



BN Products-USA™

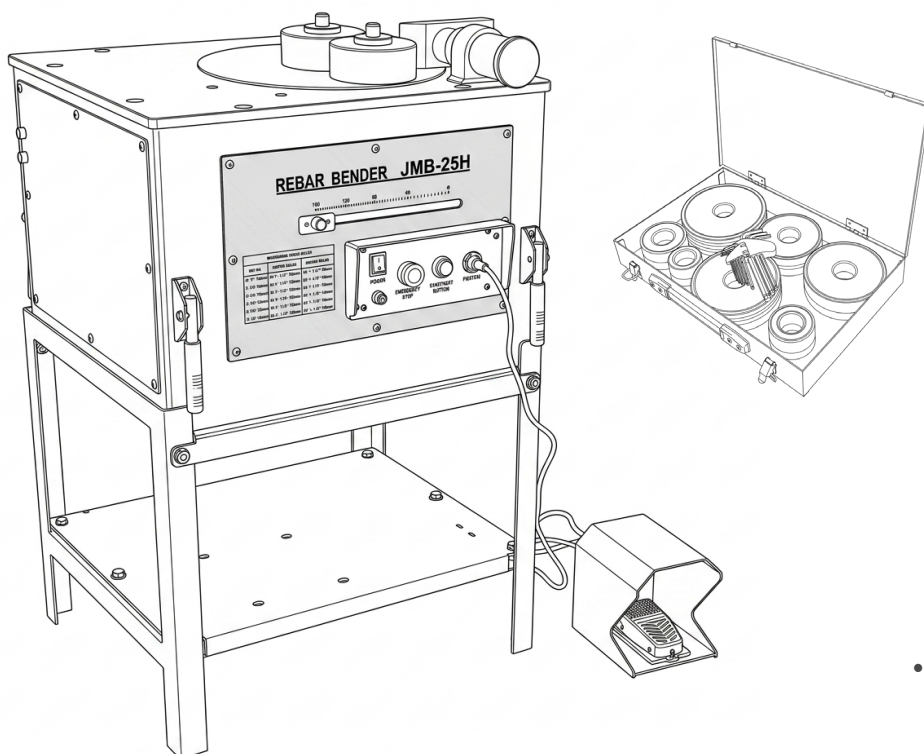
A DIVISION OF BENNER-NAWMAN, INC.

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ELECTRIC REBAR BENDER

JMB-25H

OPERATOR MANUAL



JMB-25H Electric Rebar Bender

Designed For

- Construction site or Shop
 - Grade 60 Rebar
- Rebar Diameter up to 1" (25 mm)
- 0 - 180° Bending applications
 - Pre-set angle lock

JMB-25H REBAR BENDER | SERIAL NUMBER

S/N #

The JMB-25H Rebar Bender is a heavy-duty table top rebar bending tool that is a great addition to the extensive line of BN Products USA™ rebar tools. This bending machine includes heavy-duty stand for the machine, a set of nine (9) bending rollers with steel carrying case, tool kit for the bender, foot pedal control system, and a one-year warranty.

BN Products-USA™

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(800) 992-3833

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THE MOST TRUSTED NAME IN REBAR TOOLS

Thank You for choosing the JMB-25H Rebar Bender

This manual covers the proper operation and maintenance of the JMB-25H Rebar Bender.

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.

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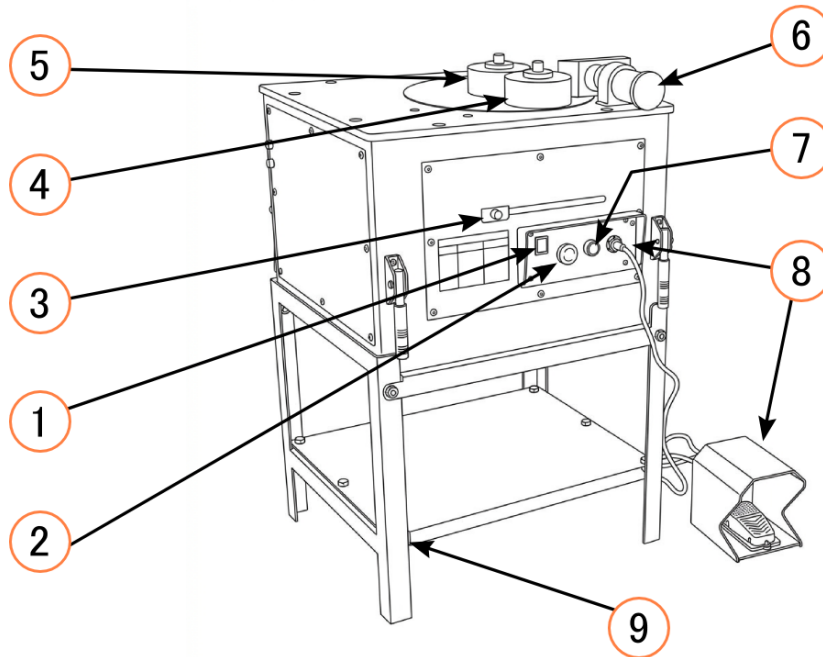
This manual is a permanent part of this rebar bender and should accompany the rebar bender if it is resold.

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.

BN Products-USA™, nor its parent company, Benner-Nawman, Inc., 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 aftermarket parts, that are not genuine, OEM parts for this product.

General Specifications

Maximum rebar diameter:	#8 (1") (25mm) Grade 60
Bending Angle:	0 – 180 degrees
Bending Speed:	9 Seconds for 180 degree bend
Power Supply:	115V 50/60Hz -15 amps
Weight (kg):	210 lbs. (95 kg)
Dimensions (mm):	21" (540) L x 22.6" (580) W x 17.2" (440) H



1 - Power Switch

2 - Emergency Stop Switch

3 - Angle Adjustment Control

4 - Moving Roller

5 - Center Roller

6 - Bar Adjustment Stop

7 - Operation Control Switch

8 - Foot Pedal Control and Interface Port

9 - JMB-25H Bender Stand

Bending Capacity

Number of Bars/Simultaneous Bends

The JMB-25H Rebar Bender will effectively bend, in a single operation of the machine:

[4 bars] #3 rebar

[2 bars] #5 or #6 rebar

[3 bars] #4 rebar

[1 bar] #7 rebar or #8 rebar

Important: Do not attempt to bend more than the capacity stated in this Guide at one time, as serious damage to the machine or personal injury may occur.

Rebar Diameter:	# 3	#4	#5	#6	#7	#8
Maximum Bars to Bend (single operation)	4	3	2	2	1	1

Safely Using the JMB-25H Rebar Bender



General Safety Precautions

- Read this Manual thoroughly before use; seek professional training if you are inexperienced in using a professional rebar bending machine
- Personal Protective Equipment is the first line of defence against potential hazards. Workers operating bar bending machines should wear the appropriate PPE, including:
 - Safety goggles and face shields to protect the eyes from flying debris.
 - For Ear protection, such as earmuffs or earplugs, to guard against the loud noise generated by the machine.
 - Hand Gloves to protect the hands from sharp edges and hot materials.
 - Steel-toed boots to prevent foot injuries in case of accidental impacts.
- Maintain a clean and organized work area around the bar bending machine. Remove any clutter, debris, or obstacles that could impede safe operation.
- Proper machine placement is essential for safe operation. Ensure the bar bending machine is positioned on a steady and level surface. It should be anchored or secured to prevent any unintended movement during the process.
- Each bar bending machines comes with specific guidelines and instructions provided by the manufacturer. Operators must follow these guidelines carefully. It includes adhering to load capacity limits, bending angles, and recommended maintenance procedures.
- The process of bending steel bars or rods often involves heavy materials. Workers must use proper material handling techniques to prevent back injuries and strains. This includes lifting and positioning materials correctly.
- When the bar bending machine is not in use, it should be switched off, and power should be disconnected. Implement lockout/tagout procedures to prevent unauthorized or accidental operation of the machine.

Setup and Placement of the JMB-25H Rebar Bender

This machine includes a bender stand with the unit. While not required, using the the stand is recommended for operating the machine at optimal height for most individuals.

- Ensure that the stand is placed on a level ground surface so that the bending machine is level prior operation.
- Do not place the stand on a bench or table, or uneven flooring or ground surfaces. The stand is designed for placement on a solid and even floor surface only
- The JMB-25H Rebar Bender may be used on a bench or table without the stand. If using without the stand, ensure that the unit is placed on a surface designed to support the weight of the machine, and is placed on even ground and level. Do not operate the machine with any instability in supporting the tool.

Powering the JMB-25H Rebar Bender

- This machine requires a 120V AC 15A power source; ensure the circuit supports the capacity required to operate this machine
- If an extension cord is used, a 10 AWG minimum is required; an extension cord must not exceed 150 ft. (50 m) in length.

Preparation for Use

- Turn on the Power switch. Set the bending angle to 135°; allow the machine to run idly for 3 minutes (in colder temperatures - warm-up period should be at least 5 minutes).
- After warm-up is complete, set the desired bending angle using the appropriate angle setting.
- Select, and install the Center and Moving Roller based on the diagram below.

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

Troubleshooting and Maintenance

Use this following table as a general guideline for performance and potential service issues with your JMB-25H Electric Rebar Bender. If your suspect repairs or service are necessary, or with to speak with a technician, contact BN Products-USA™ Customer Service at **(800) 992-3833**.

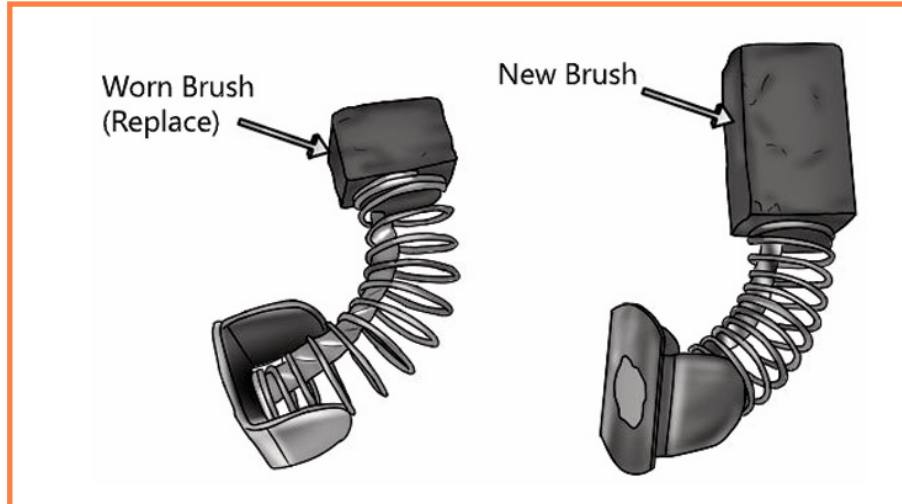
Issue	Possible Causes - Items to Review
Excessive noise coming from Bender	Wear or damage to the gears or gearbox (Service Recommended)
	Precision of Reducing Gear (Service Recommended)
Bar angle (Angle Adjustment Control) stuck or cannot be adjusted	Look for foreign object or obstruction to the adjustment lever, or determine if parts are bent or damaged
Machine fails to respond when pedal or operation switch is used	Check the foot pedal control connection; ensure the control is plugged into the correct socket
	Ensure that the Emergency Stop button is not depressed
	If operation is slow, reduced or inconsistent - check carbon brushes for wear; replace if necessary
	Internal motor parts or gearbox damage (Service Recommended)

Troubleshooting and Maintenance (continued)

Issue	Possible Causes - Items to Review
General Performance - Inconsistent or Abnormal (Service Recommended if cause cannot be determined)	Check all device connections regularly, including power cords
	Ensure all mechanical parts are free from obstruction and clean. Clean the rebar bender regularly; make sure that all surfaces are clear of dust and debris, including metal chips or fragments
	Check the condition of wiring - make sure that wires are not damaged or cut and that all connections are secure, and are not exposed to moisture

Repairs - Inspection - Regular Maintenance

Carbon Brushes - When a carbon brush is worn, the motor of the machine may lose power and/or stop. Worn carbon brushes must be replaced, and should be checked regularly to ensure proper working condition of the machine.



To Replace:

- Turn the machine OFF, disconnect the power cord from any power supply.
- Remove the side panels of the machine to access the electric motor, using a screwdriver or socket tool.
- Use the JMB-25H Parts Guide (if necessary) to locate the carbon brush caps near the top of the motor. Using a flathead screwdriver, remove the brush along with the spring, repeat the process for the second brush as both should be replaced.
- Seat the carbon brushes in the holder exactly as the original brushes, and replace the brush caps using a flathead screwdriver. Re-secure the side panels of the rebar bender.

Best Practices - Maintaining your Rebar Bender in Good Condition

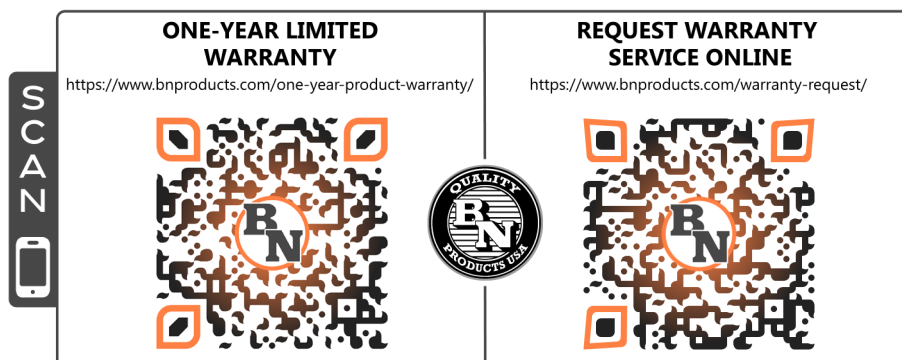
- **Inspection:** Check all external bolts and fasteners to ensure that all bolts and nuts are fully tightened before operating the machine
- **Cleaning:** The JMB-25H Rebar Bender should be cleaned after each use. Avoid using chemical cleaners. A soft, clean rag should be used to clean exposed surfaces after each use.
- **Moisture:** In the event of rainfall (outdoor use), inspect the machine thoroughly for moisture. If necessary, dry the machine completely using a dry rag or towel before operating the machine.
 - **Cover the machine** if it is not going to be used for a period of time, especially if the machine is outdoors and may be exposed to moisture or weather
- If the JMB-25H performs differently than expected, or does not power on when connected to a live power source, contact BN Products-USA™ Customer Service if you require assistance, or have questions not explicitly covered in this Manual.
 - BN Customer Service Telephone: **(800) 992-3833** (8:am - 4:30pm MST)
 - Email: **Mail @BNProducts.com**



Warranty Information

This product is covered by a limited one-year manufacturer warranty to the original purchaser to be free of defects in materials and workmanship under everyday and proper use for one year.

Use the QR codes below to access the full warranty policy, or to request warranty service from BN Products-USA™



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