

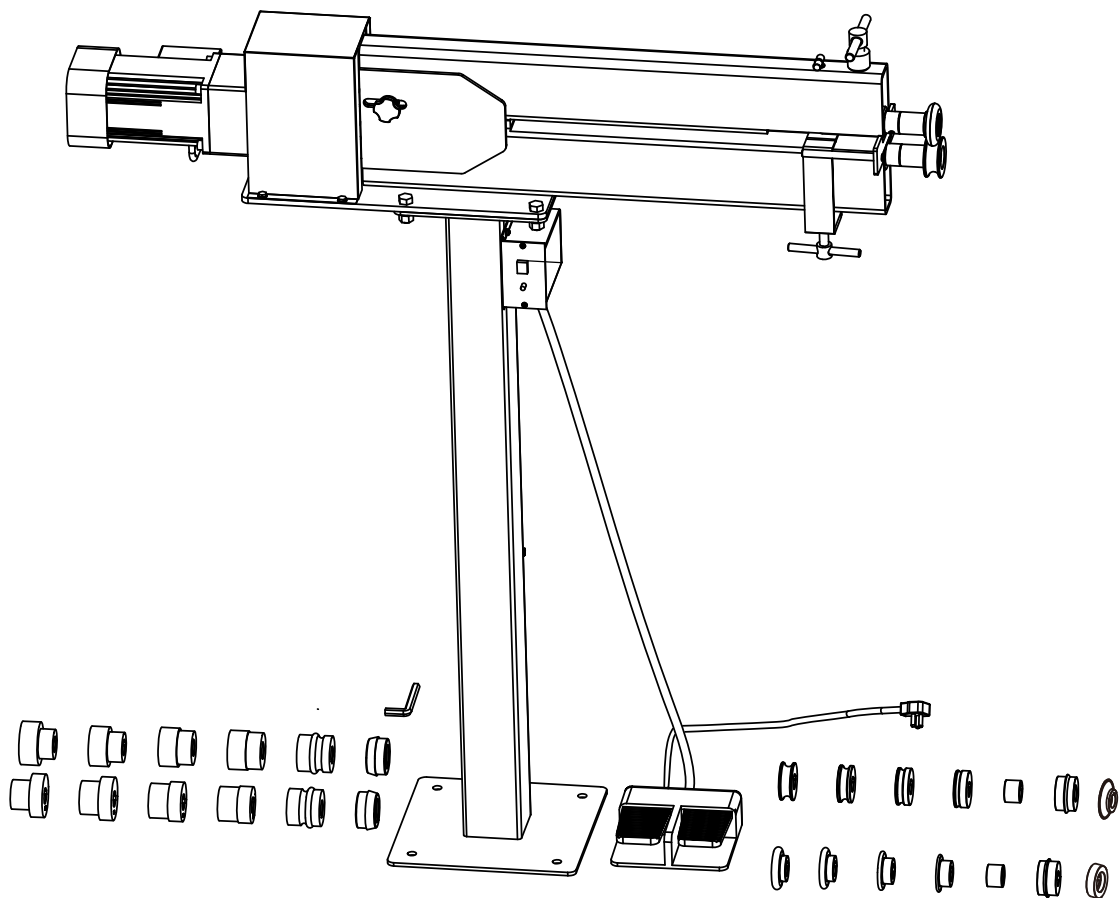
## ASSEMBLY & OPERATING INSTRUCTIONS

**Save This Manual** Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures.  
Keep this manual and the receipt in a safe and dry place for future reference.

ART. V123-06  
ITEM NO. 1071001

  
**KNT-Hjul & Verktyg AB**

# ROTARY MACHINE-POWERED 220V



Diagrams within this manual may not be drawn proportionally.  
Due to continuing improvements, actual product may differ slightly from the product described herein.



**Read this material before using this product.  
Failure to do so can result in serious injury.  
SAVE THIS MANUAL.**

## SPECIFICATIONS

|                                |  |
|--------------------------------|--|
| Motor                          | 180W, 1350RPM, 220V, 50Hz, Single Phase        |
| Speed Range (RPM)              | 0-17   |
| Capacity (mm//gauge)           | 1//20  |
| Guide Fence                    | Adjustable                                     |
| Throat (mm//in)                | 585//23  |
| Bead Mandrels Sizes (mm//in)   | 4//5/32,6.35//1/4,9.5//3/8,12//15/32,15//19/32 |
| Flange Mandrels Sizes (mm//in) | 1.6//1/16,3//1/8,6.35//1/4,9.5//3/8            |
| Shearing Mandrel Quantity      | 1 set  |
| Ogee Beading Mandrel Quantity  | 1 set  |
| Wiring Mandrel Quantity        | 1 set  |
| Wiring Roller Die Quantity     | 1 set  |

### SAVE THIS MANUAL

You will need the manual for the safety warnings and precautions, assembly instructions, operating and maintenance procedures, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep the manual and invoice in a safe and dry place for future reference.

### SAFETY WARNINGS AND PRECAUTIONS

**WARNING:** When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage.

**Read all instructions before using this tool!**

- 1. Keep work area clean.** Cluttered areas invite injuries.
- 2. Observe work area conditions.** Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep work area well lighted. Do not use electrically powered tools in the presence of flammable gases or liquids.
- 3. Keep children away.** Children must never be allowed in the work area. Do not let them handle machines, tools, or extension cords.
- 4. Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
- 5. Do not force tool.** It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool capacity.
- 6. Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. Do not modify this tool and do not use this tool for a purpose for which it was not intended.
- 7. Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.

- 8. Use eye and ear protection.** Always wear ANSI approved impact safety goggles. Wear a full face shield if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, wood, and chemical dusts and mists.
- 9. Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines. Keep hands and fingers clear of the Roll Dies when operating.
- 10. Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and, if damaged, have them repaired by an authorized technician. The handle must be kept clean, dry, and free from oil and grease at all times.
- 11. Disconnect power.** Unplug when not in use.
- 12. Remove adjusting keys and wrenches.** Check that keys and adjusting wrenches are removed from the tool or machine work surface before plugging it in.
- 13. Avoid unintentional starting.** Be sure the switch is in the Off position when not in use and before plugging in.
- 14. Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
- 15. Check for 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 and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the tool if any switch does not turn on and off properly.
- 16. Guard against electric shock.** Prevent body contact with grounded surfaces such as pipes, radiators, ranges and refrigerator enclosures.
- 17. Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool.
- 18. Do not operate tool if under the influence of alcohol or drugs.** Read warning labels if taking prescription medicine to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.
- 19. Maintenance.** For your safety, service and maintenance should be performed regularly by a qualified technician.
- 20. Workpiece may be sharp.** After bending or cutting workpieces use caution. Be aware of sharp edges or sharp shreds of metal that may be created. Use heavy duty gloves when handling the workpiece.

**NOTE:** Performance of this tool may vary depending on variations in local line voltage. Extension cord usage may also affect tool performance.

**WARNING:** The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

## FEATURES

1. Strong steel construction.
2. 12 die sets included to form the most-needed shapes.
3. Reliable motor power.
4. Very easy to use and changing wheels is done in seconds.
5. Forward and Reverse controlled by foot pedal.
6. Easy for operation with Foot Switch.
7. Multiple micro adjustments for accurate rolling precision.
8. Strong steel Stand provides an ideal working height.

## UNPACKING

When unpacking, check to make sure that all parts shown in the Parts Diagram are included. If any parts are missing or broken, please contact the seller.

## ASSEMBLY

The Motor (48#) (Transmission included), Guide Fence (7#), and Double Directions Foot Pedal(76#) come preassembled to the Frame (2#). For additional information regarding the parts listed in the Parts List, refer to the Parts Diagram.

1. Place the Stand (1#) on the floor. Stand to be bolted to floor is required.
2. Place the Frame (2#) on the Stand (1#) with 4 Bolts (42#) , Washers (23#), Spring Washers (12# ) and Nuts (46#).

## OPERATION

### Roller Dies Vertical Distance Adjustment

The vertical distance between the Roller Dies sets (13#-22#,49#-61#) should be adjusted before using,according to the thickness of the workpiece.Adjust the Pressing Clamp (34#) to achieve an appropriate distance between the Roller Dies sets.

### Roller Dies Horizontal Distance Adjustment

1. Only when you change the roller die sets,you need to adjust the roller dies horizontal distances.
2. Remove the Screws (41#) and Fixing Washer (27#) and then you can change to your desired die sets.
3. Assemble the Fixing Washer (27#) and Screws (41#) back and tighten.
4. You can use the Short Bushing (24#) optionally according to the width of the Roller Dies sets.
5. Loosen the Lock Handles (40#) and adjust the Driven Shaft (5#),until the horizontal distances between the Roller Die sets are achieved.
6. Tighten the Lock Handles (40#).

### Guide Fence Adjustment

1. Loosen the Guide Fence Clamp (32#) and Slide the Guide Fence (7#) to your desired

- position.
2. Tighten the Guide Fence Clamp (32#).

### **Usage**

1. Place the Double Directions Foot Pedal (76#) on the appropriate location for safe operation.
2. Plug in the machine.
3. Feed the material into the gap between the Roller Dies sets.
4. You can press the left or the right pedal for forward and reverse movements.

### **MAINTENANCE**

1. Clean the Transmission of dirt and debris after 250 hours of use.
2. Lubricate the Copper Bushing inserted in the Long Sleeve(3#) periodically.
3. Replace the grease in the Worm Gear Box every 2 years.

### **PLEASE READ THE FOLLOWING CAREFULLY**

THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS DIAGRAM IN THIS MANUAL AS A REFERENCE TOOL ONLY. NEITHER THE MANUFACTURER NOR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT. IN FACT, THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

## PARTS LIST

| Part No. | Description             | Qty |
|----------|-------------------------|-----|
| 1        | Stand                   | 1   |
| 2        | Frame                   | 1   |
| 3        | Long Sleeve             | 1   |
| 4        | Slide Block             | 2   |
| 5        | Driven Shaft            | 1   |
| 6        | Driving Shaft           | 1   |
| 7        | Guide Fence             | 1   |
| 8        | Driven Gear             | 1   |
| 9        | Driving Gear            | 1   |
| 10       | Washer                  | 2   |
| 11       | Base                    | 1   |
| 12       | Spring Washer 10mm      | 4   |
| 13       | Bead Roller Die 5/32"A  | 1   |
| 14       | Bead Roller Die 1/4"A   | 1   |
| 15       | Bead Roller Die 3/8"A   | 1   |
| 16       | Bead Roller Die 15/32"A | 1   |
| 17       | Bead Roller Die 19/32"A | 1   |
| 18       | Bead Roller Die 19/32"B | 1   |
| 19       | Bead Roller Die 15/32"B | 1   |
| 20       | Bead Roller Die 3/8"B   | 1   |
| 21       | Bead Roller Die 1/4"B   | 1   |
| 22       | Bead Roller Die 5/32"B  | 1   |
| 23       | Washer 10mm             | 4   |
| 24       | Short Bushing           | 2   |
| 25       | Long Bushing            | 2   |
| 26       | Fixed Bushing           | 2   |
| 27       | Fixing Washer           | 2   |
| 28       | Pin                     | 1   |
| 29       | Coupling Shaft          | 2   |
| 30       | Washer                  | 2   |
| 31       | Pressing Plate          | 1   |
| 32       | Guide Fence Clamp       | 1   |
| 33       | Pressing Plate          | 1   |
| 34       | Pressing Clamp          | 1   |
| 35       | Spring                  | 1   |
| 36       | Key 6X40                | 4   |
| 37       | Connecting Plate        | 1   |
| 38       | Hex Key Wrench 6mm      | 1   |
| 39       | Screw M3X8              | 2   |
| 40       | Lock Handle             | 2   |
| 41       | Scre M10X25             | 2   |
| 42       | Bolt M10X30             | 4   |
| 43       | Bolt M6X10              | 4   |
| 44       | Washer 6mm              | 4   |
| 45       | Screw M8X8              | 6   |
| 46       | Nut M10                 | 4   |

| Part No. | Description                  | Qty |
|----------|------------------------------|-----|
| 47       | Key 5X18                     | 2   |
| 48       | Motor                        | 1   |
| 49       | Shearing Die                 | 2   |
| 50       | Flange Roller Die 3/8"A      | 1   |
| 51       | Flange Roller Die 3/8"B      | 1   |
| 52       | Flange Roller Die 1/4"A      | 1   |
| 53       | Flange Roller Die 1/4"B      | 1   |
| 54       | Flange Roller Die 1/8"A      | 1   |
| 55       | Flange Roller Die 1/8"B      | 1   |
| 56       | Flange Roller Die 1/16"A     | 1   |
| 57       | Flange Roller Die 1/16"B     | 1   |
| 58       | Ogee Beading Die A           | 1   |
| 59       | Ogee Beading Die B           | 1   |
| 60       | Wiring Die A                 | 1   |
| 61       | Wiring Die B                 | 1   |
| 62       | Timing Box Base              | 1   |
| 63       | Timing Box Top               | 1   |
| 64       | Cable Gland                  | 6   |
| 65       | Screw M8X20                  | 8   |
| 66       | Screw M4X8                   | 18  |
| 67       | Sping Washer 8mm             | 8   |
| 68       | Flat Washer 4mm              | 16  |
| 69       | Spring Washer 4mm            | 16  |
| 70       | Flat Washer 3mm              | 2   |
| 71       | Speed Change Device          | 1   |
| 72       | Nut M3                       | 2   |
| 73       | Foot Switch Cable            | 2   |
| 74       | Power Cable                  | 1   |
| 75       | Flat Washer 8mm              | 8   |
| 76       | Double Directions Foot Pedal | 1   |
| 77       | Connecting Wire              | 6   |
| 78       | lock washer 4mm              | 4   |
| 79       | Ground Connection Sign       | 3   |
| 80       | Gear Cover                   | 1   |
| 81       | Safe Cover                   | 1   |
| 82       | Nut M4                       | 5   |
| 83       | Cable Tie                    | 8   |
| 84       | Rubber Washer                | 2   |
| 85       | Insulated Bushing            | 1   |
| 86       | Cable Tie                    | 2   |
| 87       | Insulated Box 1              | 1   |
| 88       | Insulated Box 2              | 1   |
| 89       | Insulated Box 3              | 1   |
| 90       | Wiring Roller Die A          | 1   |
| 91       | Wiring Roller Die B          | 1   |
| 92       | Grease Cup                   | 4   |

# PARTS DIAGRAM

