ETH STUDENT PROJECT HOUSE

FOLDING MACHINE

FSBM 1020-25 E
Max material width 1000 mm
Max thickness MS 2.5mm (Al 3.0; SS 1.5)
Max bending angle 135°

SAFETY

This is a brief manual. Consider also **manufacturer's manual** and **ask supervisor in case of doubts**.

- **Safety glasses are required**
- **Safety shoes are required**
- **Wear robust clothes**
- **Wear gloves**
- **Keep distance to moving parts**
- **Be careful when operating the foot pedal: Hold the workpiece so it won't drop**
- **Be careful not to release the foot pedal by mistake**

SECURING THE WORKPIECE

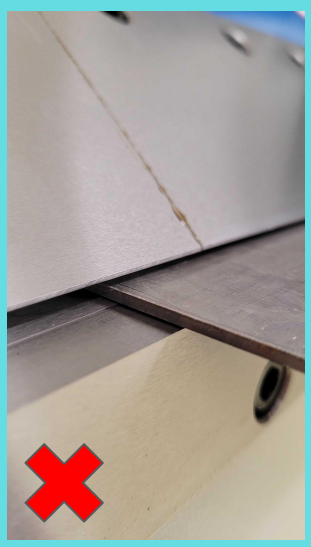
Material

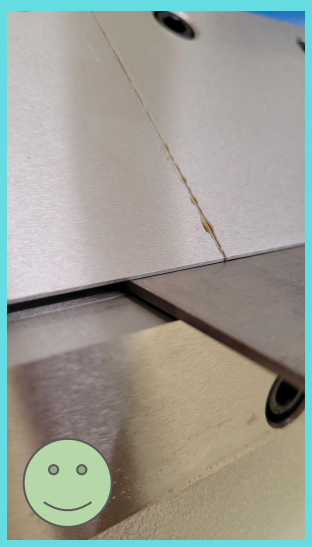
Be sure the material is not thicker than 2.0 mm.
Materials that do not fit the machine or are too thick can't be bended.

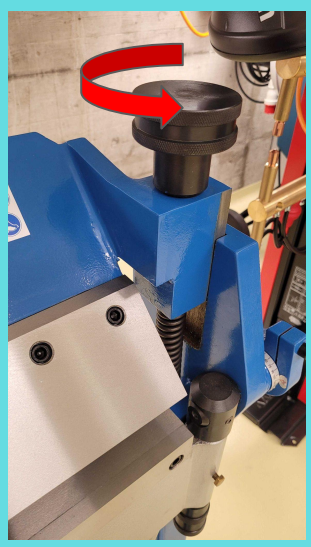
The material needs to be flat and without dents.

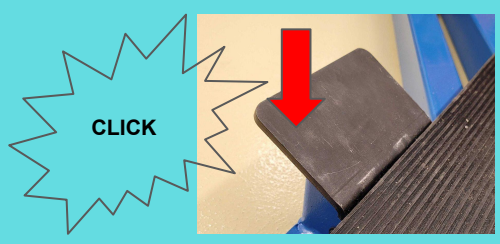
Preparing the machine

To prepare the machine you need to adapt the top screw to fit the material.
A good way of doing it is to screw it in while closed on it then open the bender and screw it a bit tighter.
The pedal should close and the material not move at all.





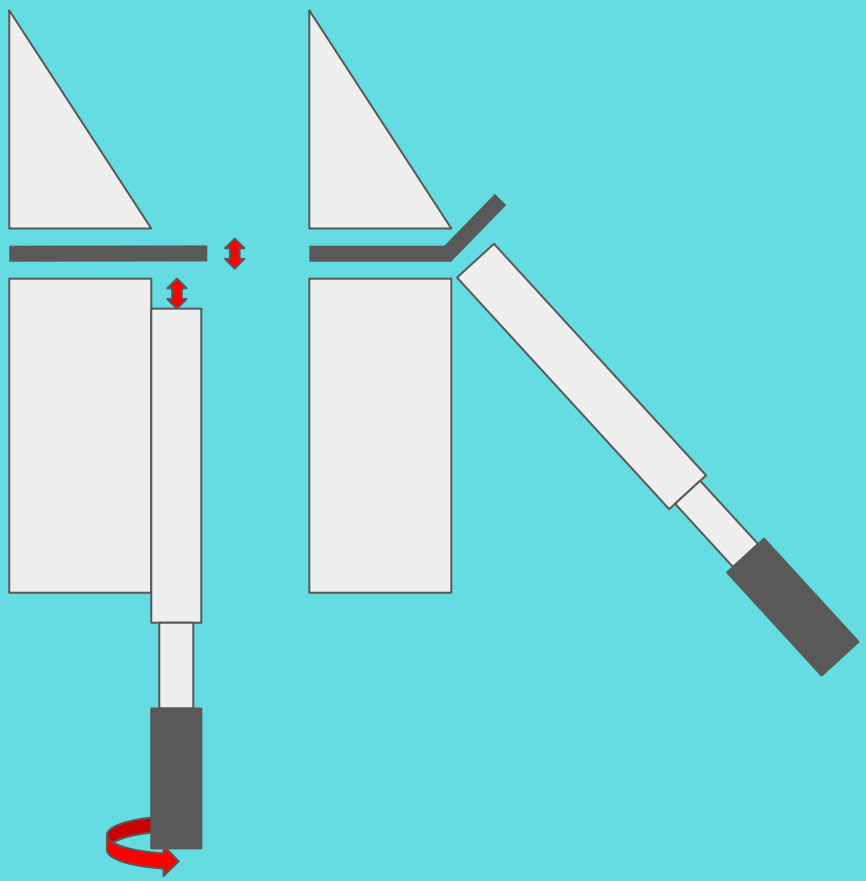




PREPARING TO BEND

It is important now that the small gap on the moving part is around the same size as the material (thickness) so that it will fit while bending.
You can change the gap with the bottom screws.

Try to keep the opposite screws as similar as possible on both sides.



USAGE

Pedal

Before starting to bend be sure that the pedal is locked well and the material is properly fixed.

Angle

You can see the bending angle on the right of the machine, due to how the machine is built you will have to calculate the actual angle you are bending with.

If you start with a flat metal piece once you arrive at 30° you will have a 90° angle on your metal.

If you need more accuracy:
It's recommended to bend iteratively, using an Angle protractor for checking the angle.