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DBD-32X Rebar Bender Roller Selection Chart

TABLE A Roller Selection Chart for DBD-32X Only
 Combination of Center Roller and Moving Roller according to
 the bar size:

Bar Diameter Size Grade 60	Center Roller	Moving Roller	No. of bars that can be bent at one time
1-1/8" (29mm) #9	No. 5	No. 2	1 Piece
1" (25mm) #8	No. 5	No. 3	1 Piece
7/8" (22mm) #7	No. 5	No. 3	1 Piece
3/4" (19mm) #6	No. 4	No. 3**	2 Pieces
5/8" (16mm) #5	No. 3	No. 5	2 Pieces
1/2" (13mm) #4	No. 2	No. 6	3 Pieces
3/8" (10mm) #3	No. 1	No. 7	4 Pieces

TABLE B Roller Sizes

Part Number -Roller #	Outside Diameter
#1BR7090 - No. 1	1.95" (50mm)
#1BR7091 - No. 2	2.73" (70mm)
#1BR70931 - No. 3	3.50" (89mm)
#1BR70941 - No. 4	4.31" (110mm)
#1BR70951 - No. 5	5.06" (129mm)
#1BR70961 - No. 6	6.13" (156mm)
#1BR7097 - No. 7	7.44" (189mm)

** Use a second No 4 Roller on moving roller to produce 180° Bends

ATTACHING OR REMOVING ROLLERS OR ACCESSORIES.

WARNING: ALWAYS UNPLUG TOOL BEFORE CHANGING ROLLERS

1. Select and set the correct rollers for the bars to be bent. See the table on page 3-4.
2. Plug the electrical power cord into an appropriate outlet.
3. Lay the bar on the machine surface between the center roller and bending roller. Adjust the stopper so that the bar is parallel to the front edge of the machine.
4. Turn the main switch on and check that the pilot lamp has lit up.
5. Set the angle and make a test bend. If the bent angle is not exact, adjust the angle setter slightly to the right or left. Lock in the angle stoppers to duplicate the same angle each time.
6. Push the operation button or foot switch. The moving bending roller will automatically return to the start position once the bend has been completed.
7. If it is necessary to stop the machine in an emergency, push the emergency stop
8. button or release your foot from the foot operated switch. The bending roller will return to the start position automatically.