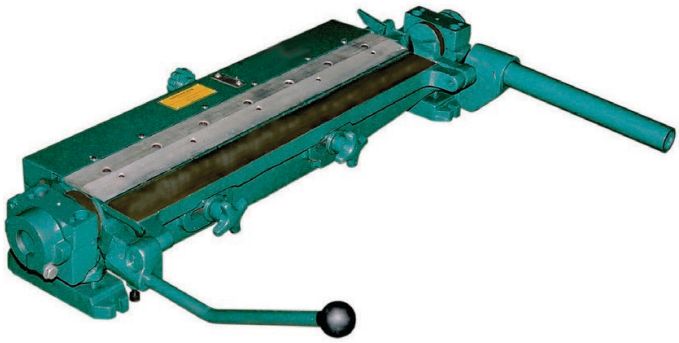
TIN KNOCKER

TK BAR FOLDER

INSTRUCTIONS & PARTS DIAGRAM



TAAG INDUSTRIES CORP.
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TIN KNOCKER
SAFETY RULES
TK BAR FOLDER

1. Never use a machine or tool for anything other than its intended purpose. Use the proper tool and equipment for the task.

2. Do not operate the machine in excess of its rated capacity.

3. Beware of protruding machine elements or assemblies. Avoid any pinch-points created by the movement of the machine's components.

WARRANTY

All new TAAG Machinery Co. machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. TAAG Machinery Co. at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. TAAG Machinery Co. will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to TAAG Machinery Co., at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to TAAG Machinery Co.. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

NOTE: This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Readjustment can easily be done by following the procedures described within. These are procedures with which you, as a user, should be familiar, as you will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you. Call us at: (800) 640-0746

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SPECIFICATIONS:

FOLDING LENGTH……..30 INCHES

CAPACITY, MILD STEEL……..22

GAUGING RANGE….1/8-1 INCHES

ROUND FOLDS FOR WIRE MAX DIA. …….1/4

SHIPPING WEIGHT, BOXED APPROX ……240 LBS

Operating Instructions

For S Clips and Drive Cleats, forming sharp locks on edge of sheet metal for double seam, open locks for wired edges, flanges of various degrees and single or double hems. For radius bends short-run production, quickset gauging. One motion to clamp and fold. Steel stand extra.

CAUTION! Before operating, machine must be bolted to work bench. If pedestal has been provided, machine must be bolted to pedestal with bolts provided. Pedestal must be lagged to floor. Failure to comply will result in machine tipping over, and may cause machine damage or bodily injury.

1. Mount Bar Folder on bench with Counter balance and Handle facing towards rear of Bench.

2. Gauge is adjustable from 1/8" to 1". To adjust Gauge, turn Hand Knob (33). This moves Gauge Indicator to desired depth of lock.

3. Wedge adjustment is necessary for open or round locks. To adjust Wedge: (a) loosen Two knobs (20) on Folding Bar (4) (b) raise Folding Bar (4) to almost a right angle with edge of Folding Blade (17) (c) slide knobs (20) to right to raise Wing (5), or to left to lower Wing (5) to any desired lock within the capacity of the machine. Always allow a minimum clearance of the thickness of the metal being folded between the Wing (5) and the edge of the Blade (17). After the correct adjustment has been made, tighten Wedge Locking Knobs (20) to lock position.

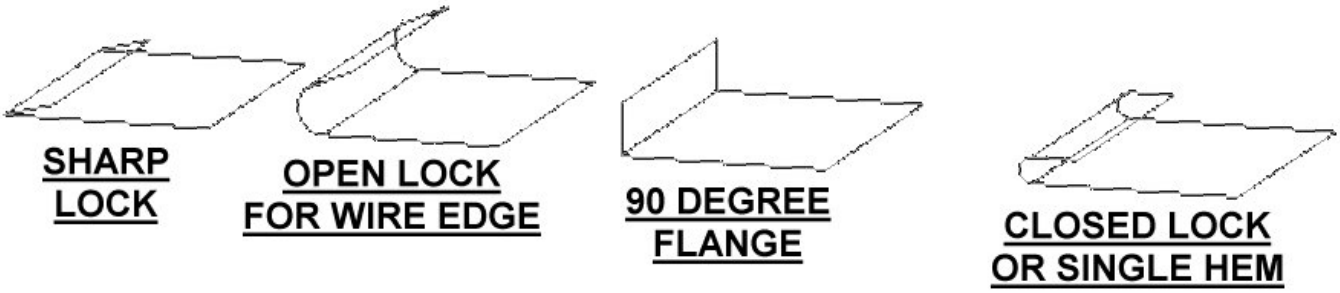
4. For adjustment of clamping action between Blade (17) and Jaw (2). (a) Bring Folding Bar (4) to almost a right angle with edge of Folding Blade (17). (b) Adjust Set Screws (43) in Shoes (22) located at both ends of machine. (d) Lock Set Screws (43) in Shoes (22) in place.

This adjustment is set when machine leaves factory for single lock operation. For double lock operation, more clearance is required between Jaw (2) and Folding Blade (17). To obtain correct clearance follow Instruction 4. After desired clearance is secured adjust Wedges (15) and Wing (5) to suit Jaw (2) and Blade (17).

5. For bending angles of 45° or 90° set Stops (28) provide for respective angles at either End of machine. An adjustable Stop (35) for any angles from 10° to 120° is located at right of operator.

6. Lubricate all Bearings and moving parts with a medium (SAE 30) motor oil.

FORM DIAGRAM

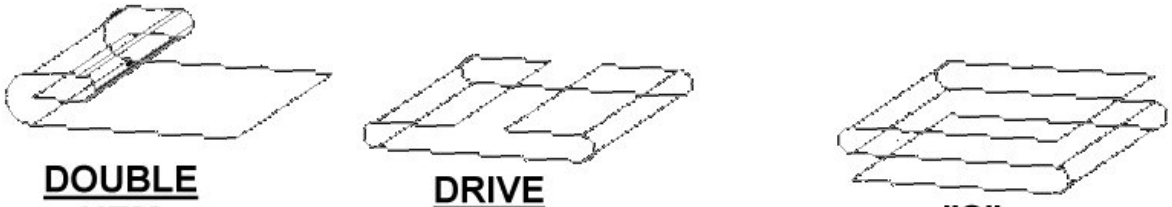


SHARP LOCK

OPEN LOCK FOR WIRE EDGE

90 DEGREE FLANGE

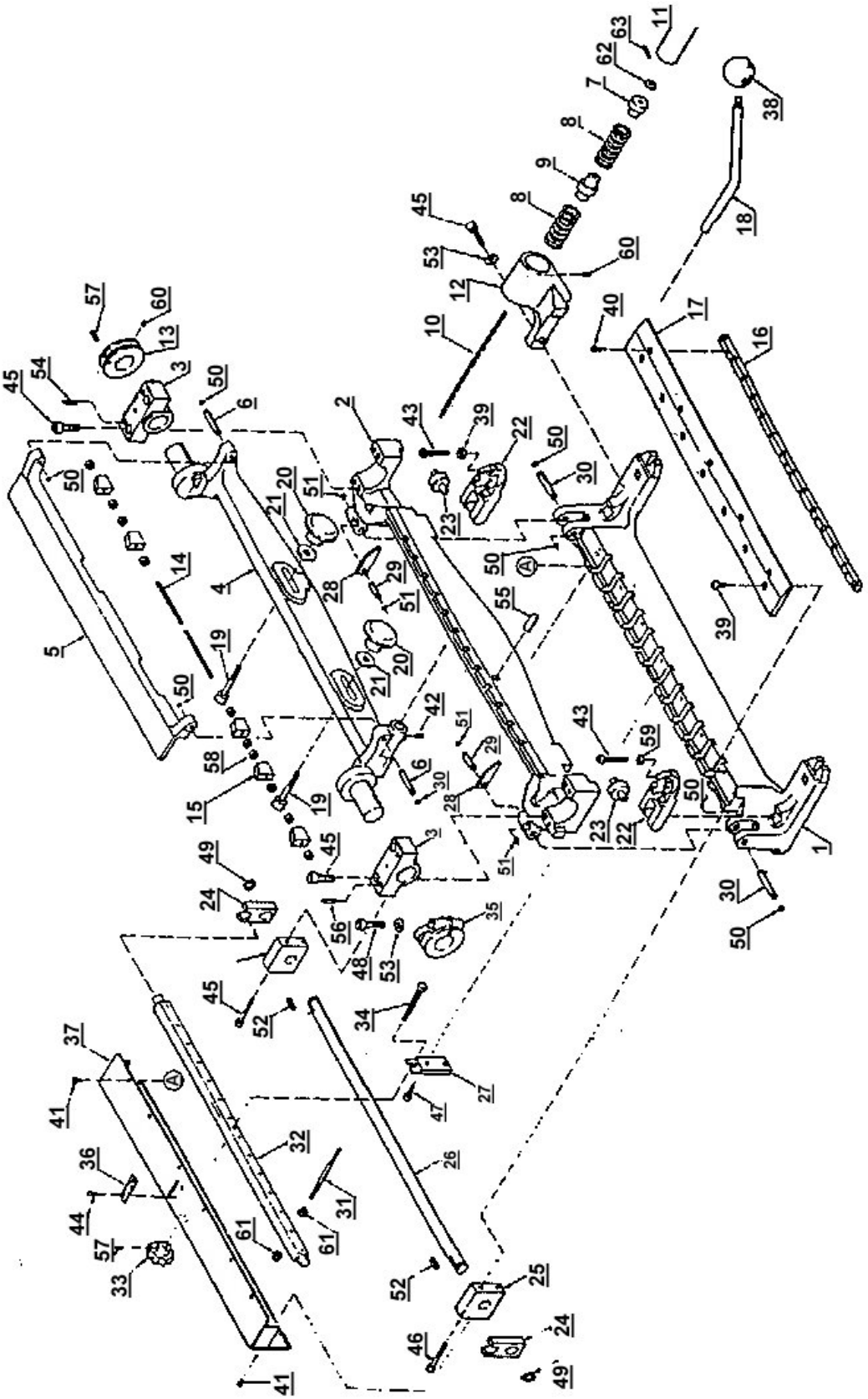
CLOSED LOCK OR SINGLE HEM



DOUBLE HEM

DRIVE CLEAT

"S" CLIP



Parts For Barfolder

Fine No.	Part No.	Description	No. REQ"D.
1	BARFOLD2001	Frame	1
2	BARFOLD2002	Jaw	1
3	BARFOLD2003	Block-Pillow	2
4	BARFOLD2004	Folding Bar	1
5	BARFOLD2005	Wing	1
6	BARFOLD2006	Pin-Pivot, Grooved	2
7	BARFOLD2007	Bushing	1
8	BARFOLD2008	Spring-Compression	2
9	BARFOLD2009	Bushing	1
10	BARFOLD2010	50 Plain Finish Chain –Sash	1
11	BARFOLD2011	Container – Spring	1
12	BARFOLD2012	Bracket – Counterbalance	1
13	BARFOLD2013	Roll- Counterbalance	1
14	BARFOLD2014	Screw – Wedge	1
15	BARFOLD2015	Wedge	5
16	BARFOLD2016	Guide- Gauge	1
17	BARFOLD2017	Blade- Top	1
18	BARFOLD2018	Handle	1
19	BARFOLD2019	Clamp- Wedge	2
20	BARFOLD2020	Knob	2
21	BARFOLD2021	Spacer	2
22	BARFOLD2022	Shoe- Adjustable	2
23	BARFOLD2023	Roll-Lifting	2
24	BARFOLD2024	Lever	2
25	BARFOLD2025	Block-Mounting	2
26	BARFOLD2026	Bar-Equalizer	1
27	BARFOLD2027	Plate	1
28	BARFOLD2028	Stop-Angle	2
29	BARFOLD2029	Pin- Pivot Grooved	2
30	BARFOLD2030	Pin Pivot Grooved	2
31	BARFOLD2031	Gauge	12
32	BARFOLD2032	Bar-Gauge	1
33	BARFOLD2033	Knob	1
34	BARFOLD2034	Screw- Adjusting	1
35	BARFOLD2035	Collar- Stop	1
36	BARFOLD2036	Scale	1
37	BARFOLD2037	Cover	1
38	BARFOLD2038	Ball Handle	1
39	BARFOLD2039	Screw – Soc. But. Hd. Cap	7
40	BARFOLD2040	Screw- Soc. But. Hd. Cap	5
41	BARFOLD2041	Screw-Soc. But. Hd. Cap	8
42	BARFOLD2042	Screw Soc.Set	1

43	BARFOLD2043	Screw – Sq. Hd. Set	2
44	BARFOLD2044	Screw – Rd. Hd.	2
45	BARFOLD2045	Screw-Sq. Hd. Cap	6
46	BARFOLD2046	Screw- Soc. Hd. Cap	4
47	BARFOLD2047	Screw- Soc. Hd. Cap	2
48	BARFOLD2048	Screw-Hex Hd. Cap	1
49	BARFOLD2049	Ring-Retaining	2
50	BARFOLD2050	Ring-Retaining	8
51	BARFOLD2051	Ring-Retaining	4
52	BARFOLD2052	Key	2
53	BARFOLD2053	Plain Washer- Sld. SAE “N”	3
54	BARFOLD2054	Pin-Dowel	1
55	BARFOLD2055	Dowel	4
56	BARFOLD2056	Roll Pin	1
57	BARFOLD2057	Pin – Roll	1
58	BARFOLD2058	Nut – Hex Lock	12
59	BARFOLD2059	Nut – Hex Jam	2
60	BARFOLD2060	Screw – Soc. Set Cup Point	2
61	BARFOLD2061	Nut – Hex Jam	22
62	BARFOLD2062	Washer	1
63	BARFOLD2063	Pin - Cotter	1