



**BN Products - USA, LLC.**

A Division of Benner-Nawman, Inc. - Wickenburg, AZ

# PRODUCT: JMB-25H REBAR BENDER OPERATIONS MANUAL



REV | 0522023

JMB-25H 2023 HALF LETTER Operations Manual.i.indd

3450 Sabin Brown Road • Wickenburg, AZ 85390  
(800) 992-3833 • mail@bnproducts.com

Thank you

Thank you for choosing our JMB-25H Rebar Bender

This manual covers the proper operation and maintenance.

Before operating, please read this manual carefully for important procedures and safety.

All technical data and drawings in this manual are consistent with the information on this product. As a result of revisions and other on going updates, the contents of this manual may be slightly different from the actual product. BN Products reserves the right to make changes at any time, without notice and without incurring any obligation, please understand.

The copyright of this instruction manual belongs to us. No reproduction is allowed without the written consent from BN Products-USA. All rights are reserved.

This manual is a permanent part of this rebar bender and should accompany the rebar bender if it is resold.



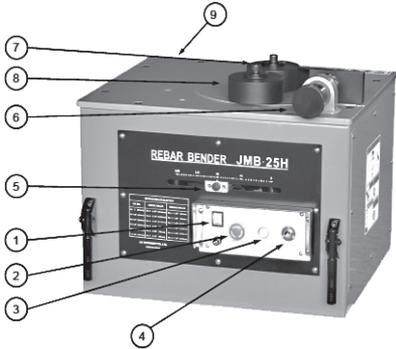
Please read this manual carefully to ensure the safe use of this bender. Failure to comply with the instructions in this manual may lead to accidents and injuries. Therefore, make sure to operate the machine in compliance with these instructions. We are not liable for any damage caused to the machine or injury to the operator resulting from unauthorized modification of the device or the use of parts that are not genuine.

## Basic Specifications and Performance Specifications

Classification	JMB-25H
Power Supply	Single Phase 115V / 60HZ
Current	12 Amp
Motor	2.2 kW
Bending Capacity	25mm ( #8)
Bending Angle	1~180
Bending Time	180 / 7sec.
Weight	132kg

## Feature Identification

1. Power Switch
2. Emergency Switch
3. Operation Switch
4. Footing Switch
5. Angle Adjustment Handle
6. Bar Adjustment Stopper
7. Center Roller
8. Moving Roller
9. Spring Tension Bolt



## Simultaneous Bending Capacity and Number of Bars (refer to the front panel of the machine)

Rebar No.	No. 3	No. 4	No. 5	No. 6	No. 7	No. 8
JMB-22	4	3	2	2	1	1

# Installation and Work Preparation

## Installation

- Install the machine on a level, even surface.
- If the ground is not level, use an auxiliary base capable of supporting the bender rigidly.

## Power Connection

- Power cable conductor must be at least 5.5mm<sup>2</sup>.
- Power cable length must not exceed 50m.  
(If it exceeds 50m, use a cable of 8mm<sup>2</sup> minimum.)

## Work Preparation

- Turn on the power switch. Set the Angle Adjustment at about 135, and let the machine run idly for at least 3 minutes.
- (Warming up should be at least 5 minutes in winter.)
- Once warmed up, set the desired angle for bending.
- Select the roller according to the thickness of the steel bar.

Bar Diameter	Center Roller	Moving Roller
#8 1" (25mm)	No. 7 - 5.97" (153mm)	No. 1 - 2.54" (65mm)
#7 7/8" (22mm)	No. 6 - 5.15" (132mm)	No. 3 - 3.63" (93mm)
#6 3/4" (19mm)	No. 4 - 4.45" (114mm)	No. 5 - 4.45" (114mm)
#5 5/8" (16mm)	No. 3 - 3.63" (93mm)	No. 6 - 5.15" (132mm)
#4 1/2" (13mm)	No. 2 - 3.09" (79mm)	No. 8 - 6.48" (166mm)
#3 3/8" (10mm)	No. 1 - 2.54" (65mm)	No. 9 - 7.14" (183mm)

# Periodic Check and Maintenance

Trouble	Inspection and Maintenance
Excessive noise	Check the precision of the reducing gear.
	Check for wear or damage of the gears in the gearbox.
Bar angle cannot be adjusted	Remove foreign matter from the Angle Adjustment Slide. Check switch for ease of operation. Repair or replace as appropriate.

Trouble	Inspection and Maintenance
Does not rotate	Check Foot Switch connection.
	Check if Emergency Switch is pressed.
	Check gear connection. Take measures as necessary.
	If motor output power is reduced, replace carbon brush of motor.
Electric devices and wiring connection	Check connections from time to time. Fix wiring when necessary.
	Check switch operation. Remove foreign matter if necessary.
	Check wiring connections. Correct broken or damaged lines.
Clean-up	Clean the machine of dust and bar chips with a brush (do not use compressed air).
	Check for cracks or damage in mechanical parts. Replace or request after-service as necessary
	After the rainy season or after rain, pull off cover and dry machine completely.
	When soaked in water or exposed to rain, there is a danger of electric shock. Do not try to use the machine. Call for service.

## Precautions

- Do not exceed the machine's capacity for simultaneous bending. If exceeded, machine failure may result.
- When bending rebars while holding them, watch out for your fingers and prevent accidents.
- Depending on the rebar material, it may fracture during bending, resulting in an accident. Therefore, keep your attention fully focused on the bending work.
- Ensure that no persons or objects are within the radius of the bending rebar.
- Since this machine uses electric power, rain or water may cause an electricity leak. Keep in a dry place or cover with a waterproof film.
- When moving the machine, check that the transportation handle is firmly fixed.

## Repairs and Security

- Replacing the carbon brush - Be sure to isolate the power plug from the power source. Check the carbon brush for wear when the machine is not in operation. If the carbon brush in the motor, which is subject to wear and tear, is worn, the motor will lose power or even stop until the power is next turned on. In such cases, the carbon brush(es) must be replaced.
- On the motor inside the machine, unscrew the brush cap with a straight tip screwdriver, and remove the brush together with the spring (replace both of the brushes.)
- When replacing the rotating roller or fixed roller, clean up with a brush.
- Inspection and Security. Check that bolts and nuts are fully tightened from time to time.
- Dry the machine sufficiently after the rainy season or rainfall before operation
- If the rotating roller jolts when returning to its original position, adjust it by unscrewing the spring tension adjustment bolt. If it returns too slowly, tighten the adjustment bolt.
- The machine is ready for operation when the power indicator lamp lights up after power input and power switch. If the lamp is not lit, check the power cable connection.
- If the machine does not start up when the power lamp is lit, check the fuse or check the carbon brush in the motor for wear.
- In the event of other troubles, please call (800) 992-3833

