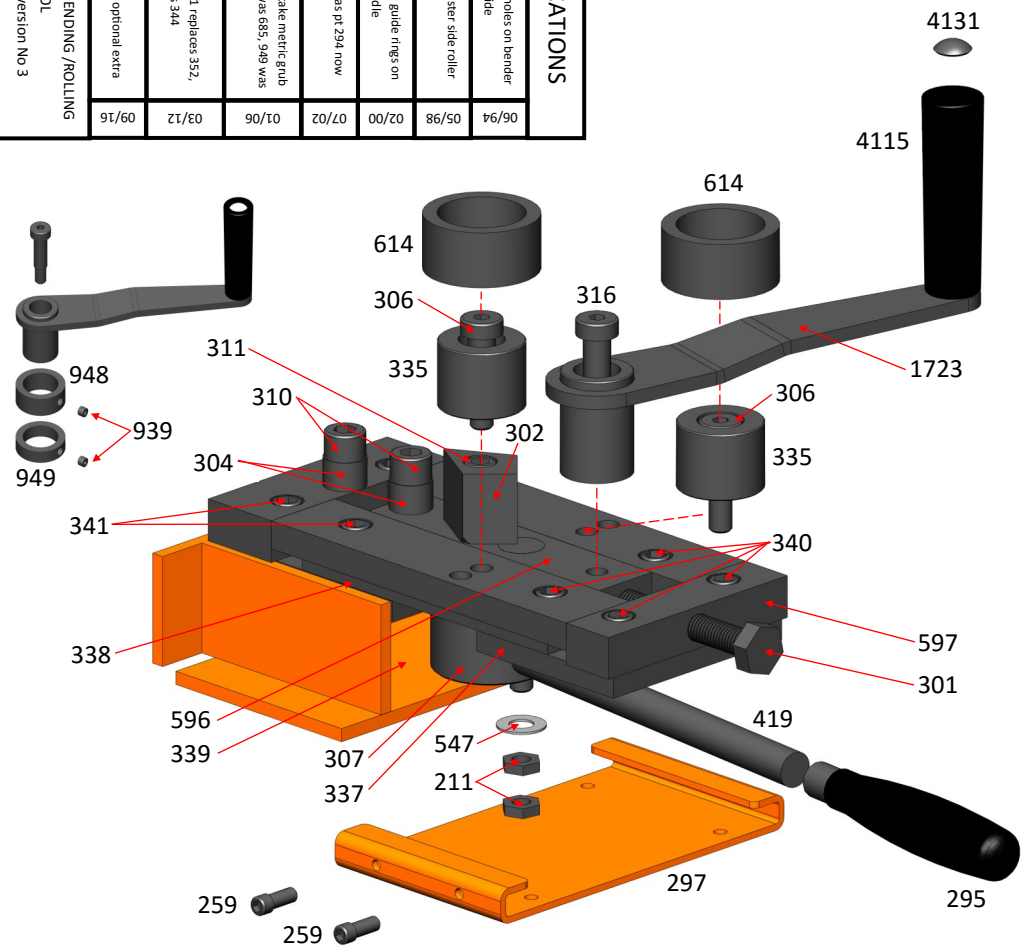


|   |       |  |
|---|-------|--|
| MASTER RIVETING BENDING /ROLLING TOOL<br>Part No: 16 version No 3 | 06/94 | Movement of threaded holes on bender body and slide                                |
|   | 05/98 | Introduction of new master side roller shims                                       |
|   | 02/00 | Introduction of the new guide rings on winding handle                              |
|   | 07/02 | Longer handle fitted was fit 294 now pt.419  |
|   | 01/06 | Guide rings changed to take metric grub screw 939 was 684,948 was 685, 949 was 686 |
|   | 03/12 | 1723 replaces 343, 4131 replaces 352, 4115 replaces 344                            |
|   | 09/16 | Micro Bender added as optional extra   |

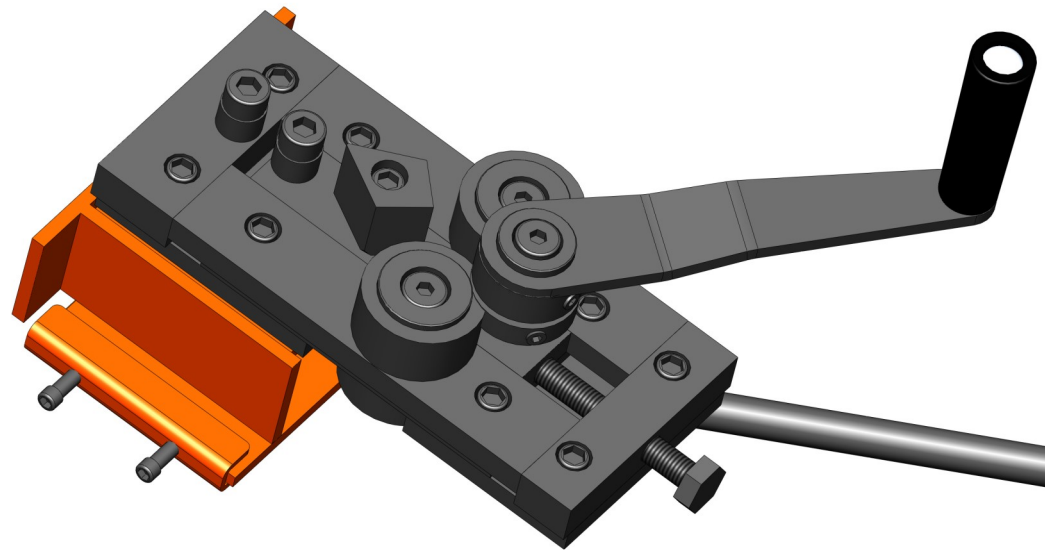
Please keep these instructions in a safe place for future reference to the parts diagrams.  
**IMPORTANT** : Ensure all moving parts are regularly lubricated and all bolts kept tightened.



# OPERATING INSTRUCTIONS



## MASTER RBR



**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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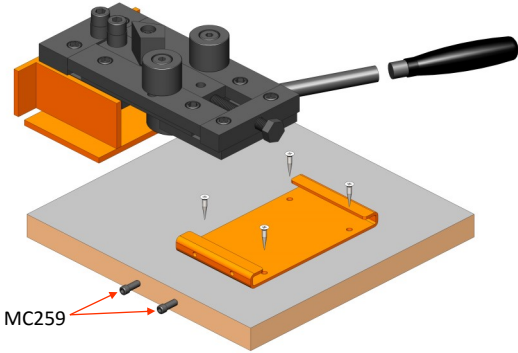
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# MASTER RIVETING/BENDING/ROLLING TOOL

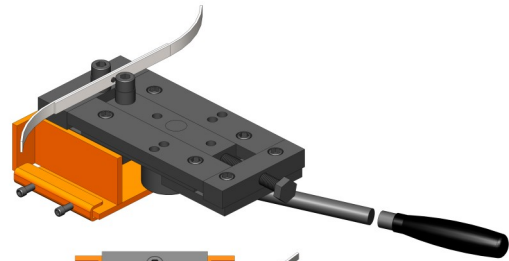
## 1 FIXING MASTER RBR TOOL

Fix base of Master riveting/bending/rolling tool firmly to the work bench with screws (not supplied). Then fit the tool to the base and clamp firmly with securing screws (MC259).

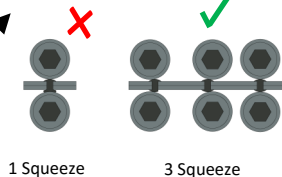


## 2 TO RIVET

All unnecessary components can be removed to give easy access to all parts of a large structure. Place the metal scrolls/bars ready punched with rivet in place between the posts. Push the lever in the direction shown to close the rivet, using the minimum amount of pressure necessary.

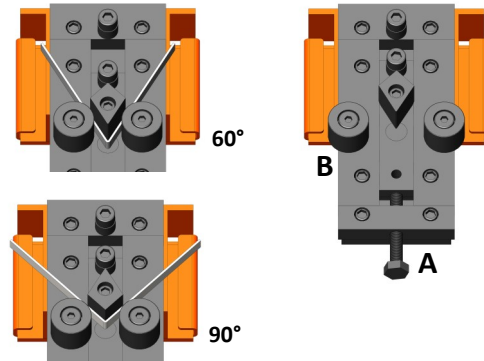


Do not attempt to close the rivet in one go. This can cause damage to the tool. Instead, rivet as shown below.



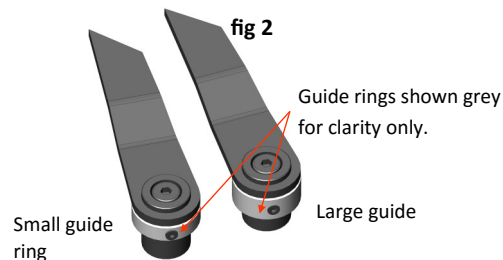
## 3 TO FORM BENDS

The double sided bending former can create an included angle as small as 60°. When bending or rolling thicker section metal strip, the two side rollers should be fitted in their outer location holes to reduce the amount of effort required (position B shown below). Screw stop "A" is adjusted to set and repeat bends and curves.

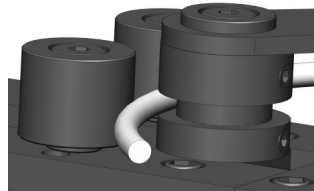


## 4 TO FORM CURVES OR ROLL CIRCLES

**4a** Before fixing the winding handle, choose the appropriate guide ring (small for 16mm—20mm wide flat bar, large for 10mm—16mm wide flat bar, 10mm square/round bar and, no ring required for 20+mm). Then fix winding handle to the centre slide and adjust guide ring height to rest on top of metal bar to be rolled and tighten using the screw provided. See Fig 2.

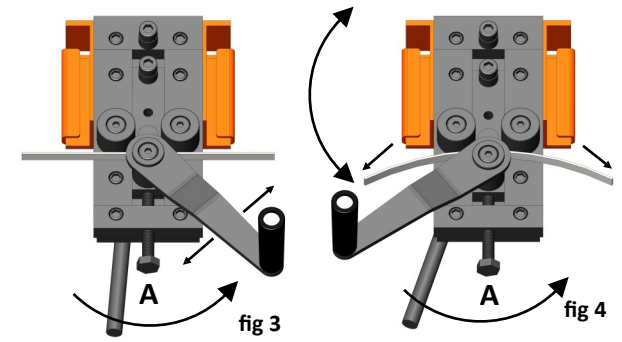


**4b** When rolling round or square bar up to 8mm place the steel between the two guide rings.



**4c** Open the space between the rollers by means of lever. Place metal bar between the 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 return back through the rollers and produce more curvature. See figs 3 and 4.

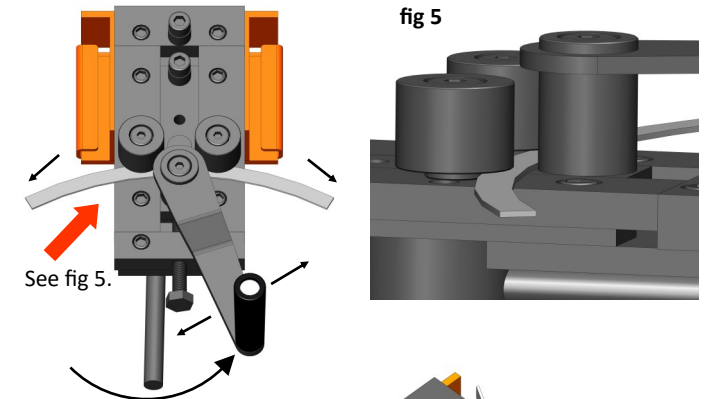
Screw stop "A" can be used to maintain the applied pressure, thereby allowing both hands to be used for operating the winding handle. By repeating this it is possible to produce an infinite variety of curves and circles.



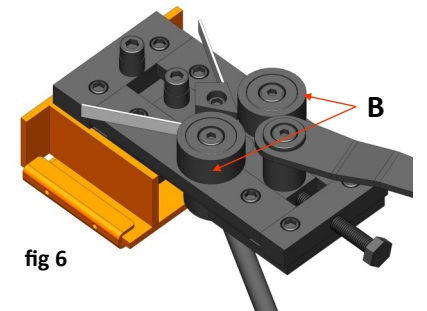
## 5 ROLLING ON EDGE

3mm thick bar can be rolled on edge by passing it through the rollers fixed at centres "B" as shown below, see fig 6.

**Caution:** Rolling on edge can be carried out occasionally on this tool. However, frequent use may overstress the tool.



**6** When rolling or bending materials less than 5mm thickness, it is advisable to use the Side Roller Sleeves "B" provided. This reduces clearance to produce better angle bends and roll smaller radii.



## SPECIFICATION TABLE

MAXIMUM SIZE MATERIAL

| Section / Operation | ●                           | ■    | ▬                     |
|---------------------|-----------------------------|------|-----------------------|
| ROLL                | 10mm                        | 10mm | 25mm x 6mm—30mm x 5mm |
| BEND                | 10mm                        | 10mm | 25mm x 5mm            |
| RIVET               | Maximum size 5mm dia x 30mm |      |                       |

### NOTE:

1) These sizes are for Hot Rolled Black Mild Steel Bar & Annealed Bright Mild Steel Bar.

2) Working beyond the capacities stated above or with materials of greater strength or hardness will

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