



How to use an automatic CNC steel bar bending machine GW40C and GW50C (manuals of GW40C and GW50C steel bar bending machine)

- Before using the automatic CNC steel bar bending machine, please read this operating manual carefully



Automatic CNC steel bar bending machine



| Machine Model | GW40C | GW50C |
|-------------------|---------------|---------------|
| Round bar | Ø4mm-Ø40mm | Ø4mm-Ø50mm |
| Rebar | Ø4mm-Ø32mm | Ø4mm-Ø40mm |
| Motor Power | 3Kw | 4Kw |
| Motor Speed | 1450RPM | 1450RPM |
| GW/NW | 420Kg/380Kg | 450Kg/420Kg |
| Package Dimension | 850*850*800mm | 950*850*800mm |



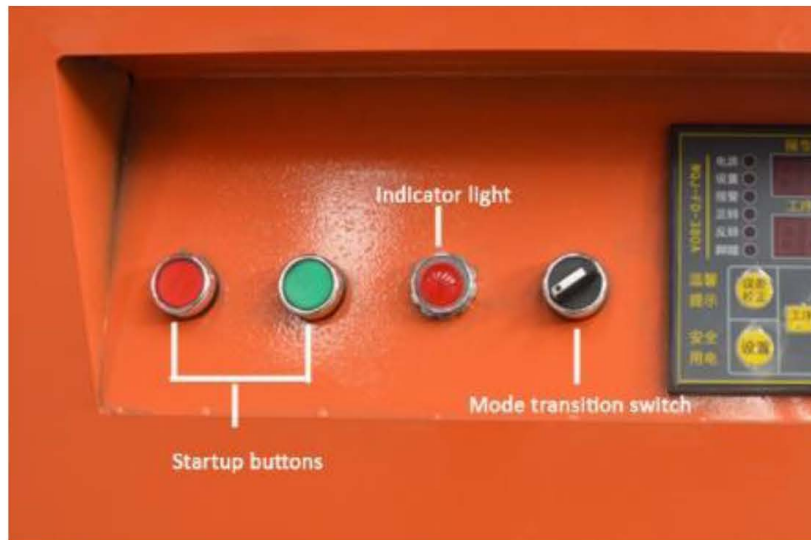
Fill machine oil

- First of all, open oil hole cover, then fill machine oil through oil hole, and inject machine oil per 4 hours working



Control panel introduction

- Red indicator: this is indicator of automatic mode, if the machine is working in automatic mode, the indicator will be light
- Touch startup buttons: the two buttons are startup buttons, they are available when the machine is working in manual mode,
- Mode switch: Automatic or Manual, you can switch it to mode that you need
- Reverse switch: this is power reverse switch
- GW40C and GW50C are multifunctional,
- You can use it as automatic mode, automatic mode is better for angle degree presetting, and it is better for heavy duty repetition rebar bending works
- You can use it as manual mode, manual mode is auxiliary function, it's better for pieces of bending works



Commissioning

- Connect power line 380V three phase,
- If you use Automatic mode, touch footswitch for bending,
- If you use Manual mode, touch startup buttons for bending
- After commissioning, then you can go ahead with heavy duty works





How to set angle degree (in automatic mode and in manual mode)

Automatic working mode: setting the angle degree by CNC controller panel;

- CNC controller panel introduction:
- Error correction: if there's angle bending error, press this button
- Set: it's a startup button for preset process
- Batch -: preset batches decrease
- Batch +: preset batches increase
- Angle degree +: preset angle degree increase
- Angle degree -: preset angle degree decrease
- Enter: after you make the preset done, click Enter button
- Forward: startup button for forward bending
- Retreat: startup button for reverse bending

Manual mode: control angle degree manually by press startup buttons



Matters need attention

- Power source should meet machine power requirement, 380V three phase,
- If the machine power is customized, do it as customized power source
- You have to keep machine oil in proper level
- Operator has to use machine under its load capacity,



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- You have to use machine in safety situation
- If operator is skilled, it will be better