



Isitan

USER`S MANUAL

MODEL IKMP 1,2

**MOTORISED
SWAGING MACHINE**



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1. GENERAL NOTES

1.1 INTRODUCTION

Thank you for choosing a Isitan Sheet/Metal Working Machine. We are proud to have you in our long list of satisfied customers all over the world.

This User's Manual is absolutely for your safety and is essential for the machine to have a long production life. As long as you keep up with our Manual you'll be able to run your machine smoothly and safety. Keep in mind that the machine is firstly designed for maximum safety and secondly for efficient working.

Before connecting the machine double-check electrical connection read the instructions carefully.

Almost a 65 % of the failure reports we receive is based on either wrong electric connection or use in contradiction to user User's Manual.

On all steps of installation, operation and maintenance safety must be your first concern for the protection of yourself, other users and the life of the machine.

In case of any failure please first refer trouble-shooting guide then if a solution can not be found contact first of all the distributor where you purchased our product. Do not forget to refer to te drawing and the numbers for any spare part needed or to define any problem.

Our Technical Staff will make their best to help you in the most convenient way.

1.2 TRANSPORT

As soon as you receive the machine, check for any visible transport damages. Should there be any visible damages; report it straight away to the transporter company and of course Isitan Mak. San. Tic. Ltd.Şti. or your supplier.

*Remove any protective crates around the machine and read the instructions on related chap-ters of this Manual carefully to set up the machine. If the machine is damaged while transport, **imme-diatelly take some photographs for insurance** claims.*

Take precautions while loading / unloading or moving the machine to avoid any injuries. Refer also to related chapter of this Manual for the best way of handling the machine.

1.3 ELECTRICAL INFORMATION

All necessary connection procedure can be found on this Manual. Do not try to connect the machine before reading these procedures and fully understanding the drawings. For any unclear matters get in touch with Isitan Mak. San. Tic. Ltd.Şti. or any of the Isitan distributors. Have the machine con-nected by a qualified electric technician. For, as we made clear in the "general conditions of guaran-tee", under no circumstances installing mistakes, including electrical connection mistake, can not be covered by guarantee agreement. Always turn off power before making any connections or discon-necting the machine.

1.4 MAINTENANCE

Your machine is designed and produced to work efficiently and smoothly. To achieve this you should also take care while operating the machine. Regard Maintenance Sections to have the longest life from your machine. Try and use original spare parts where necessary and most importantly do not overload the machine or do not make any unauthorized modifications.

1.5 SAFETY

Take all precautions possible to avoid any personal injury while using the machine. Keep in mind to protect the third party people around the machine. Refer to safety directives.

2. LIMITED WARRANTY FOR ALL ISITAN PRODUCTS

Limits of Warranty:

We as Isitan manufacture and control our machines with utmost care in total good intention and try to avoid any exposed areas on the machine that can injure the user. Our CE-Mark is product of this intention and all guards and protective measures have been placed on the machine with this intention.

We Isitan Mak. San. Tic. Ltd.Şti. as the manufacturer of the described machine herewith guarantee our machines for a period of 12 months from the date of purchase against manufacture defects and manufacture defect based failures. However this warranty is limited to the following cases and in no event shall Isitan or its suppliers be liable for any special, incidental, indirect, or consequential damages whatsoever (including without limitation, damages for personal injury, loss of business, loss of business profits, business interruption and any other related/non-related loss) arising out of the use or inability to use the machine. Furthermore Isitan is only responsible for the parts manufactured by Isitan and any other brand of components on the machine is subject to warranty conditions of their own manufacturer.

- Machine failures in normal operation
- Defect components
- Manufacture defect based problems

In any case Isitan responsibility does not exceed supply and/or replacement of spare parts. If a Isitan technician is needed for the replacement and/or repair, depending on the situation this can be charged to the customer in terms of travel and accommodation cost and labor cost on a per hour basis.

Cases where warranty is not applied

- All wearing parts during the normal operation of the machine are excluded from the warranty.
- Failure to report any damage to the Isitan distributor or Isitan directly.
- Any transport damages.
- Any misuse, abuse and use in contradiction to the User's Manual.
- Any electric connection based faults.
- Any user mistakes.
- Any modification and /or repair carried out by any other person/company without written consent of Isitan Mak.Ltd.Şti.
- Any damage caused by inevitable events as burglary, natural catastrophes, fire, terror and war activity etc.

The application of warranty is not limited to the clauses above and Isitan reserves the right to make any changes to the applicable items above.

Isitan Mak.Ltd.Şti advises the end-users to make Product Liability Insurance. For further information on this matter please contact local insurance companies.

For any legal purposes regarding this warranty Bursa(TÜRKİYE)courts and laws will be applied.

3. ATTENTION

As soon as you receive the machine check for any visible transport damages. If there are any visible damages immediately report it to the transporter company and of course Isitan or your supplier.

Remove any protective crates around the machine and read the instructions carefully to set up the machine. If the machine is damaged while transport, immediately take some photographs for insurance and future reference purposes. Failure to do so may result in the termination of your guarantee and insurance claims.

This User's Manual is absolutely for your safety and is essential for the machine to have a long production life. As long as you keep up with our Manual you'll be able to run your machine smoothly and safely. Keep in mind that the machine is firstly designed for maximum safety and secondly for efficient working.

4.SAFETY

4.1.SAFETY NOTES

The Isitan Motorised Swaging Machine is supplied with necessary guards to protect from injuries. The only other area which needs to be carefully monitored during use is the rotation of the rolls. Also abuses and misuses should cause following problems:

- Serious injury of the user*
- Serious damage to the machine*

All persons who is in charge with the machine should carefully read and fully understand this manual for the benefit of themselves.

This is for your safety!

Beware!

Never try to bend very hard or fragile material on the machine (e.g.hard steel,glass) as it may explode and cause serious injury to the user and to the machine.

Any modification on the machine without written confirmation from the manufacturer is strictly forbidden as such changes in the machine can cause unintended damages or injuries.

All orders and advises in this Machine should be strictly obeyed for a safe working environment.

4.2.MAIN PURPOSE OF THE MACHINE

The main purpose of the machine is to bend various profiles to the edge of the material (sheet metal) by using the roll sets.

4.3 NOISE

The noise of the machine during operation is below than 70 Db.

4.4 DANGER ZONES

The rolls' area of the machine is the most dangerous area of the machine. Only the user himself is responsible for his safety. Even the danger here is not very significant and avoidable following points must be done in case of any emergency.

- Motor should be immediately stopped by Emergency Button.*
- If this is not possible the electric plug should be removed.*
- Never remove any guards before completely stopping the machine.*

4.5 PERSONNEL

Personnel under age 16 years is strictly forbidden to operate the machine (EG-Law)

The operator of the machine should carefully read this Manual and understand the dangers that he might be in if he misuses or abuses the machine. If any part of this Manual is unreadable or misunderstood please contact with dealer or manufacturer.

The owner of the machine should be responsible for operating the machine with qualified personnel.

4.6 PERSONNEL PROTECTION

No special protection is needed during the normal operation of the machine. Only hand gloves are recommended to avoid minor cuts in the hands which may be caused by the material.

4.7 PROTECTION ON SETUP

The machine must be firmly and rigidly bolted to the ground (Look foundation plan 6.3.). An unsteady machine have the risk of over-dropping and may cause serious personnel injury and can even be fatal. Also while setting up the

4.8 SAFETY EQUIPMENT

Your machine is designed and produced to work efficiently and safety. To achieve this you should also take care while operating the machine.

Always check all guarding plates of the machine are on it before starting operation.

4.9 IMPORTANT NOTES

The machine must be used by qualified personnel at all times.

All modifications and changes on the machine without the written confirmation of manufacturer is forbidden and if such a case occurs all responsibilities of the manufacturer will be out of consideration.

Any such modification is also breaking of European Norms and Laws.

The machine must be stored and used in closed areas. Take care not to put near any explosive, flammable or any dangerous articles.

In case of using any non-original spares or accessories causing injuries and damages, manufacturer will not be responsible of such claims.

If any damage occurs on the machine whether it is visible or hearable immediately stop the machine and contact with your dealer or directly with the manufacturer.

5. PROTECT ARRANGEMENT

Before starting to operate the machine please check the list below carefully every time for a safe start. This will protect the user and also the machine.

5.1 PROTECT ARRANGEMENT CHECKLIST

- Guarding Plates must be mounted and bolted tightly.*
- Emergency Stops must be free and easily accesible.*
- Electric Box must be tightly bolted and grounded.*
- Warning labels must be clearly visible. If any labels are lost or unreadable contact with the manufacturer for new ones.*

6. SETTING UP

6.1 OPENING THE PACKAGE

If you see any damage on the machine when you receive it immediately inform your dealer or the manufacturer. Also never forget to state any damages on transporting documents.

The packing material is completely safe and do not consist any environmentally dangerous articles. However they must be kept out of children's reachable area that some nylon products may cause suffocation if used as a toy etc.

6.2 SETTING UP

While setting up the machine dimensions that should be taken as reference are given in the machine's working area.

The machine does not need to be fixed to the ground as it is possible to use it both vertically and horizontally. Any flat and preferably concrete base will be sufficient. However parallelism of the machine base must be checked with a water gauge for accurate working.

6.3 FOUNDATION PLAN



6.4 ENVIRONMENT CONDITIONS

To get a higher working performance and to lengthen the life of the machine take care with the replacement place to these:

- Keep away from machines that make sawdust and dust.
- Keep away from machines that may cause vibrations.
- The machine should be replaced on a concrete surface against vibration.

6.5 CLEANING OF THE RUST COVER

Every part in the rust cover must be cleaned before using the machine. For cleaning you can use Nitro or Triklorutlen.

6.6 SETTING UP AND TRANSPORT

You can lift and carry the machine as shown below. We recommend the use of a web sling or rope capable of lifting at least 1000 kgs.

IKMP – 1,2 = 110 kgs



The machine must be carried carefully with the help of a crane as shown above. Do NOT lift from anywhere else other than the lifting ring.

7. PREPARING TO START OPERATION

7.1 ELECTRICAL CONNECTIONS

Warning!

All electrical connections must be performed and completed by a qualified electric technician in order to prevent injuries or damages that can be by wrong connection. The cable must be directly connected to the machine. No intermediates should be used. The following pages contain the necessary diagram of electrical connections.

Ensure that Electric Net is capable up to V. Double check the grounding for a safe operation.

7.2 ROTATION OF THE MOTOR After completing the electrical connections check the rotary axis of the motor. If the rotation axis is wrong check the electrical connections carefully to get the correct rotation of the motor.

7.3 BEFORE OPERATING

Before operating be sure that this Manual is thoroughly read and understood by the personnel who will directly operate the machine.

7.4 LUBRICATION

The machine needs to be lubricated periodically for efficient working and a longer life. You can see the points of lubrication on the figure below.

If the machine works more than 8 hours a day it must be lubricated more often. Some lubrication points shown below are actually inside the machine and the back cover must be opened to grease them. For greasing any commercial grease can be used.



The machine needs to be thoroughly lubricated. Lubrication once a week to moving parts in full working conditions will be satisfactory. If the machine has not been used for a long period of time an inspection and lubrication of moving parts may be needed.

7.5 MAINTENANCE

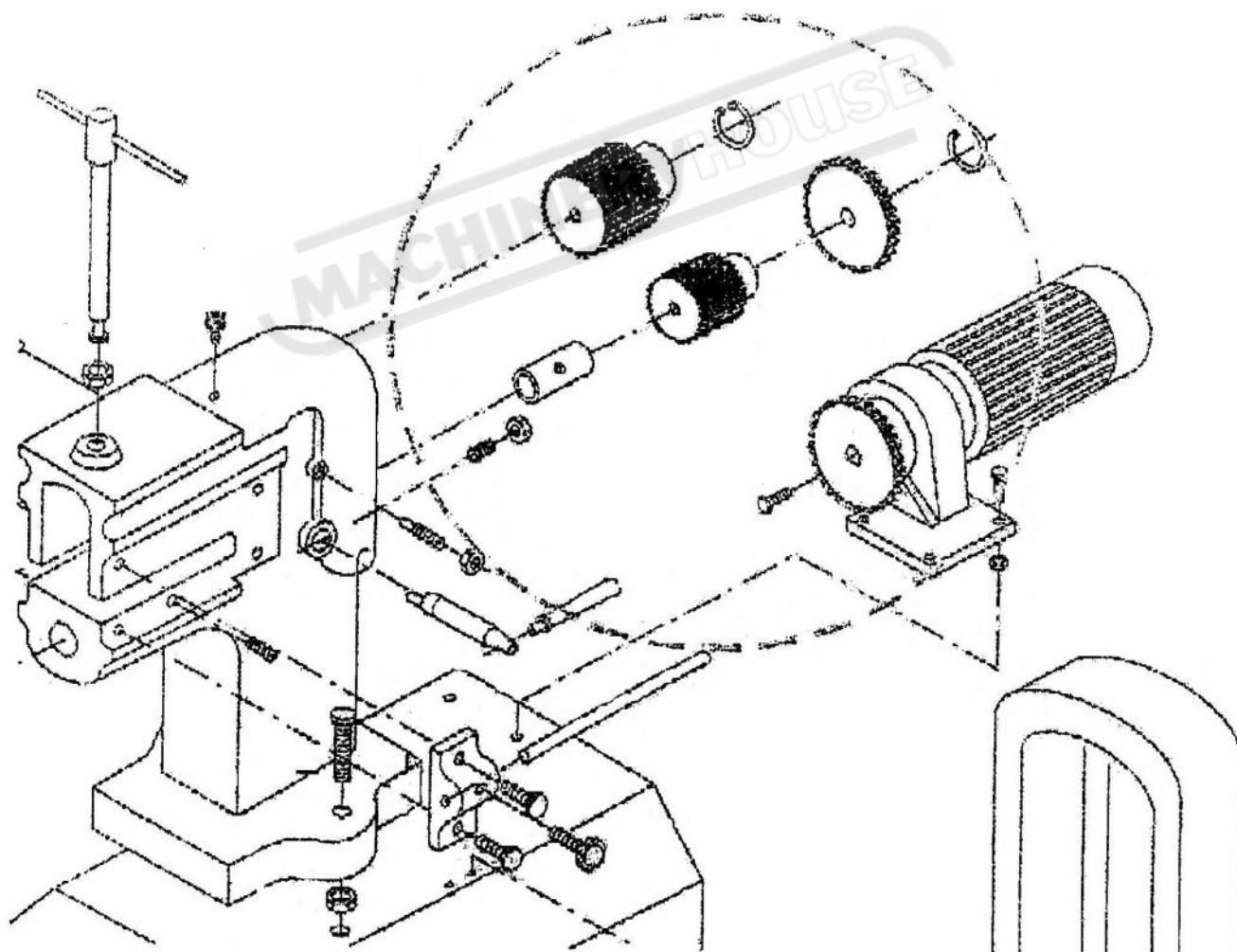
PERIODIC CONTROLS

The rolls of the machine must **NEVER** be greased or lubricated. Because, then the rolls will slip the material and will not bend or not cut. Always keep the rolls clean and free from grease or any lubricant. Also make sure that the material is free from grease and dirt.

These points must be greased periodically at least once a month or more if daily usage exceeds 8 hours a day. Note that some of these points are actually inside the machine cover and the front cover must be removed in order to reach them. Any seal Grease (shell seal Grease 3) can be used for lubrication.

NUMBER	PERIOD	WHAT TO DO
Gear System	Once a month	Grease

“Shell Seal Grease 3”



8. OPERATION

The material to be bend must have the following qualities:

- It must be flat and smooth and free from grease and dirt.
- Must not exceed the machine capacity.

8.1 MOUNTING THE ROLLS

First of all the necessary type of rolls must be mounted to the machine. The top roll has right thread and the bottom roll has left thread. These nuts must be tightened securely when setting up the rolls.

8.2 BOTTOM ROLL ADJUSTMENT

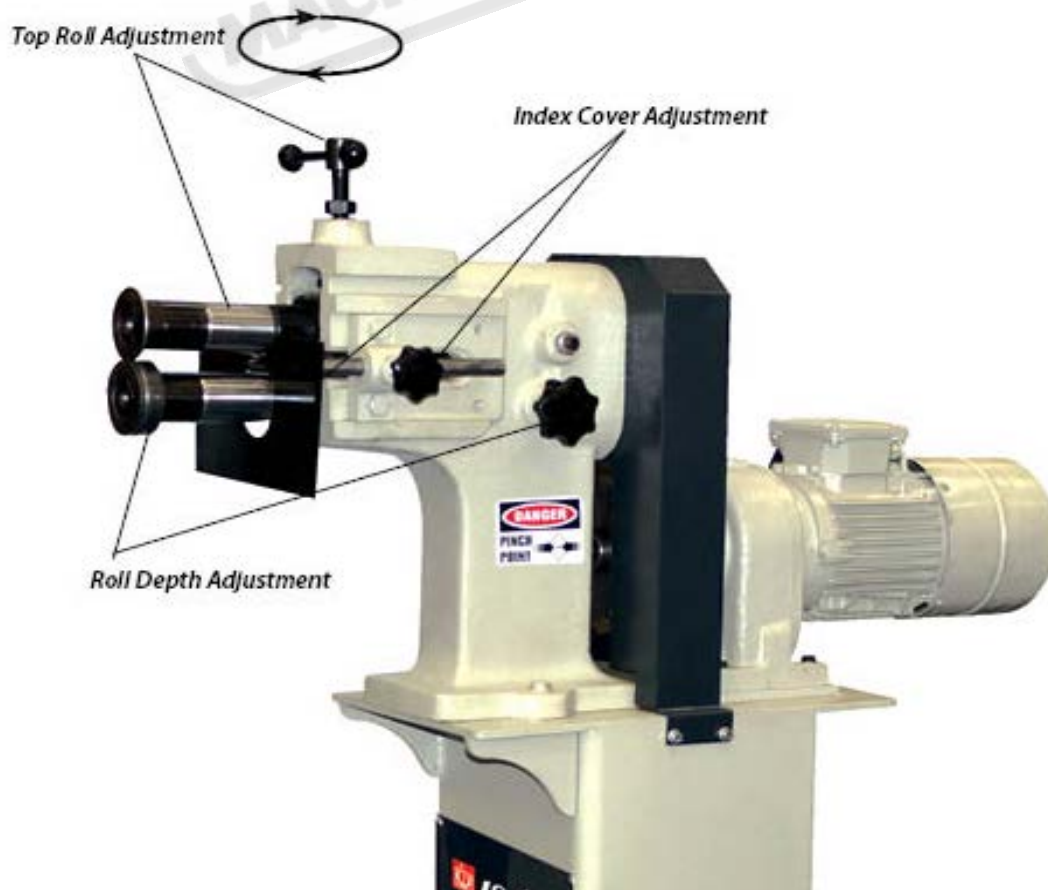
By using the lever on left side bottom roll shaft length is adjusted to work parallel with the top roll. When you are satisfied with the parallelism you can tighten the bolt of bottom roll on right hand side of the machine and fix the position of bottom roll.

8.3 INDEX COVER ADJUSTMENT

By using small levers on the top of the machine you can adjust the index cover position according to the material position.

8.4 BENDING

You can now insert the material between the rolls and stuck the material between the rolls by moving the top roll to position with the hand wheel. Also the index cover should be used to achieve accuracy. This cover can be used as a gauge for the material lead and throughout the entire operation the material should be touching the index. Now you can bend the material by using the foot pedal and moving the material front and back.



9. GENERAL INFORMATION

9.1 TECHNICAL DATA

DATA		IKMP 1,2
Roll Length	MM	140
Bending Capacity	MM	1,25
Roll Diameter	MM	62
Throat Depth	Ø MM	100
Motor Rotation	RPM	64
Motor Power	KW	0,75
Length	MM	900
Width	MM	450
Height	MM	1350
Weight	KG	110

This User's manual is intended for both IKMP 1,2 Machines. Although the models are identical there are slight differences in size and weight etc.

Please find the correct measurements for your models while checking this manual.

9.2 PARTS LIST OF IKMP 1,2 MODEL

Assembly No	Part Identification	Assembly No	Part Identification
1	Body	31	Motor Gearbox
2	Protection Cover	32	Platform
3	Lower Shaft	33	Connection Bolts
4	Upper Shaft	34	Nut
5	Roll	35	Main Shaft Ring
6	Pin	36	Bolt
7	Rings	37	Nut
8	Nut	38	Gearbox Cover
9	Inner Bushing	39	Gear Box Connection Bolts
10	Inner Bushing Part	40	Nut
11	Protection Cover Connection	41	
12	Bolts M6	42	
13	Bolts M6	43	
14	Side Fastener Wheel	44	
15	Side Fastener	45	
16	Shaft Hand Wheel Nut	46	
17	Shaft Hand Wheel	47	
18	Shaft Hand Wheel	48	
19	Inner Bushing Bolts	49	
20	Nut	50	
21	Greasing Bolt	51	
22	Bolt	52	
23	Nut	53	
24	Bolt	54	
25	Nut	55	
26	Gear	56	
27	Ring	57	
28	Gear	58	
29	Gear	59	
30	Gear	60	

IKMP MOTORISED SWAGING MACHINE PART LIST

