How to use a rebar stirrups bender GF20 and GF25 (manuals of GF20 and GF25 rebar stirrups bender)

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

- Tech details specification of the rebar stirrups bender
-

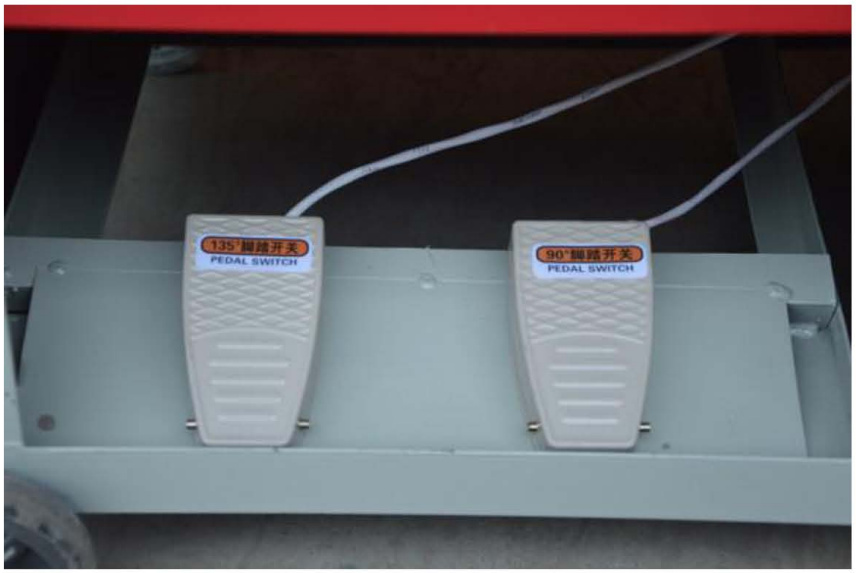
Machine Model	GF20	GF25
Bending Capacity	Ø4mm-Ø20mm	Ø4mm-Ø25mm
Bending Frequency	25-30 times per minute	25-30 times per minute
Motor Power	2.2Kw	3Kw
Motor Speed	1450RPM	1450RPM
GW/NW	140Kg/120Kg	180Kg/150Kg
Package Dimension	820*590*800mm	820*650*820mm

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

Angle degrees changing

- Factory settings: 90 degree and 135 degree in Angle degree integrated control center
- If you want to bend a degree that is below 90, adjust the 90 degree angle degree clamp controller to the point as you required,
- If you want to bend a degree that is above 135, adjust the 135 degree angle degree clamp controller to the point as you required,
- The two footswitch (90 and 135) are matched with the Angle Degree Integrated Control Center



Fault handling (Machine can't bend)

- Please check if the rebar size is over load, GF20 (round bar Ø20mm,rebar bar Ø16mm), GF25(round bar Ø25mm,rebar bar Ø20mm)
- Please check if the electricity is ok, GF20 require 2.5Kw electricity at least, GF25 require 3Kw electricity at least, and please check
- Please check if the v belt is tight, v belt should be tightly much
- Please check if the machine Power Switch is on the right side