

# USERS GUIDE

## BPSE-100S



### ATTENTION!

### READ CAREFULLY BEFORE FIRST USE!

The machines are delivered adjusted after a bending test. Do not unscrew the screws of the machine, do not disassemble it! All adjustment options are available for bending metal sheets, detailed below.

### PURPOSE AND FIELD OF APPLICATION:

This machine is primarily designed for on-site work. Compared to the machine's dimensions and precision edge bending capabilities, it has an extremely light weight, so even one person can move it relatively easily. It is easy to transport and load, it can be put to work on a stable workbench or any stable flat surface on a construction site, without a require for special fixing, it's standalone. If there's a need, you can fix at the oval cut-out on the legs or at the profiles which are connecting to the legs. Do not use it to bend thicker material than specified in the specification!

Do not bend other materials (nails, screws, flat steel, round steel, square sections, etc.) apart from sheet-metal industry!

### REMOVING AND INSTALLING THE CRANK ARM (OPTIONAL):



If necessary, the crank arm can be removed and installed (1-4). Due to the precise fit, it is **IMPORTANT** that the crank arm is parallel to approx. It must be moved **within a 5-5mm** difference when connecting and disconnecting! If you are not sure that you can perform the operation alone, ask a colleague for help! The right and left sides should be sliding with light hits (with the palm of your hand or a hammer with a plastic head) to the bottom line (4), then when it is horizontal, you can start driving in the adjusting screw (7). The adjusting screw (7) must be driven in very gently and with feeling due to the threads with different pitches. **DO NOT FORCE!**

If necessary, move it within 1-2 mm **between the two marks**, until the screw gently engages the thread. Compared to the horizontal marking of the crank,

the left and right sides should be parallel (so that the screws are not strained during the thread), so wind them to the desired height!

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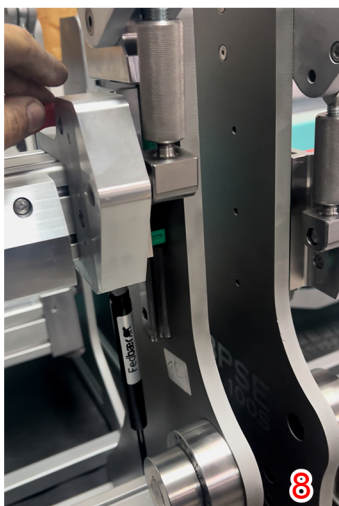


The bending arm can be fixed with the hook (6) on the left side of the machine.

### MOVEMENT OF THE SPREADING ARM:

The staged movement of the upper beam is natural: To avoid collision, the safety stroke deceleration of the gas spring takes effect at about 80%. In addition, gently move it to the end position, where the upper beam reaches the full opening height (~73mm). Optionally, you can fix the upper arm in two positions permanently, down to closed or fully opened. These attachment points can be important especially during transport.

### ADJUSTMENT OPTIONS:



There are two options for adjusting the plate thickness: One on the edges of the upper beam (8), and one on the bottom of the bending arm on both the left and right sides (7). There are two marks on the bending arm's height adjustment rod (5): the upper mark is the maximum of the adjustment (regarding to plate thickness), the lower mark is the approximate insertion point of the screw used for installation, be careful when approaching this line when adjusting, because as the adjustment screw close to be released, the arm can fall (~3mm from the top line)!



There's a stretching option on the bending arm and the lower, rear profile: adjust these carefully according to the needs of the plate bending.

### MAINTENANCE:

Periodically grease the guide rail by hand (11) or with a greasing tool (10). Be careful, when deattaching the tool. **KEEP** the lower and upper horizontal segment receiving rails **CLEAN**, dirt and burr must not get inside! Occasionally wipe the groove on the inside of the segment receivers with an oily or service spray (e.g. WD-40) cloth so that the ball in the segments would run freely in the groove. If dirt gets inside, blow it out with compressed air and clean it.



Spray the frame and moving, rotating parts (12-13) of the machine with service spray, wipe it with a cloth, so you can increase its aesthetic and mechanical life!



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### OTHER:

In addition, the condition of the screws must be checked periodically, if they come loose, fasten them in place! The storage box, which is filled a unique cut foam is designed for the segment jaws. In the box, the components and the walls of the sponge fits tightly together, so they can be stored without collision or damage!

Periodically check the condition of the connecting surfaces! Also treat the spring studs with a service spray. If the segment jaws or the ball bushing installed in them are damaged, do not insert the beads into the rail! In this case, the bushing can be easily replaced, contact the manufacturer or distributor!

### WARRANTY:

Machines are assembled, set up and distributed by Biró Profil Kft. are guaranteed for 24 months from the date of purchase (verified by an invoice). Unique made parts made in Hunary. If there's a complaint, the manufacturer or distributor **must be** notified without disassembling or disassembling the machine! The warranty does not exceeds to malfunctions attributable to natural wear and tear, overloading, or any kind of unprofessional handling. Other large-scale impacts and unjustified external influences may hinder the machine's professional operation, all of which may result in exclusion from the warranty!

### TECHNICAL DATA:

Bendable plate thickness: 0.6mm (steel) 0.8mm (copper, zinc), 0.8mm (aluminum), 0.5mm (stainless)

Useful working length: 1000mm

Upper segment beads angle: 150°

Upper segment beads height: 73mm

Lower segment beads height: 60mm

Opening height (max): 73mm

Size (length, width, height): 1165x500x685mm

Weight (without segments): ~44kg

Weight of segments (without box): ~11kg

Dimensions of segments (Bottom, top, back): 1x30mm 1x40mm 2x50mm 1x60mm 1x70mm 5x100mm 1xL100mm 1xR100mm

### STRUCTURAL CONSTRUCTION, COMMISSIONING:

Materials used: Structural aluminum alloy (EN AW7075, EN AW6060, EN AW6082), Stainless-steel (KO-36S, KO-33, screws: A2, A4), galvanized steel (screws), bronze bushing, hardened steel nail, 8.8 steel screw. The machine is made of qualified materials and parts! Segment beads are hard-anodized.

Year of manufacture:

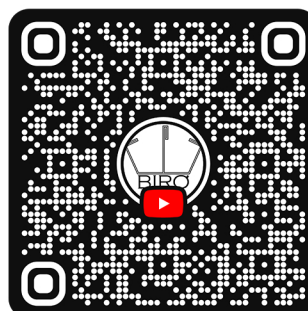
Serial number:

#### Contact:

[biroprofil@gmail.com](mailto:biroprofil@gmail.com)

[www.biroprofil.com](http://www.biroprofil.com)

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MADE IN HUNGARY

Daniel Biro  
BIRÓ PROFIL KFT.