



Manual / Instruction

PORTABLE REBAR BENDER



PF22B



PF25B



PF32B

Read this instructions carefully before attempting to use .Ignoring proper operating procedure can lead to accidents. If have any doubt about any procedure, contact us.

Parameters

Models	PF22B	PF25B	PF32B
Voltage	240vac	240vac	240vac
Wattage	1100W	1100W	1600W
Bending speed	3-6S	4-7S	5-8S
Bending range (To 90°)	Φ 8 ~ Φ 22	Φ 16 ~ Φ 25	Φ 20 ~ Φ 32
Net Machine Weight	13Kg	16Kg	23Kg
Package Shipping Weight	14.3Kg	22.65Kg	27.4Kg
Machine size	585*220*215mm	585*220*215mm	635*125*200mm
Package size	635*370*200mm	635*370*200mm	780*300*250mm
Note: Don't use the machine to bend steel bars that exceed the maximum bending size.			

CONTENTS

Using Attentions.....	1
warning!☆☆.....	1
Caution! ☆☆.....	2
Common safety precautions.....	2
Hydraulic oil fuctions.....	3
Warning!☆☆.....	3
Caution!☆☆.....	4
Refueling hole location and refueling method.....	4
Cautions before using.....	5
Correct Operating method.....	6
Inspection and maintenance.....	7
Machine assembly drawings and accessories.....	8
Common malfunction and solutions.....	12
Accessories.....	14

Using Attentions

Before using the portable hydraulic bending machine, please read this manual for safe operation. The operation methods and safety precautions mentioned in this manual are only applicable to the equipment mentioned in this manual. All safety problems caused by failure to operate according to the prescribed methods are the responsibility of the user.

1. Failure to comply with the contents of (Warning!) may cause personal accidents.
2. Failure to comply with the contents of (Caution!) may cause machine damaged or malfunction.

warning!☆☆

1. Don't use this equipment outside the scope specified in the manual.
2. Please strictly follow the instruction manual for correct operation and safe operation. Non-professionals are prohibited from using it. At the same time, for professional operators, please use it after training.
3. Because moisture will reduce the insulation of the motor, it may cause an electric shock accident. Therefore, do not perform steel bending operations in the rain, damp places, places with water, and places where water or oil is likely to enter the machine.
4. In order to prevent electric shock accidents, please use the power supply through the leakage circuit breaker. In addition, in addition to double insulation, please be sure to install the correct grounding "ground wire".
5. Please fully keep the workplace bright, and always pay attention to rectification. Scattered places will become the cause of accidents.
6. Rectification sparks may occur during the use of the bending machine, and sparks may also occur when the switch is opened and closed. Therefore, it is dangerous to work in places where paint, paint, volatile oil, gasoline, gas, adhesives, etc. may cause fire or explosion. Please never use it. At the same time, it is forbidden to use this equipment in closed rooms, tunnels and other places with poor ventilation.
7. Except operators, other personnel, please do not approach the work site, do not touch power tools and wires, etc.
8. Please wear neat clothes for work. Fat clothes, clothes with open cuffs, towels wrapped around the head, knitted gloves, ties, necklaces and other accessories may get caught in the rotating part of the machine and cause personal injury.
9. Operators are requested to wear safety helmets and safety shoes.
10. Wear protective goggles for work. In addition, in dusty places, please use a dust mask and dust collector (dust collector) at the same time.
11. Before turning on the equipment, please make sure that the bolts are not loose or fall off.
12. Please use the voltage indicated on the nameplate for the power supply. If the voltage exceeds the indicated voltage, the rotation of the motor will become abnormally high speed, which may damage the motor, body, etc., and cause danger. Conversely, the use of low voltage will also

become the cause of motor failure.

13. Before inserting the plug into the power supply, please confirm whether the switch is disconnected to avoid sudden start of the machine.

14. Do not move the machine when the plug is connected to the power source. Even if you don't put your finger on the switch, if clothes or other things are hung on the switch, accidentally closing the switch will cause an accident.

15. Please always pay attention to the soles of your feet and work in a stable posture. Working in an inappropriate posture will bring danger.

16. If the machine is found to be in bad condition or abnormal during use, please stop using it immediately and check and repair it immediately.

17. Do not use the machine and accessories outside the scope of its use capacity, and do not perform excessive operations. Unsuitable work not only causes damage to the machine, but also is dangerous, please avoid it.

18. In order to make the equipment safe and efficient use, please check regularly. If repairs are required, please contact the supplier. In addition, when replacing parts, be sure to use designated parts.

Caution! ☆☆

1. If the device is dropped, the outer frame may be deformed or cracked or damaged by collision, so be careful. If there is any abnormality, please repair it immediately.

2. Grasp the wire to transport the product or pull the wire to unplug it from the socket, which will damage the wire and cause disconnection or short circuit. At the same time, please be careful not to make the lead wire come into contact with blades, hot objects, chemicals, etc. When the wire is damaged, stop the operation immediately and repair it in time.

3. The wind window of the machine is a necessary part of cooling the motor, please do not block it due to dust. If it is clogged, the temperature of the motor will rise and become the main cause of burnout.

4. Please always pay attention to cleaning the machine and keep it in the best condition. Especially the dust on the motor part and the switch part, and it must be wiped off after each use.

5. Please keep the machine and its accessories in the following places:

- A. Places out of reach or locked by children's hands.
- B. A place where the temperature and humidity do not change drastically.
- C. A dry place without humidity.
- D. Don't place the machine in where cause fire and explode easily

Common safety precautions

1.1 Operating

1.1.1 The steel bar bending machine is only suitable for steel bars.

1.1.2. Please note that there will be steel bars splashing when bending

1.1.3. Materials exceeding the specified specifications will greatly increase this risk and damage the tool. Don't try to bend steel bars that are harder and thicker than specified.

1.2 Caution in using

1.2.1 Wear safety goggles, use side protective glasses or use protective covers when using protective covers.

1.2.2 Provide a safety barrier. In order to protect colleagues from possible interference at the end of the flight, a safety barrier needs to be erected. When working at high places, place the steel bars under the safety screen.

1.2.3 Appropriate control

Hold the machine firmly and maintain a proper foothold and balance. Do not overextend when working at high places. Use a safety rope to fix the knife on the scaffold. Check whether the power cord is contaminated and keep the cord away from sharp edges and heat.

1.2.4 Protection against electric shock

To avoid electric shock, do not handle the bending machine with wet hands, nor use the bending machine in rainy or humid places. Pay attention to all possible contact wires, circuits and other possible contact hazards. Especially those objects that are below the surface or hidden out of view.

1.2.5 Pay attention to the environment

Do not use knives in the presence of flammable materials (such as paint, thinner, petroleum products, adhesives). Do not use the bending machine where there are no lights and obstacles. The operator should have an unobstructed view of the tool, steel reinforcement and surrounding area at all times.

1.2.6 Wear suitable clothes

Don't wear loose clothes, hanging objects or jewelry, pay attention to long hair. It is recommended to use hard hats and rubber-soled boots. If you wear safety gloves, be especially careful not to let the gloves get stuck on moving parts.

1.2.7 Keep others safe

All visitors should keep a safe distance from the work place to protect themselves and prevent operators from being distracted.

1.2.8 Storage

When not in use, store the cutter and accessories in a dry place out of the reach of unauthorized persons.

Hydraulic oil functions

Warning! ☆☆

1. The hydraulic oil entering the eyes may cause inflammation, so please wear protective glasses during operation to prevent the hydraulic oil from entering the eyes. Contact with the skin may cause inflammation, so please wear protective gloves before operation.

2. Emergency treatment:

A. After entering the eyes, please wash with clean water first, and then receive a doctor's diagnosis in time.

B. After touching the skin, please wash it off thoroughly with water and soap.

C. After drinking it by mistake, please do not force it to vomit, please accept the doctor's

diagnosis immediately.

3. Treatment of waste oil:

Do not dispose of waste oil in the sea, rivers, lakes, other rivers, or in drains to prevent fire hazards from polluting the environment.

Cautions! ☆☆

Please check the oil level before operation. (46# anti-wear hydraulic oil is recommended for this series of products)

Hydraulic oil is the power medium of the equipment. The reduction of the oil volume will result in the reduction of power and the performance cannot be fully utilized. Therefore, please check the oil volume before operation. In addition, if the temperature of the machine body reaches 70° C or higher, the power will be reduced, so please cool down, and then turn on the machine after the standby body has cooled down.

2. Please perform warm-up operation.

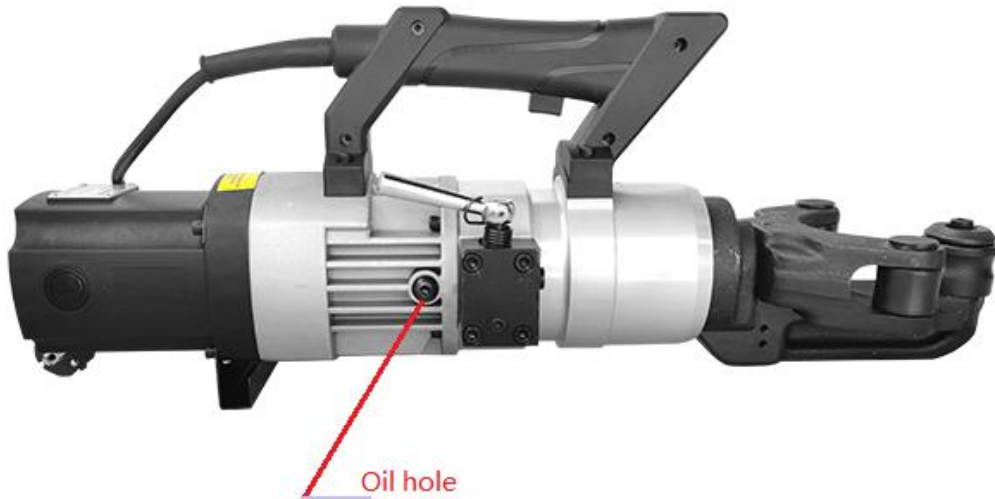
In winter, the low-temperature hydraulic oil sometimes freezes and is difficult to start, so please preheat it for about 30-60 seconds without load before bending.

3. Please turn off the switch once.

When the switch is kept on, the piston sometimes goes in and out continuously, so after confirming that the piston has reached the top end, be sure to turn off the switch once before using it.

Refueling hole location and refueling method

1、 Refueling hole location:



PFXXB type Rebar bender Refueling hole location

Note: Due to different models, the Exterior maybe have some difference

2、 Refueling method

- 2.1. Place the bender flat on the desktop,the oil hole face upwards.
- 2.2. Unscrew the screw at the oil hole.
- 2.3. Slowly inject hydraulic oil from oil hole.
- 2.4. First add some hydraulic oil, block the hole and press the bender switch to make the bender shaft move forward slowly,then inject the hydraulic oil after moving a certain distance, repeat this operation until the hydraulic oil is filled up when the bender shaft moves to the limit position , And then press the manual pressure relief valve to return bender shaft and repeat the operation until the machine works normally.
- 2.5. Finally, tighten the screws and finish Refueling.

Cautions before using

1. Confirm the power supply.
Make sure to use the power supply voltage specified on the nameplate.
2. Check the power socket.
When the plug is inserted into the socket, if it is wobbly or can be easily unplugged, it needs to be repaired. If it is still used as such, it will cause an accident due to overheating.

Correct Operating method

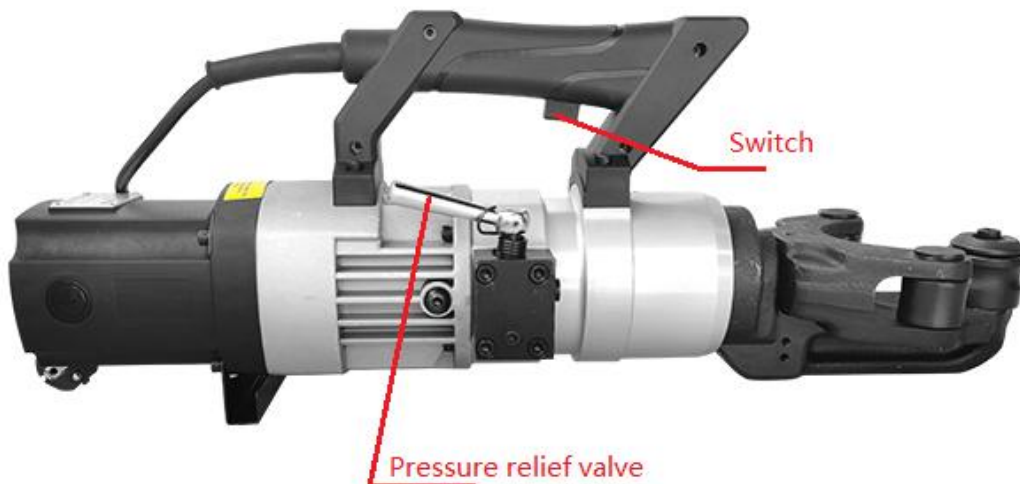
1、 Confirm whether the steel bar is placed in the correct position firstly, please put the steel bar at the bottom between the head frame and the push block . as the diagram show



2、 After place the bar,start the switch.

3、 The the push shaft forward, and the steel bar is bent. When the push shaft is advanced to the proper position, release the switch. Pull the manual pressure relief valve, and the push shaft will return automatically.

4、 The positions of the switch and manual pressure relief valve are as below diagram



5、 Until the push shaft has completely returned to its original position, press the switch,if the push the shaft can't move,it is reason that pressure relief valve has not been fully returned, Continue pull the pressure relief valve,let it fully return .

6、 When the push shaft cannot return normally, press the pressure relief valve,use bar to tap the push shaft,let it back.Then it can recover normally.

Inspection and maintenance

1. Check the hydraulic oil quantity

A. After work long time, the hydraulic oil will become turbid and contain impurities. At this time, all the oil in the machine needs to be poured out and replaced with new oil

B. Sometimes the oil is sufficient but there is no power. This is because the parts (piston, plunger valve core) in the pump are worn out. Please consult with supplier.

2. Please clean the area around the push shaft regularly.

A. Unplug the plug.

B. Wear leather gloves.

C. When the compressed air is cleaning, the steel plate iron filings are dangerous as a needle, so please wear leather gloves to clean it. And it is dangerous to enter people's eyes or inhale it.

3. For long-term storage, you need to discuss with the supplies whether has necessary to replace the internal spring, oil bag and other parts before restart using.

4. Carbon brush

Check the carbon brushes at least twice a month. (The normal use time is 200 hours.)

Note: Worn carbon brushes will cause power loss, heat up the motor part, and cause irreparable damage to the motor commutator.

Method of checking carbon brush

4.1. Unplug the power plug

4.2. Unscrew the brush cap and pull out the carbon brush.

4.3. If the length of the carbon brush is less than 6 mm, it should be replaced immediately.

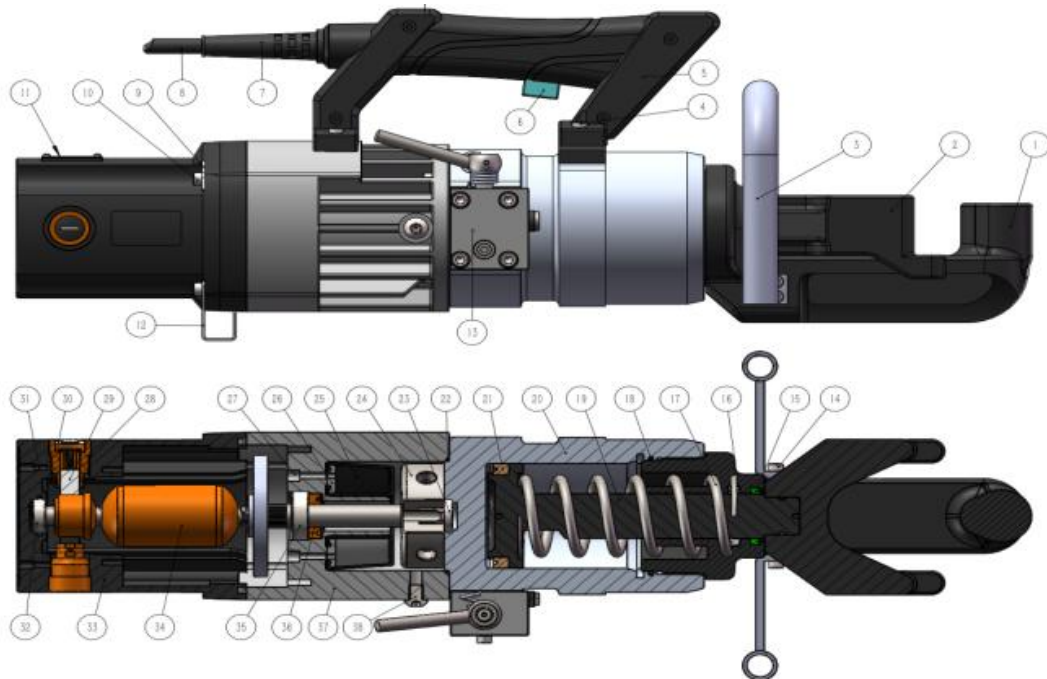
IMPORTANT!!!

Clean and lubricate slide way regularly

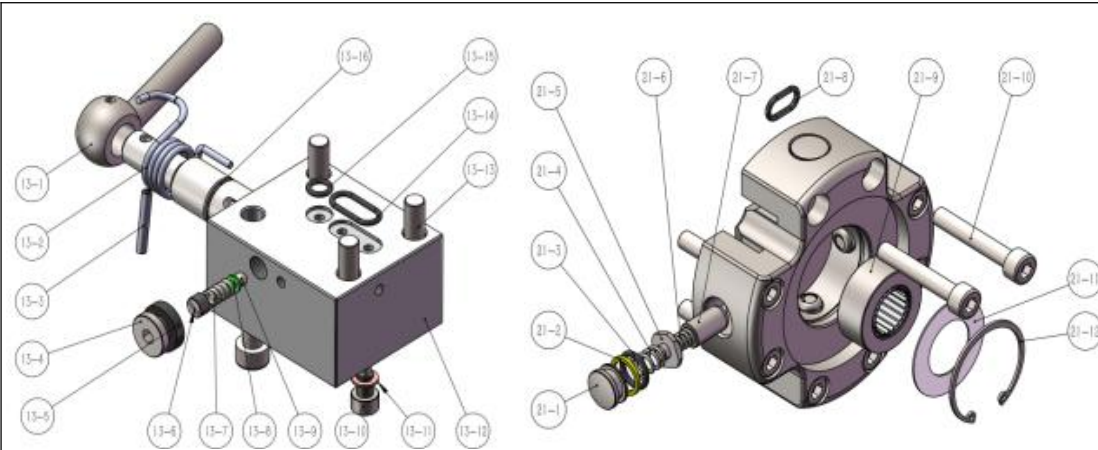


Machine assembly drawings and accessories

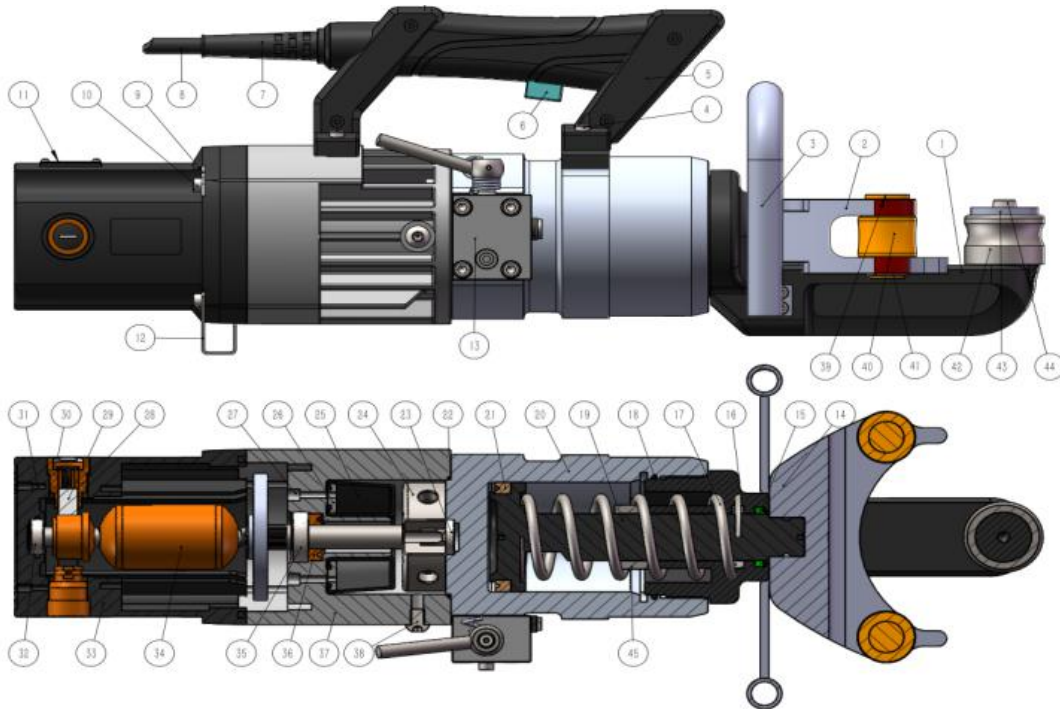
PF22B ACCESSORIES LIST



Numb er	Name	Amou nt	Numb er	Name	Amou nt
1	Front seat	1	22	O-ring $\Phi 73 \times 2$	1
2	Jaw	1	23	Bearing 608	1
3	Handle	1	24	Plunger assembly	1 set
4	Hexagon socket bolt M5*25	4	24~1	Plunger cap	4
5	grip	1 set	24~2	Fluorine rubber retaining ring	4
6	power switch button	1	24~3	O-ring $\Phi 11 \times 1.5$	4
7	Power cord rubber sheath	1	24~4	Plunger check valve compression spring	4
8	Power line $3 \times 1.5 \text{mm}^2$ With plug	1	24~5	Plunger check valve	4
9	Shaped Gasket	2	24~6	Plunger return compression spring	4
10	Hexagon socket bolt M5*35	4	24~7	piston $\Phi 7$	4
11	Nameplate	1	24~8	O-ring $\Phi 11 \times 1.5$	4
12	Bracket	1	24~9	Needle bearing $12 \times 24 \times 10$	1
13	Manual pressure relief valve assembly	1 set	24~10	Hexagon socket bolt M5X25	8

					
Manual pressure relief valve assembly			Plunger assembly		
13~1	Wrench	1	24~11	Wear-resistant sheet	1
13~2	Torsion spring	1	24~12	Circlip $\Phi 28$	1
13~3	Split pin $\Phi 3 \times 18$	1	24~13	Plunger body $\phi 73$	1
13~4	Hexagon socket bolt M8X1.0-8	1	25	Annular oil bag	1
13~5	Rubber pad	1	26	Oil bag pressure plate	1
13~6	Flat bolt M6X0.5-4	1	27	Hexagon socket bolt M4X20	6
13~7	Compression spring	1	28	Carbon brush holder	2
13~8	Spring drag	1	29	Carbon brush	2
13~9	Steel ball $\Phi 4$	1	30	Carbon brush holder cap	2
13~10	Hexagon socket bolt M5	1	31	Set bolt M4X8	2
13~11	Flat pad $\Phi 5$	1	32	Bearing 608	1
13~12	Manual pressure relief valve body	1	33	Motor plastic shell	1
13~13	Hexagon socket bolt M6X35	4	34	Motor rotor stator assembly 1.1KW	1 set
13~14	O-ring $\Phi 8 \times 1.5$	1	35	Bearing 6002	1
13~15	O-ring $\Phi 15 \times 1.5$	1	36	Skeleton oil seal TC15*30*7	1
13~16	O-ring $\Phi 14 \times 1.5$	1	37	Back cavity	1
14	Hexagon socket bolt M5X12	4	38	Hexagon socket head bolt M8x10 With rubber pad	1
15	Dust seal DHS $\Phi 30 \times \Phi 38-5/6.5$	1			
16	Sealing ring UN $\Phi 30 \times \Phi 40 \times 6$	1			
17	Compression spring $\Phi 55 \times \Phi 6 \times 125$	1			
18	O-ring $\Phi 78 \times 2.65$	1			
19	Piston shaft	1			
20	Cylinder	1			
21	Sealing ring UN $\Phi 55 \times \Phi 70 \times 9$	1			

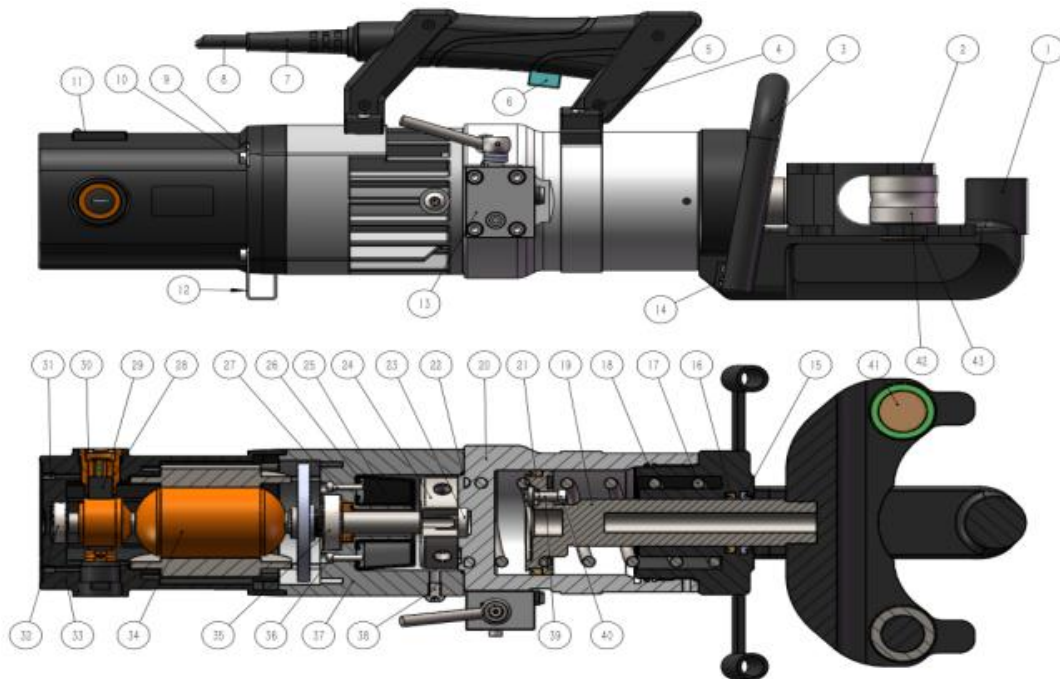
PF25B ACCESSORIES LIST



Numb er	Name	Amou nt	Numbe r	Name	Amou nt
1	Front seat	1	24	Plunger assembly	1 set
2	Jaw	1	25	Annular oil bag	1
3	Handle	1	26	Oil bag pressure plate	1
4	Hexagon socket bolt M5X25	4	27	Hexagon socket bolt M4X20	6
5	grip	1 set	28	Carbon brush holder	2
6	power switch button HY79-21	1	29	Carbon brush	2
7	Power cord rubber sheath	1	30	Carbon brush holder cap	2
8	Power line 3X2.5mm ² With plug	1	31	Set bolt M4X8	2
9	Shaped Gasket	2	32	Bearing 608	1
10	Hexagon socket bolt M5X35	4	33	Motor plastic shell	1
11	Nameplate	1	34	Motor rotor stator assembly 1.1KW	1set
12	Bracket	1	35	Bearing 6002	1
13	Manual pressure relief valve assembly	1 set	36	Skeleton oil seal TC15*30*7	1
14	Hexagon socket bolt M5X12	4	37	Back cavity	1
15	Dust seal DHS Φ30XΦ38-5/6.5	1	38	Hexagon socket head bolt M8x10	1

				With rubber pad	
16	Sealing ring UN $\Phi 30 \times \Phi 40 \times 6$	1	39	Positioning pin	2
17	Compression spring $\Phi 55 \times \Phi 6 \times 125$	1	40	Force sleeve	2
18	O-ring $\Phi 78 \times 2.65$	1	41	External circlip $\Phi 20$	2
19	Piston shaft	1	42	Guide sleeve	2
20	Cylinder	1	43	Pressure plate	2
21	Sealing ring UN $\Phi 55 \times \Phi 70 \times 9$	1	44	Hexagon socket bolt M8X15	1
22	O-ring $\Phi 73 \times 2$	1	45	Limit sleeve	1
23	Bearing 608	1			

PF32B ACCESSORIES LIST



Numb er	Name	Amou nt	Numb er	Name	Amou nt
1	Front seat	1	23	Bearing 608	1
2	Jaw	1	24	Plunger assembly	1set
3	Handle	1	25	Annular oil bag	1
4	Hexagon socket bolt M5X25	4	26	Oil bag pressure plate	1
5	grip	1set	27	Hexagon socket bolt M4X20	6
6	power switch button HY79-21	1	28	Carbon brush holder	2
7	Power cord rubber sheath	1	29	Carbon brush	2

8	Power line 3X2.5mm ² With plug	1	30	Carbon brush holder cap	2
9	Shaped Gasket	2	31	Set bolt M4X8	2
10	Hexagon socket bolt M5X35	4	32	Bearing 6200	1
11	Nameplate	1	33	Motor plastic shell	1
12	Bracket	1	34	Motor rotor stator assembly 1.6KW	1set
13	Manual pressure relief valve assembly	1 set	35	Bearing 6004	1
14	Hexagon socket bolt M5X12	4	36	Skeleton oil seal TC17*30*7	1
15	Dust seal Φ36XΦ48-5/9	1	37	Back cavity	1
16	Sealing ring UN Φ36XΦ46X6	1	38	Hexagon socket head bolt M8x10 With rubber pad	1
17	Compression spring Φ53.5XΦ7X168	1	39	Limit pressure relief shaft	1
18	O-ring Φ85X2.65	1	40	Limit pressure relief shaft lock nut	1
19	Piston shaft	1	41	Force sleeve positioning pin	2
20	Cylinder	1	42	Force sleeve	2
21	Sealing ring UN Φ70XΦ80X8	1	43	External circlip Φ28	2
22	O-ring Φ73X2	1			

Common malfunction and solutions

malfunction	Reason	solutions
Push shaft speed slow and push force small	1. the hydraulic oil is not enough or have air inside 2. The pressure relief valve is damaged	1. Let the oil hole face upwards, continuous start the switch with no load, refueling, press the pressure relief valve until the push shaft can move normally 2. Replace the pressure relief valve
The push shaft can't push out and return normally	1. The flat key in the head is stuck 2. The push shaft expands	1. Replace flat key 2. Let the shaft push out. Sand the high point with sandpaper so that the

		shaft can be retracted and extended normally
Carbon brush sparks is big	1. Carbon brush wear Severe 2. copper pieces on the rotor wear Severe 3. Short circuit	1. Replace the carbon brush 2. Replace the rotor 3. Check whether the circuit is short-circuited
The sound is abnormal when the equipment is running	1. needle bearings Broken 2. Parts loose	1. Replace the needle bearing 2. Check the connection status of each part equipment without power

Note: malfunction not mentioned, please contact supplier.

Accessories

- | | |
|-----------------------|--------|
| 1. Manual instruction | 1 copy |
| 2. Tool kit | 1 set |
| 3. Oil can | 1pcs |
| 4. Certificate | 1 pcs |