
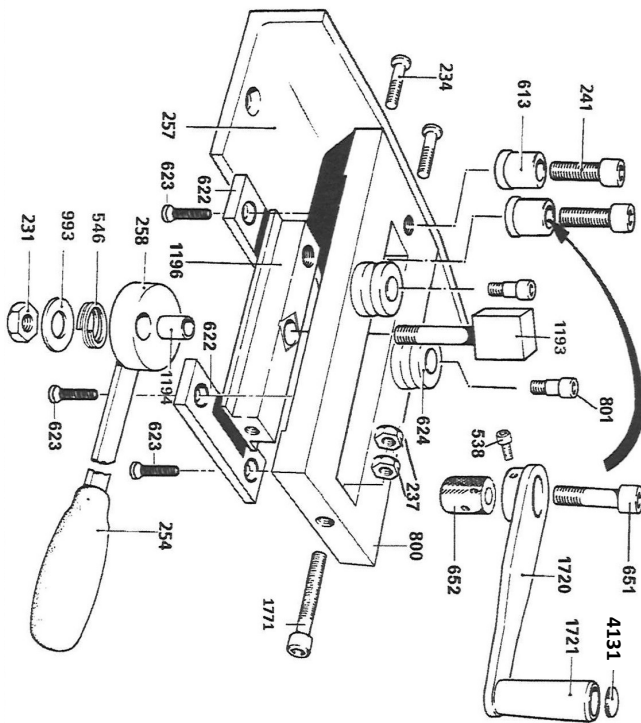


MODIFICATIONS	
Re-allocation of part numbers: P/N 218 becomes P/N 237. Part remains 1/4" BSW nut (black)	6/94
Introduction of strengthened rivet post support P/N 613 replaces P/N 233	6/97
Upgrade to work 20mm x 3mm hot rolled steel	9/88
Introduction of the new winding handle No.s 650,651,652 & 538 replace 240 & 626	1/99
Introduction of revised body & bolts No.s 800,801 replace 625,627	9/01
Modified components P/N 1161, 1162 replace 223 & 228 No 342 removed	06/07
P/N 1193 replaces P/N 1162 P/N 1194 replaces P/N 229 P/N 1196 replaces P/N 1161 P/N 993 replaces P/N 320 P/N 546 added	11/08
P/N 1720 replaces P/N 650 P/N 1721 replaces P/N 389 P/N 1722 replaces P/N 390	03/12
P/N 1771 replaces 236	12/14
Introduction of extra 1/4" nut P/N 237 for repeat bending	5/16
	
<b>Practical Riveting/ Bending &amp; Rolling Tool</b> Part No: 14, version No 3.1	
REF: TR\PRBR\11\93 DTP: SPDRBR:PPP DATE: 05/16	

NOT TO SCALE



**J & CR WOOD**

66 CLOUGH ROAD , HULL, HU5 1SR, TEL: 01482 345067, FAX: 01482 441141

Email: [info@jandcrwood.co.uk](mailto:info@jandcrwood.co.uk) , [www.metal-craft.co.uk](http://www.metal-craft.co.uk)

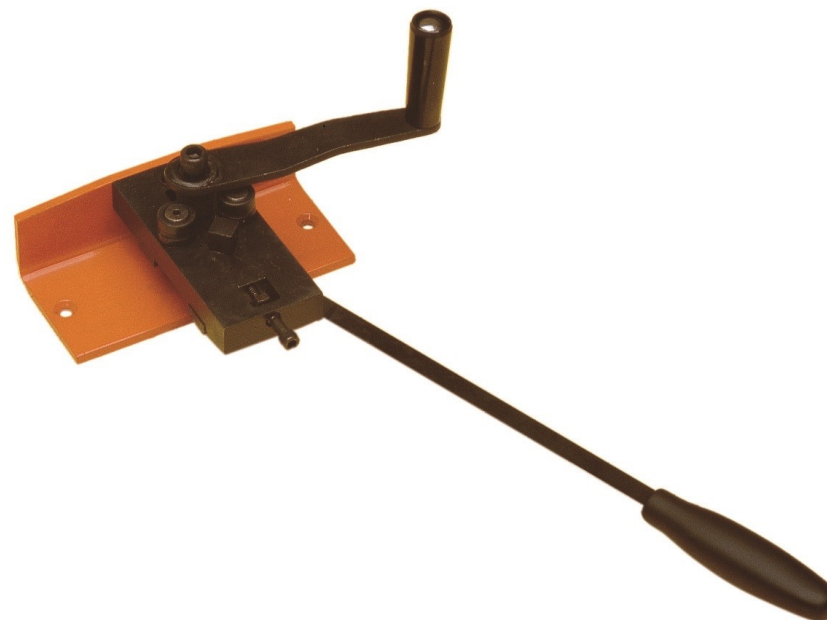
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# OPERATING INSTRUCTIONS



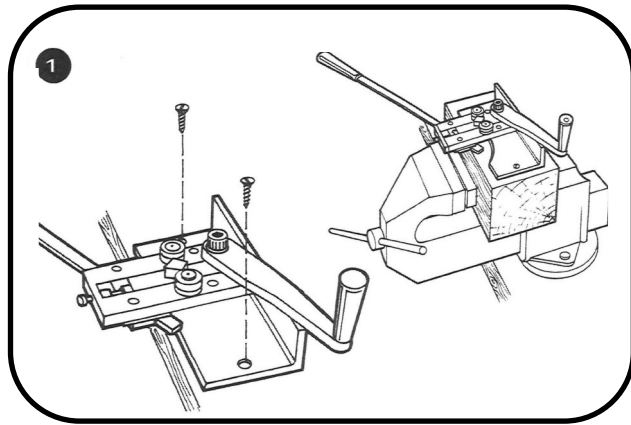
## PRACTICAL-RIVETING/ BENDING/ROLLING TOOL



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# PRACTICAL-RIVETING/BENDING/ROLLING TOOL



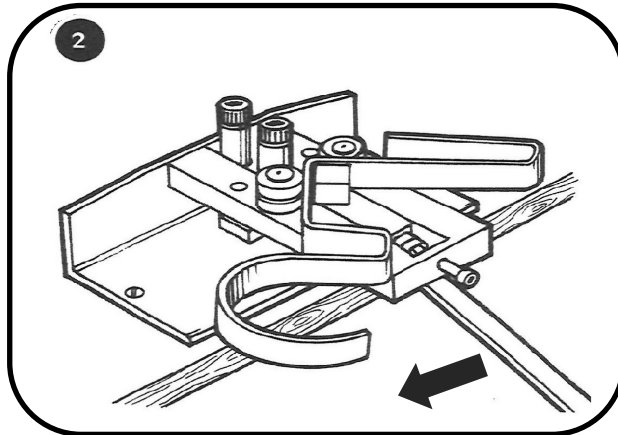
**1** Fix the riveting bending and rolling tool firmly to the work bench with screws .

**Alternatively :** Fix to wood block and hold in a vice for temporary use.

## 2 TO FORM BENDS:

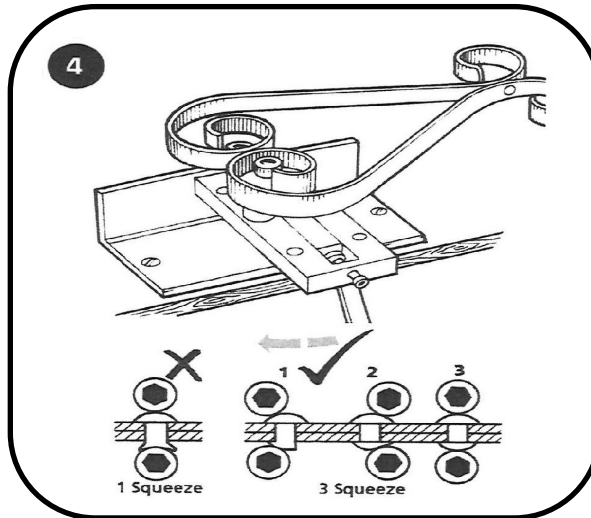
Open the gap between the square former and the side rollers by moving the hand lever (258).

Place the metal bar in this gap and then push the hand lever until the required amount of bend is achieved. Any angle between 90° and 180° can be formed with reproduction of angles set by the end stop screw (1771).



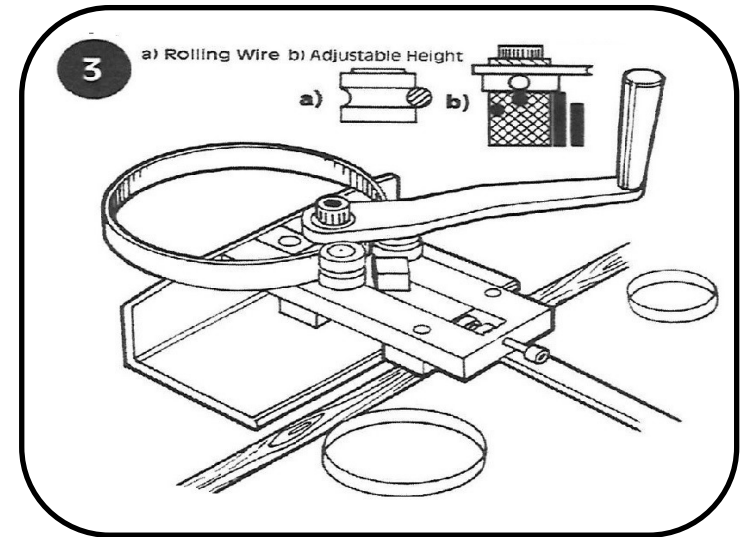
## 4 TO RIVET:

First prepare the machine for riveting by fixing the two riveting posts in place (see illustration). One on the centre slide, the other on the body of the machine (as shown in the illustration). See that they are positioned correctly and well secured with the key provided. Open the aperture between the two posts using the hand lever and place the metal scrolls/bar already punched with a rivet in place between these. Push the lever in a clockwise direction to close the rivet. Only apply sufficient pressure as is necessary to close the rivet firmly. Too much pressure applied on the handle may over-stress the machine and cause damage.



## 3 TO FORM CURVES OR ROLL CIRCLES:

Fix rolling handle to centre slide with allen key provided. Open space between the rollers by means of lever. Place the metal bar between rollers and apply slight pressure with lever. Rotate rolling handle to drive the metal bar through the machine, this will produce a curve. By applying more pressure and rotating the handle in the reverse direction the metal bar will turn back through the rollers and produce more curvature.



The two adjusting nuts (237) are provided to enable repeatable curves and circles to be reproduced. To make a repeatable curve, start by unscrewing the bolt (1771) until only a few threads of the bolt remain in the hole in the end of the centre slide (1196) and secure this by winding the inner nut (237) down the thread of the bolt (1771) until it is in contact with the end of the centre slide (1196). Now form your first curve exactly as described above and on the final pass through the rollers, wind the outer nut (237) towards the head of the bolt (1771) until it touches the inner face of the RBR body (800). This sets the minimum radius of the first curve, so that when you start rolling the next piece of metal bar, it acts as a stop so you create the same radius/curve as the first one.

N.B Due to varying temper (springiness) of steel, curves may vary slightly but these can be put back into the tool and matched with fine adjustment."

### IMPORTANT NOTES:

- 1) These sizes are for hot rolled black mild steel bar and annealed bright mild steel bar.
- 2) Ensure all moving parts are **regularly lubricated** and **all bolts kept tightened**.
- 3) Working beyond the capacities stated above or materials with greater strength or hardness will reduce the operational life of the machine.
- 4) Please keep these instructions in a safe place for any future reference to the parts diagrams.

## SPECIFICATION TABLE

### MAXIMUM SIZE MATERIAL

OPERATION	●	■	▬
RIVET			3mm Rivet- ●
BEND	5mm	4mm	20mm x 3mm
ROLLING	5mm	4mm	20mm x 3mm

Due to a policy of continual development and improvement the company reserve the right to modify Metalcraft tools without prior notification.