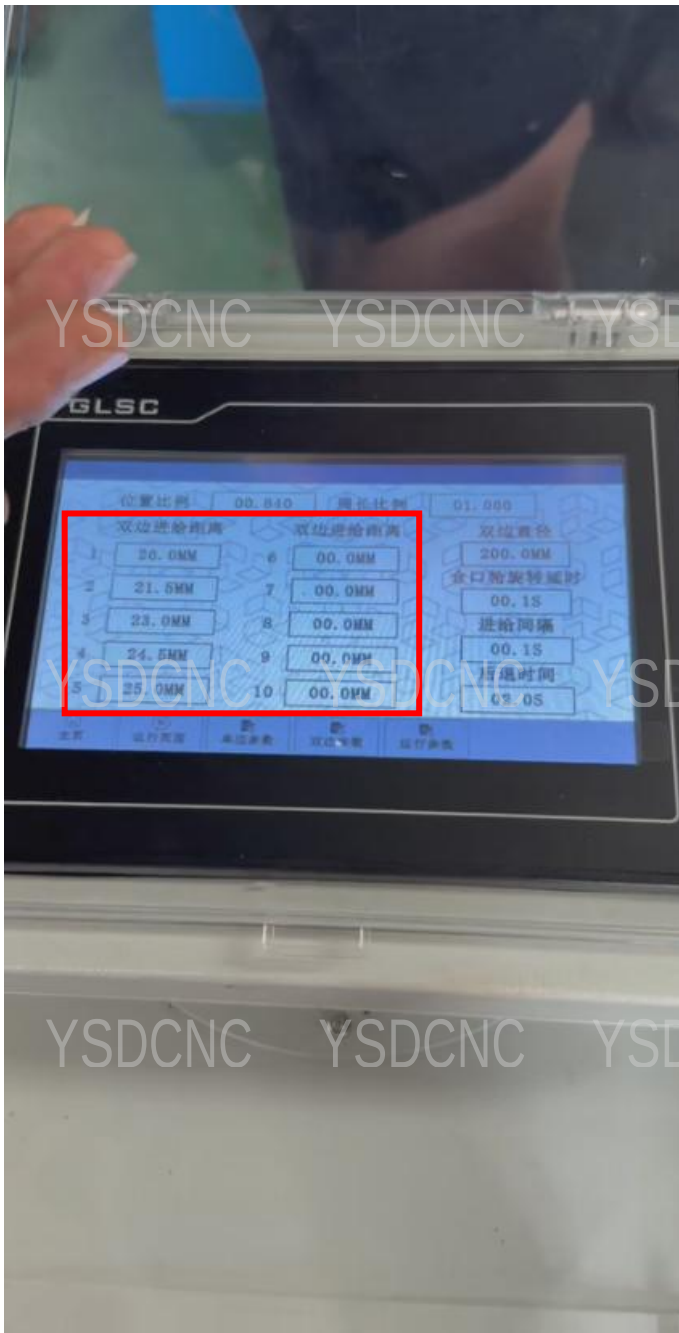


关于如何设置双边参数中的进给距离

- ① 首先打开手动模式，打开双边模式
- ② 拿一个工件放在咬合处，摇动手柄使其咬紧
- ③ 咬紧后查看当前位置的数值是多少，目前显示为“19.8mm”
- ④ 点击双边参数，进入该页面

How to set the feed distance for double-side parameters

- ① Switch to manual mode, then enable double-side mode.
- ② Place a workpiece at the clamping position. Crank the handwheel to clamp it tightly.
- ③ After clamping, check the current position value. The displayed value is "19.8 mm".
- ④ Click double-side parameters to enter this page.



把当前位置的数值“19.8mm”填入“1”的方框中，
然后每1mm或者1.5mm的依次往上增加（想要咬合的速度更快可以选择1.5mm）

举例：1的进给距离为“19.8mm”，
那么2的进给距离就是“20.8mm”或者“21.3mm”，
3的进给距离就是“21.8mm”或者“22.8mm”
这样依次增加直到25mm，轮子的最终距离就是25mm，
如右图所示

Input the current position value "19.8 mm" into the box marked "1".

Then increase the value step by step by 1 mm or 1.5 mm each time. Choose 1.5 mm for a faster clamping speed.

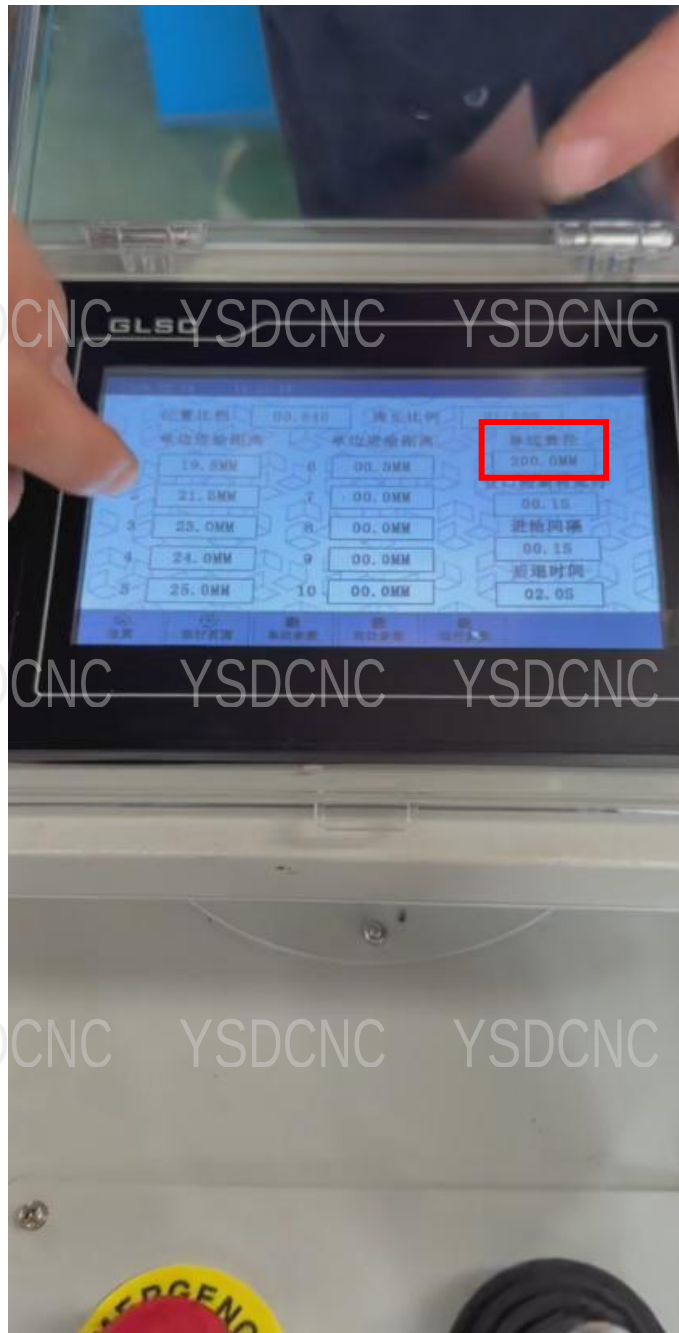
Example:

Feed distance for step 1: "19.8 mm"

Feed distance for step 2: "20.8 mm" or "21.3 mm"

Feed distance for step 3: "21.8 mm" or "22.8 mm"

Continue increasing in this manner until reaching 25 mm.
The final roller distance is 25 mm, as shown in the right figure.



图中所圈出的“单边直径与双边直径”是指“管的直径”

根据要制作的管的实际直径填入即可

举例：要制作的管直径为“200mm”

那我们填入“200mm”

The circled items "Single-side Diameter" and "Double-side Diameter" in the figure refer to the diameter of the pipe.

Enter the actual diameter of the pipe you intend to fabricate.

Example:

If the pipe to be fabricated has a diameter of "200 mm", enter "200 mm".



1. 主压轮咬合工件圆筒后，设备运行会产生向右的作用力，需要以中心为基准向右倾斜 15° 。

(倾斜角度不可过大，角度偏大会导致成型边大小不均)

2. 调节左侧限位靠轮贴合圆筒外壁并锁紧，阻挡工件向右位移，防止加工脱出；右侧限位靠轮保持松开状态，不得接触工件。

3. 限位轮只需贴合消除间隙，严禁强力挤压管壁，防止转动阻力过大、划伤工件。

4. 调试完成后点动试运转，工件转动顺畅无窜动，方可批量生产。

右边限位靠轮千万不要顶上去，否则管子会卡死！



1. After the main pressure wheel clamps the cylindrical workpiece, the machine will generate a rightward force during operation. Tilt the wheel 15° to the right based on the center reference.

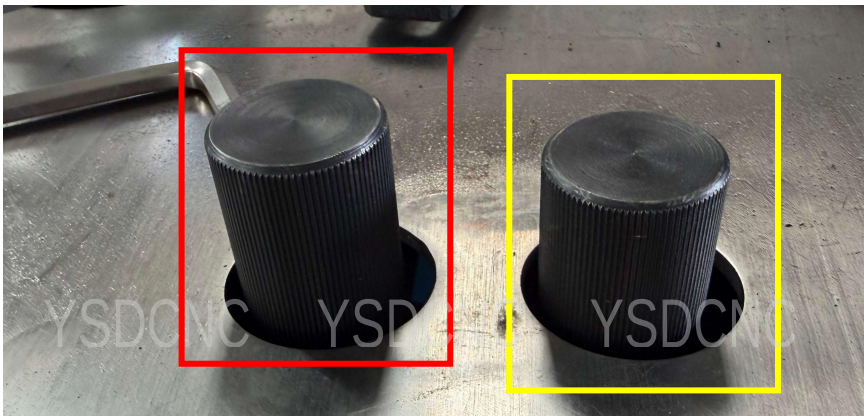
(Do not use an excessive tilt angle. A too-large angle will cause uneven finished edges.)

2. Adjust the left limit roller to fit the outer wall of the cylinder and lock it. This prevents the workpiece from shifting right and slipping out during processing. Keep the right limit roller loose; it must not touch the workpiece.

3. The limit roller only needs to be fitted to eliminate gaps. Do not squeeze the pipe wall forcefully, as this will create excessive rotation resistance and scratch the workpiece.

4. After commissioning, perform a jog test run. Batch production can only start when the workpiece rotates smoothly without axial movement.

⚠ **Never push up the right limit roller, or the pipe will jam!**



主压轮高度调节，适用板厚：0.5mm 板材

红色方框为左侧高旋钮：控制单边主压轮高度

黄色方框为右侧低旋钮：控制双边主压轮高度

模式互锁提醒：

调单边高度，需要打开【双边模式】旋钮才能拧得动

调双边高度，需要打开【单边模式】旋钮才能拧得动

Main Pressure Wheel Height Adjustment | Applicable sheet thickness: 0.5 mm

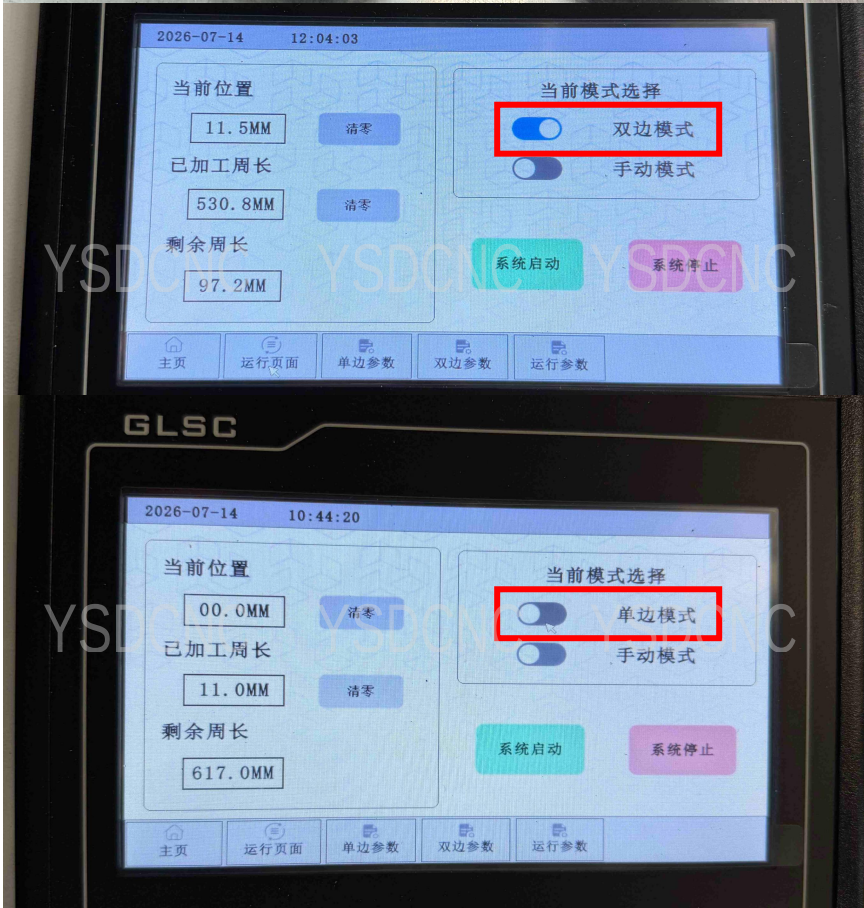
The red box marks the left high knob: it controls the height of the single-side main pressure wheel.

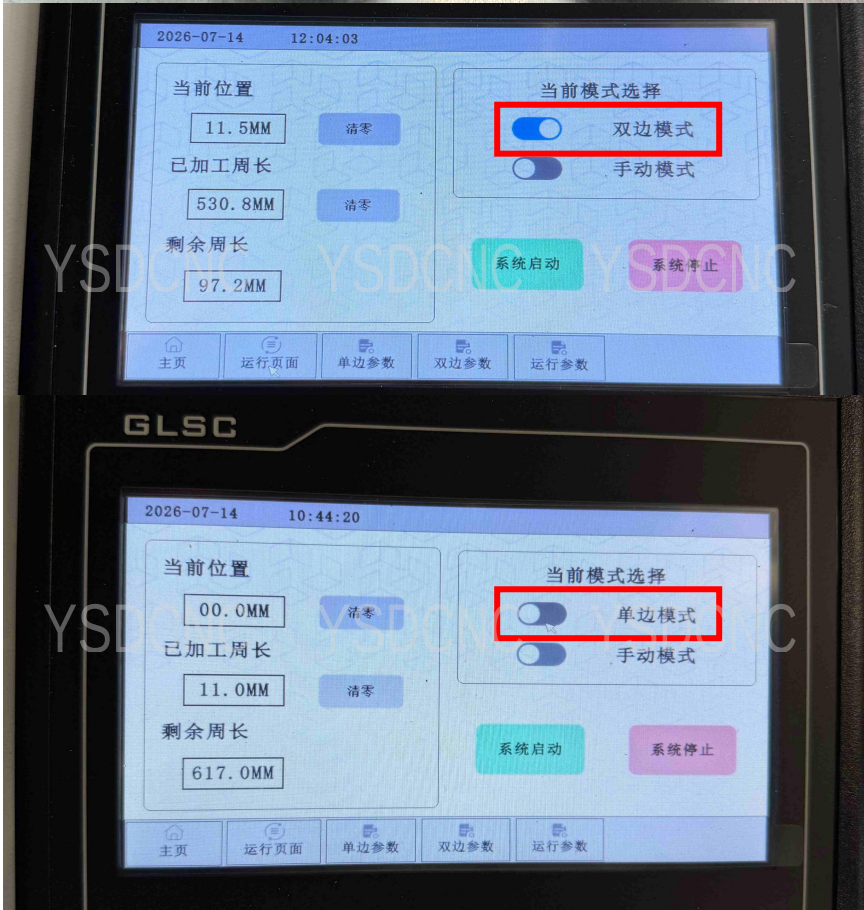
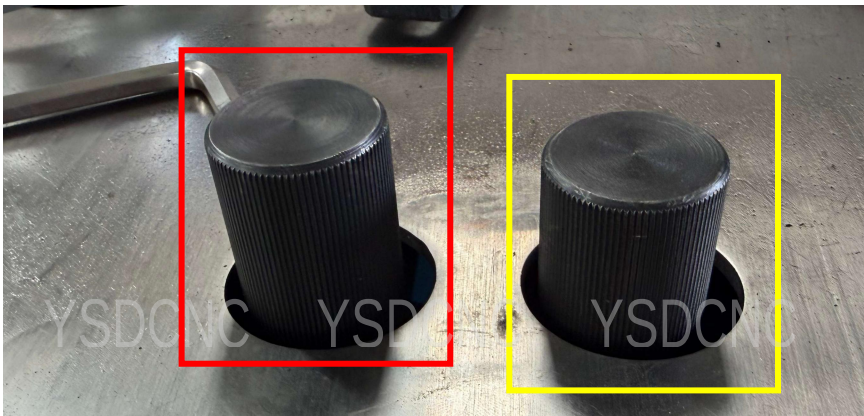
The yellow box marks the right low knob: it controls the height of the double-side main pressure wheel.

Mode Interlock Reminder:

To adjust the single-side height, turn on the **Double-side Mode** knob first, then the knob can be rotated.

To adjust the double-side height, turn on the **Single-side Mode** knob first, then the knob can be rotated.





操作步骤

1. 切换对应工作模式

调单边 → 开启双边模式，调节左侧红色方框内的旋钮

调双边 → 开启单边模式，调节右侧黄色方框内的旋钮

2. 小幅度旋转旋钮，不要一次性大幅拧动

3. 使用量尺测量压轮与工作台实际间隙，微调至标准数值

4. 放入板材试走料，校验压合效果

Operating Steps

1. Switch to the corresponding working mode

· For single-side adjustment: Enable double-side mode, then adjust the knob in the red box on the left.

· For double-side adjustment: Enable single-side mode, then adjust the knob in the yellow box on the right.

2. Rotate the knob in small increments. Do not turn it sharply by a large amount at one time.

3. Measure the actual gap between the pressure wheel and worktable with a measuring ruler, and fine-tune to the standard value.

4. Feed a sheet for trial run to verify the pressing effect.



测量位置说明

上图：单边主压轮间隙（手指指示压轮底面到工作台间隙）

下图：双边主压轮间隙（手指指示压轮底面到工作台间隙）

0.5mm 板材标准参数

单边模式：实测间隙 3.0-3.2 mm

双边模式：实测间隙 7.0 mm

（可以有0.3mm的误差）

重要：调节旋钮后，必须使用塞尺 / 卡尺实测间隙



Measurement Position Instructions

Upper figure: Single-side main pressure wheel gap (the finger points to the gap between the bottom of the pressure wheel and the worktable).

Lower figure: Double-side main pressure wheel gap (the finger points to the gap between the bottom of the pressure wheel and the worktable).

Standard Parameters for 0.5 mm Sheet

Single-side mode: Measured gap 3.0–3.2 mm

Double-side mode: Measured gap 7.0 mm

(Tolerance: ± 0.3 mm)

Important: After adjusting the knobs, always measure the gap physically with a feeler gauge or caliper.





图中指出的是1.0-1.2mm板厚的一副压轮，
根据要制作工件的板厚选择轮子，
更换压轮需要两个一起更换

The rollers indicated in the figure are for sheet
thickness of 1.0–1.2 mm.

Select the rollers according to the sheet
thickness of your workpiece.

Both rollers must be replaced together when
changing rollers.



选择垫片时，根据实际板的厚度x3倍

(x3倍之后，可以再多一些放量)

举例：制作的是0.5mm的板，那么就要选择1.8mm的垫片

Select shims based on three times the actual sheet thickness.

(A small additional allowance can be added after multiplying by 3.)

Example: For a 0.5 mm sheet, select a 1.8 mm shim.



1: 抱紧弯头

踩下脚踏开关 → 弯头执行抱紧动作。

2: 设置转速

调节面板调速旋钮，转速设置60 以上。

3: 压合测试工件

再次踩下脚踏开关，咬合位置压死，放入工件进行测试。

4: 松开工件取出

再次踩下脚踏开关，弯头松开，取出加工工件。



Operation Steps

1.Clamp the elbow

Step on the foot switch → the elbow performs clamping action.

2.Set rotation speed

Adjust the speed control knob on the panel. Set the speed above 60.

3.Press-test the workpiece

Step on the foot switch again to fully lock the clamping position.
Insert the workpiece for testing.

4.Release and take out workpiece

Step on the foot switch once more; the elbow opens. Remove the finished workpiece.



更换垫片，步骤所图所示

Shim Replacement

Follow the steps shown in the figure to replace the shims.



选择抱臂时，需要根据要加工的管径来选择
左图黄色箭头所示：管径为500-1000mm时使用
右图绿色箭头所示：管径为1000mm以上时使用
机器上安装的是200-500mm管径使用
总共配有三副

Arm Selection

Select the clamping arm according to the pipe diameter to be processed.

As indicated by the yellow arrow in the left figure: for pipe diameters of 500–1000 mm.

As indicated by the green arrow in the right figure: for pipe diameters above 1000 mm.

The arm installed on the machine is for pipe diameters of 200–500 mm.

A total of three sets of arms are supplied.