



How to use a GF25 CNC rebar stirrups bender (manual of GF25 CNC rebar stirrups bender)

- Before using the rebar stirrups bender, please read this operating manual carefully



- Tech details specification of the rebar stirrups bender

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Machine Model	GF25
Bending Capacity	Ø4mm-Ø25mm
Bending Frequency	25-30 times per minute
Motor Power	3Kw
Motor Speed	1450RPM
GW/NW	180Kg/150Kg
Package Dimension	820*650*820mm



How to change angle degree setting

- Default angle degree is 90 and 135, set the degree as you need by “+” or “-“, angle degree will display on screen,
- “Forward”, this button used for rolling work bench forward
- “Retreat”, this button used for rolling work bench back



Ruler gauge

- It's a simple ruler to help you bending different length stirrups





Commissioning

- Connect power line to power source(380V,three phase), if the machine is customized with other voltages, go with the customized electricity
- It's better to use a Reverse Switch, because it can change phase by the switch easily,
- Turn on power switch and push any one footswitch, to see if work bench rolling in right direction as arrow indicates, if not right direction, change the Revers Switch to other sider, it will be OK. DO THIS TEST WITHOUT LOAD
- Lay a rebar on working bench, and adjust clamp plates tough rebar as near as possible, then push the footswitch, anyone (90 degree and 135 degree) is OK.
- If it works no problem, then you can go ahead with heavy duty work



Fault handling (Machine can't bend)

- Please check if the rebar size is over load, GF25 CNC (round bar $\varnothing 25\text{mm}$, rebar bar $\varnothing 20\text{mm}$)
- Check if the electricity is ok, GF25 CNC require 3Kw electricity at least, and please check
- Please check if the v belt is tight, v belt should be tightly much
- Check if the machine Power Switch is on the right side



Fault handling (Machine bend error angle)

- Please make sure the “green” guide rod is straight and vertical,
- Please make sure work bench is in situ after bending each time

