



PART'S MANUAL

Metal Working



Book 2 of 2

4 STATION HYDRAULIC IRONWORKER MODEL: SW-44

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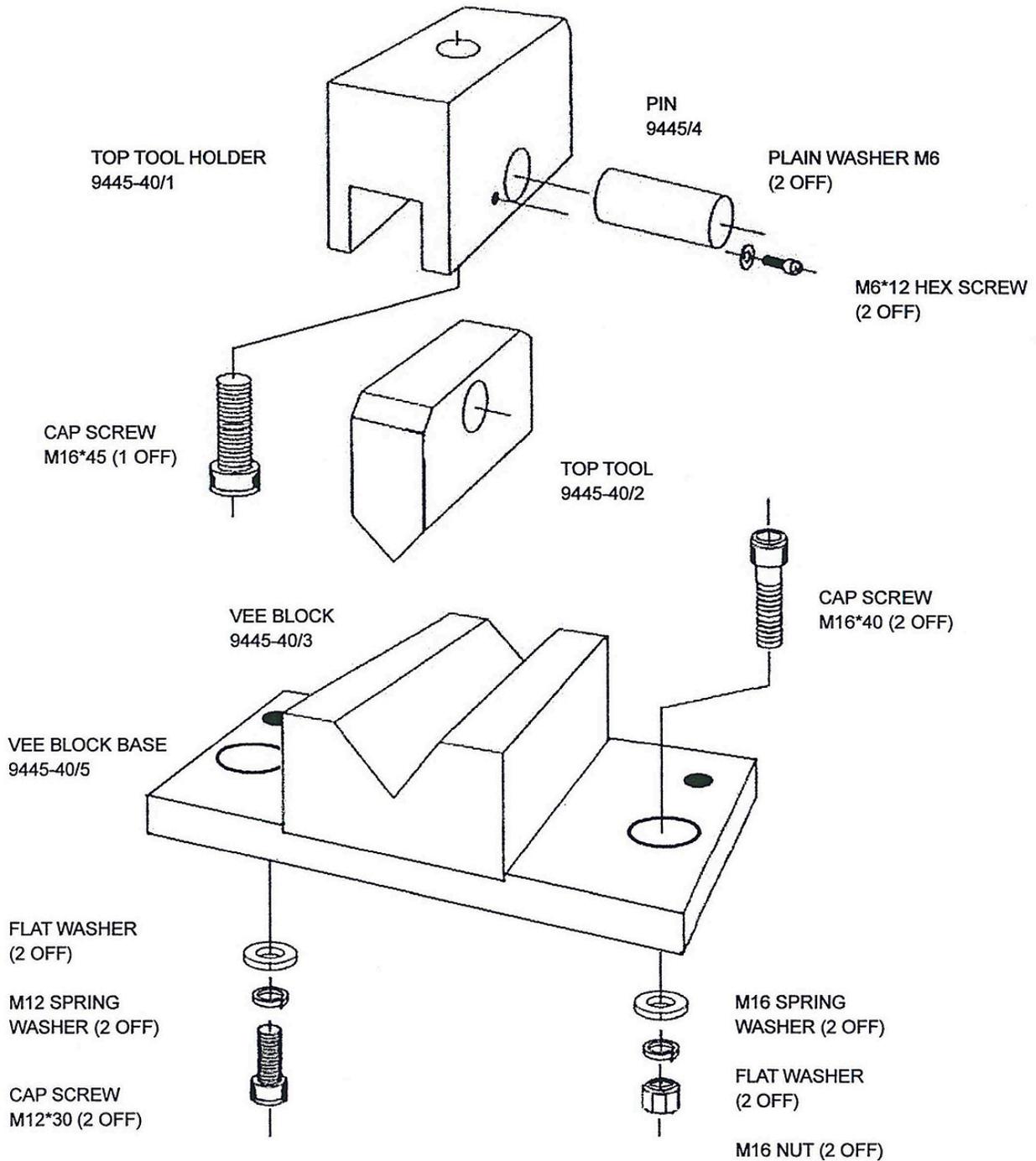


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SPECIAL TOOLING – BENDING BAR UNIT

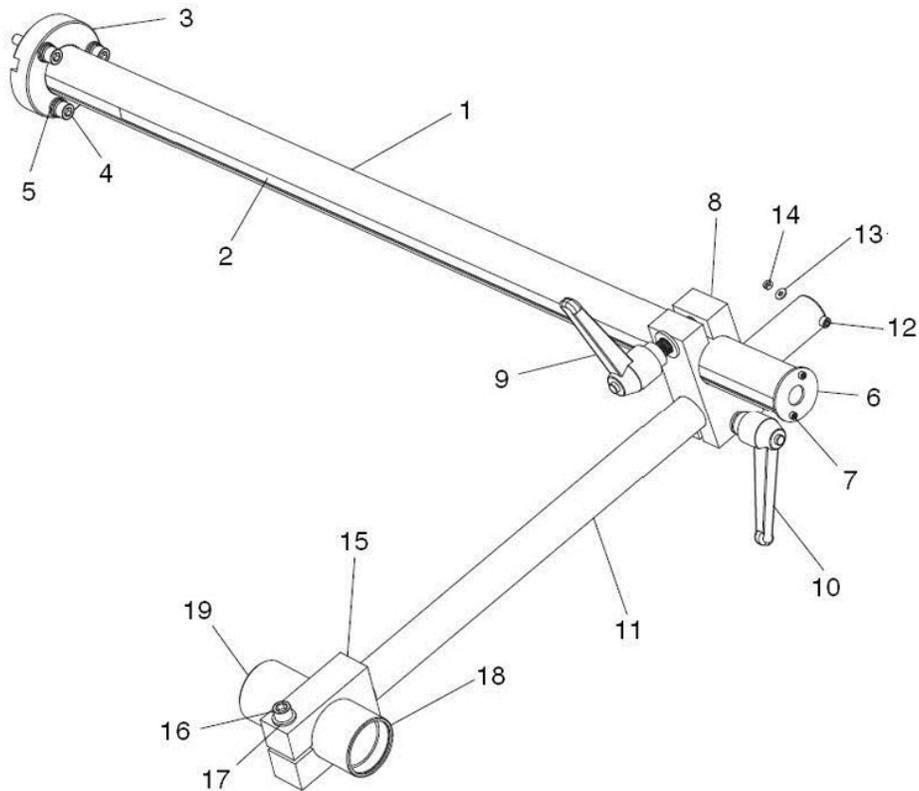
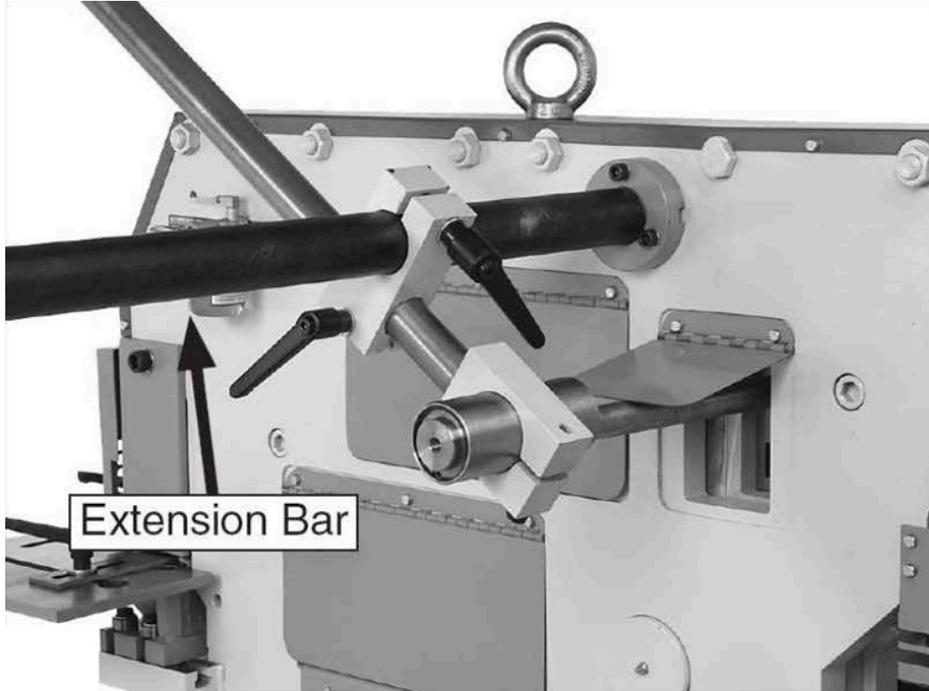


When bending always ensure work-piece is positioned central on VEE Block to avoid side loading ram. Air bending only. Adjust down limit switch to avoid unnecessary pressuring of machine.

Capacity :80 * 10 (mm²)



ONE METER RULED LENGTH STOP





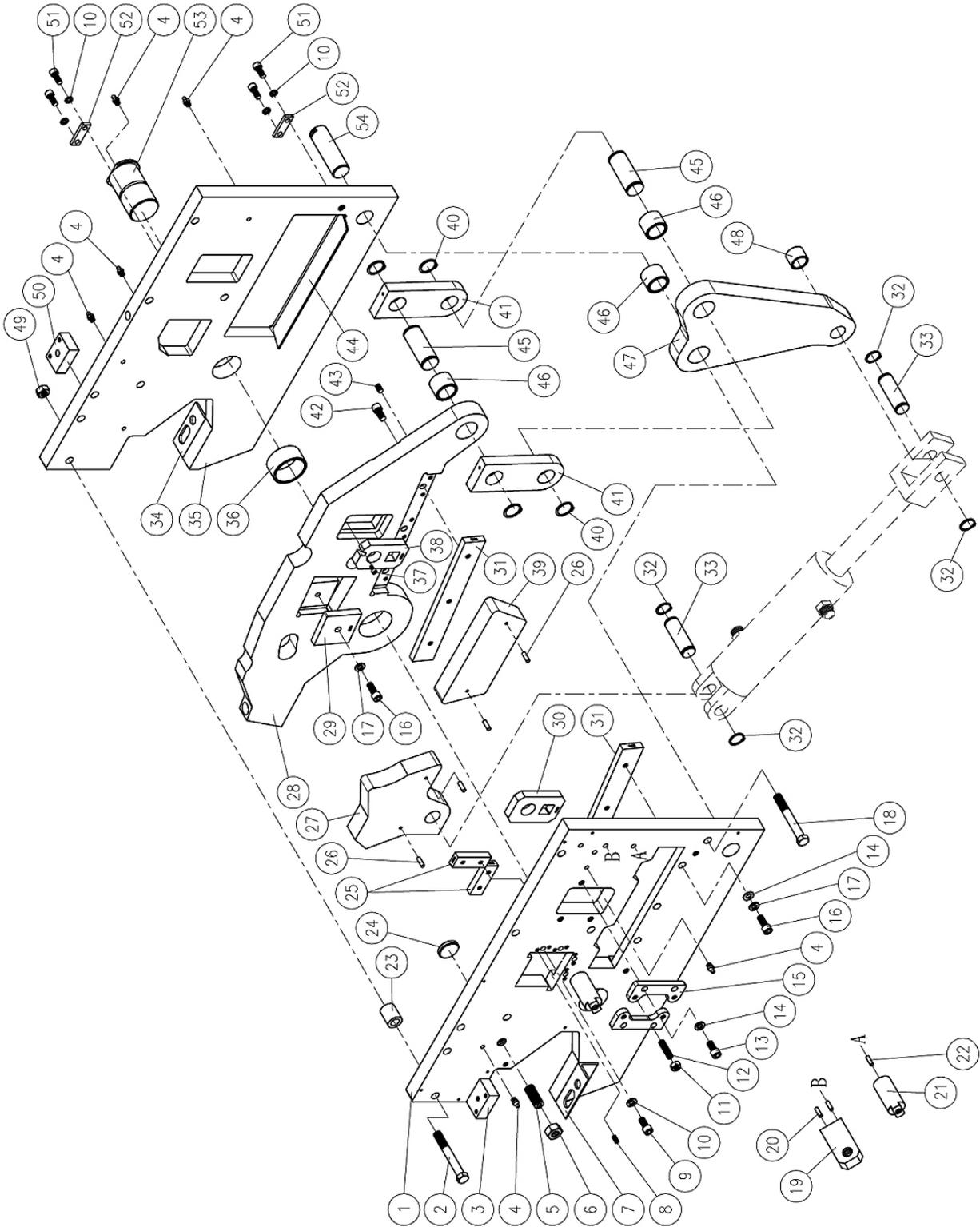
PARTS OF ONE METER RULED LENGTH STOP

| Item | Part No. | Description | Qty. |
|------|----------|----------------------------|------|
| 1 | TC 0001 | Guide Bar | 1 |
| 2 | TC 0002 | Scale 1M | 1 |
| 3 | TC 0003 | Mounting Bracket | 1 |
| 4 | TC 0004 | M10 - 1.5 x 45 Cap Screw | 3 |
| 5 | TC 0005 | 10mm, Lock Washer | 3 |
| 6 | TC 0006 | End Cap | 1 |
| 7 | TC 0007 | M4 - 0.7 x 10 Cap Screw | 2 |
| 8 | TC 0008 | Pivot Clamp | 1 |
| 9 | TC 0009 | M12 - 1.75 x 40 Lock Lever | 1 |
| 10 | TC 0010 | M16 - 2 x 45 Lock Lever | 1 |
| 11 | TC 0011 | Extension Bar | 1 |
| 12 | TC 0012 | M6 - 1 x 55 Cap Screw | 1 |
| 13 | TC 0013 | 6mm Flat Washer | 1 |
| 14 | TC 0014 | M6 - 1 Hex Nut | 1 |
| 15 | TC 0015 | Clamp | 1 |
| 16 | TC 0016 | M12 - 1.75 x 75 Cap Screw | 1 |
| 17 | TC 0017 | 12mm Flat Washer | 1 |
| 18 | TC 0018 | Support Shaft | 1 |



CUTTING HEAD PARTS DIAGRAM

Always reference machine Model and Serial number when ordering replacement blades.





Cutting Head Parts List

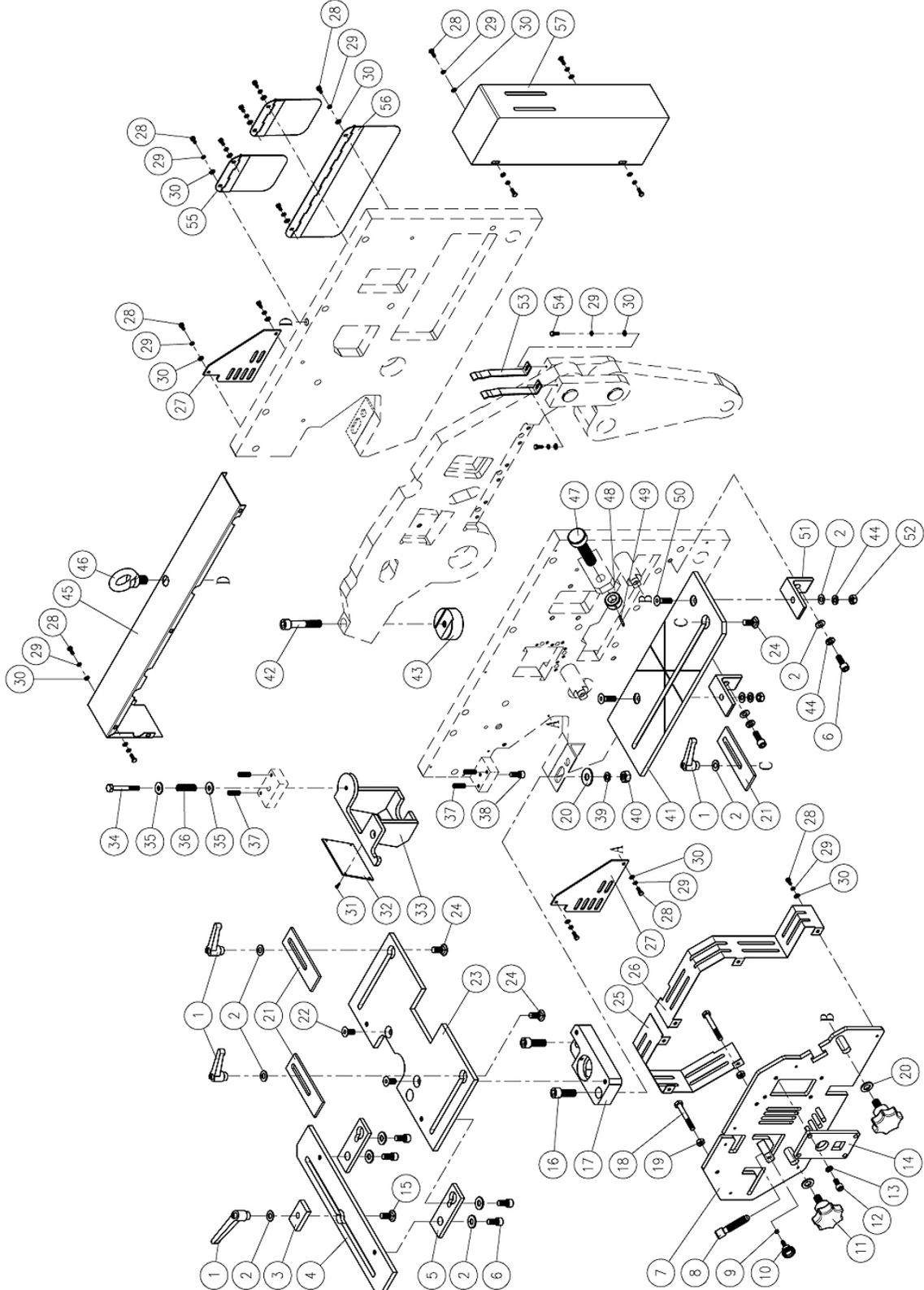
| Item | Description | Specification | Qty. |
|------|-------------------------|-------------------|------|
| 1 | Right cover | | 1 |
| 2 | Hex screw | M16*2.0P*120L*38L | 7 |
| 3 | Right plate | | 1 |
| 4 | grease fitting | PT1/8" | 6 |
| 5 | Set screw | M20*2.5P*40L | 2 |
| 6 | Hex nut | M20*2.5P | 2 |
| 7 | Punch bolster support R | | 1 |
| 8 | Set screw | M8*1.25P*20L | 8 |
| 9 | Cap screw | M10*1.5P*35L | 4 |
| 10 | Spring washer | M10 | 4 |
| 11 | Hex nut | M12*1.75P | 4 |
| 12 | Set screw | M12*1.75P*40L | 4 |
| 13 | Cap screw | M12*1.75P*30L | 4 |
| 14 | Washer | 13*23*2t | 7 |
| 15 | Section blade retainer | | 2 |
| 16 | Cap screw | M12*1.75P*35L | 4 |
| 17 | Spring washer | M12 | 3 |
| 18 | Hex screw | M16*2.0P*100L*38L | 1 |
| 19 | over setting block | | 1 |
| 20 | Spring pin | 6*25L | 2 |
| 21 | Slide | | 2 |
| 22 | Spring pin | 12*24L | 2 |
| 23 | Bushing | | 6 |
| 24 | Copper compact block | | 2 |
| 25 | Angle blade body | | 2 |
| 26 | Spring washer | 6*20L | 4 |
| 27 | Left clamping plate | | 1 |
| 28 | Main arm | | 1 |
| 29 | Angle blade arm | | 1 |
| 30 | STD section blade body | | 1 |
| 31 | Shear blade | | 2 |
| 32 | C-ring | STW-30 | 4 |
| 33 | Rotating shaft | | 2 |



| Item | Description | Specification | Qty. |
|------|-------------------------|---------------|------|
| 34 | Punch bolster support L | | 1 |
| 35 | Left cover | | 1 |
| 36 | Main pivot bush | | 1 |
| 37 | Cap screw | M6*1.0P*12L | 1 |
| 38 | STD section blade arm | | 1 |
| 39 | Middle clamping plate | | 1 |
| 40 | C-ring | STW-38 | 4 |
| 41 | Link block | | 2 |
| 42 | Cap screw | M12*1.75P*20L | 3 |
| 43 | Set screw | M10*1.5P*20L | 9 |
| 44 | Striper plate | | 1 |
| 45 | Y Link pivot | | 2 |
| 46 | Y Link bush | | 3 |
| 47 | Y Link | | 1 |
| 48 | Bearing | DU3040 | 1 |
| 49 | Hex nut | M16*2.0P | 7 |
| 50 | Left plate | | 1 |
| 51 | Cap Screw | M10*1.5P*20L | 4 |
| 52 | Support bracket | | 2 |
| 53 | Main pivot | | 1 |
| 54 | External Link pivot | | 1 |



GUARDS AND TABLE PARTS DIAGRAM





Guards and Tables Parts List

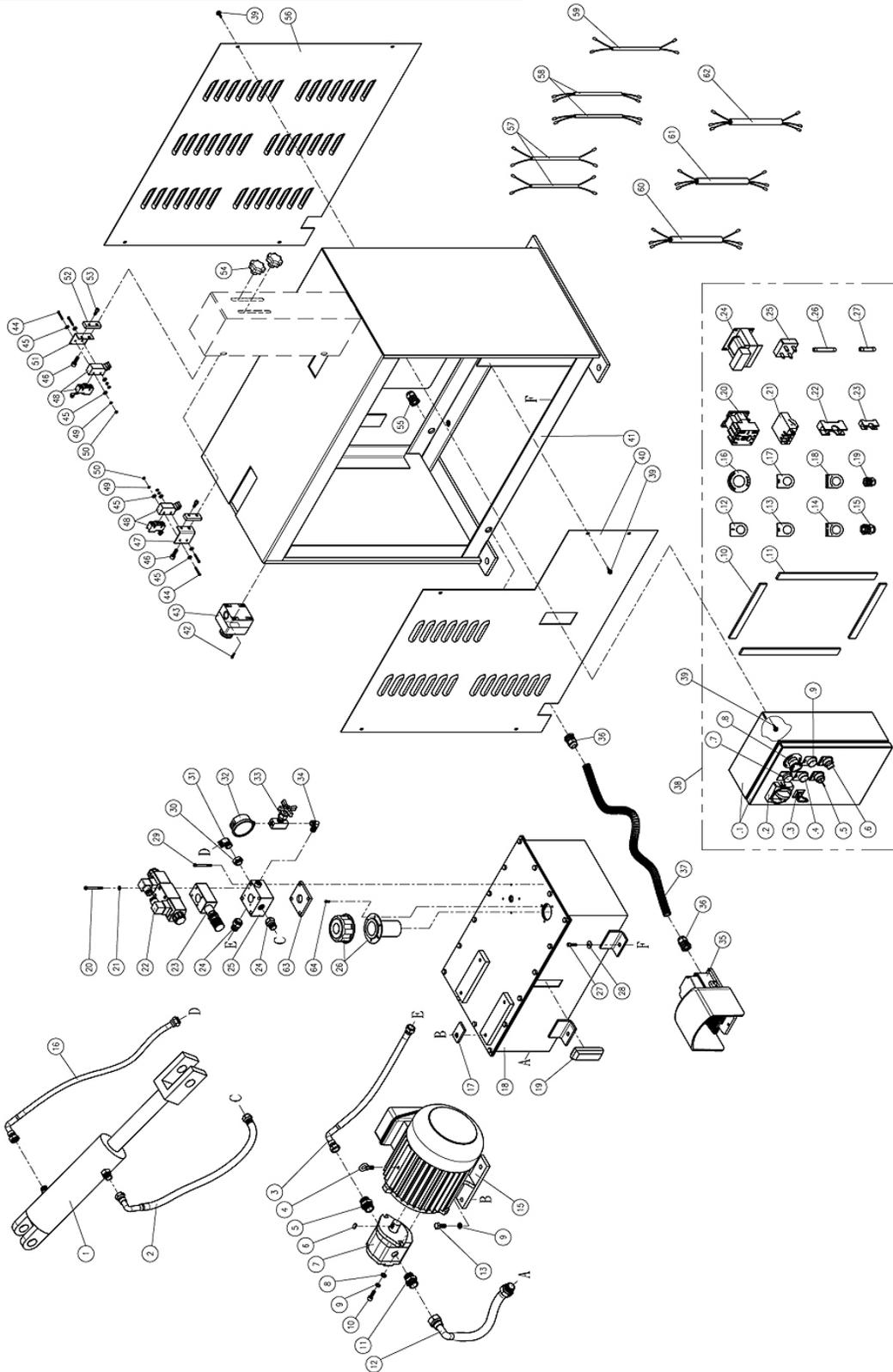
| Item | Description | Specification | Qty. |
|------|---------------------------------|-----------------|------|
| 1 | Locking Handle | 1/2"-12 *20L | 4 |
| 2 | Washer | 13*23*2t | 12 |
| 3 | Punch guide | | 1 |
| 4 | Punch table extension | | 1 |
| 5 | Punch table support bar | | 2 |
| 6 | Cap screw | M12*1.75P*25L | 6 |
| 7 | Hold down plate | | 1 |
| 8 | Angle hold down screw | | 1 |
| 9 | Angle hold locking PU block | ∅6-5L | 1 |
| 10 | Angle hold locking knob | M8*1.25P*20L | 1 |
| 11 | Hold down locking knob | M16*2.0P*30L | 2 |
| 12 | Cap screw | M10*1.5P*20L | 4 |
| 13 | Spring washer | M10 | 4 |
| 14 | Round /square section hold down | | 1 |
| 15 | Carriage Bolt | 1/2"*12*1-1/2"L | 1 |
| 16 | Cap screw | M16*2.0P*45L | 2 |
| 17 | Punch bolster | | |
| 18 | Hex screw | M10*1.5P*80L | 1 |
| 19 | Hex nut | M10*1.5P | 1 |
| 20 | Washer | 17*37*2.5t | 4 |
| 21 | Punch / Notch / shear guide | | 3 |
| 22 | Flat head screw | M12*1.75P*25L | 2 |
| 23 | Punch table | | 1 |
| 24 | Carriage Bolt | 1/2"*12*1-1/4"L | 3 |
| 25 | Hold down cover (Left) | | 1 |
| 26 | Hold down cover (Right) | | 1 |
| 27 | Cover | | 2 |
| 28 | Hex screw | M6*1.0P*12L | 28 |
| 29 | Spring washer | M6 | 30 |
| 30 | Washer | 6.5*13*1t | 30 |
| 31 | Round head screw | M4*0.7P*10L | 4 |
| 32 | Punch front cover | | 1 |
| 33 | Punch stripper bracket | | 1 |



| Item | Description | Specification | Qty. |
|------|----------------------------|---------------|------|
| 34 | Hex screw | M10*1.5P*100L | 1 |
| 35 | Washer | 10.2*26*2t | 2 |
| 36 | Spring | | 1 |
| 37 | Set screw | M10*1.5P*30L | 4 |
| 38 | Cap screw | M10*1.5P*25L | 1 |
| 39 | Spring washer | M16 | 2 |
| 40 | Hex nut | M16*2.0P | 2 |
| 41 | Shear table | | 1 |
| 42 | Cap screw | M16*2.0P*90L | 1 |
| 43 | Punch block | | 1 |
| 44 | Spring washer | M12 | 4 |
| 45 | Top cover | | 1 |
| 46 | Clevis | | 1 |
| 47 | Hold down adjustment screw | | 1 |
| 48 | Hold down adjustment nut | | 1 |
| 49 | Spring pin | 4*30L | 1 |
| 50 | Flat head screw | M12*1.75P*35L | 2 |
| 51 | Shear table support | | 2 |
| 52 | Hex nut | M12*1.75P | 2 |
| 53 | Stroke bracket | | 2 |
| 54 | Hex screw | M6*1.0P*16L | 2 |
| 55 | Angle / section cover | | 2 |
| 56 | Shear cover | | 1 |
| 57 | End cover | | 1 |



CABINET COMPONENTS PARTS DIAGRAM





Cabinet Components Parts List

| Item | Description | Specification | Qty. |
|------|-----------------------------------|---------------|------|
| 1 | Hydraulic cylinder | | 1 |
| 2 | Flex Pipe B (Manifold - Cylinder) | | 1 |
| 3 | Flex Pipe (Pump - Manifold) | | 1 |
| 4 | Eye bolts | M8*1.25P*15L | 1 |
| 5 | Adapter | | 1 |
| 6 | Key | 4*4*15L | 1 |
| 7 | Hydraulic pump | | 1 |
| 8 | Washer | 10*20*2.0t | 2 |
| 9 | Spring washer | M10 | 6 |
| 10 | Cap screw | M10*1.5P*30L | 2 |
| 11 | Adapter | | 1 |
| 12 | Flex Pipe (Tank - Pump) | | 1 |
| 13 | Hex screw | M10*1.5P*30L | 4 |
| 15 | Motor | | 1 |
| 16 | Flex Pipe A (Manifold - Cylinder) | | 1 |
| 17 | Rubber Pad | | 4 |
| 18 | Tank | | 1 |
| 19 | Oil sight glass / Manometer | | 1 |
| 20 | Cap screw | M5*0.8P*85L | 4 |
| 21 | Spring washer | M5 | 4 |
| 22 | Direction control valve | | 1 |
| 23 | Relief valve | | 1 |
| 24 | Adapter | | 2 |
| 25 | Manifold block | | 1 |
| 26 | Diffuser | | 1 |
| 27 | Cap screw | M8*1.25P*20L | 4 |
| 28 | Washer | 8.2*23*2t | 4 |
| 29 | Cap screw | M5*0.8P*45L | 4 |
| 30 | Bushing | | 1 |
| 31 | Elbow connection | | 1 |
| 32 | Pressure gauge | | 1 |
| 33 | Stop Valve | | 1 |
| 34 | Elbow connection | | 1 |



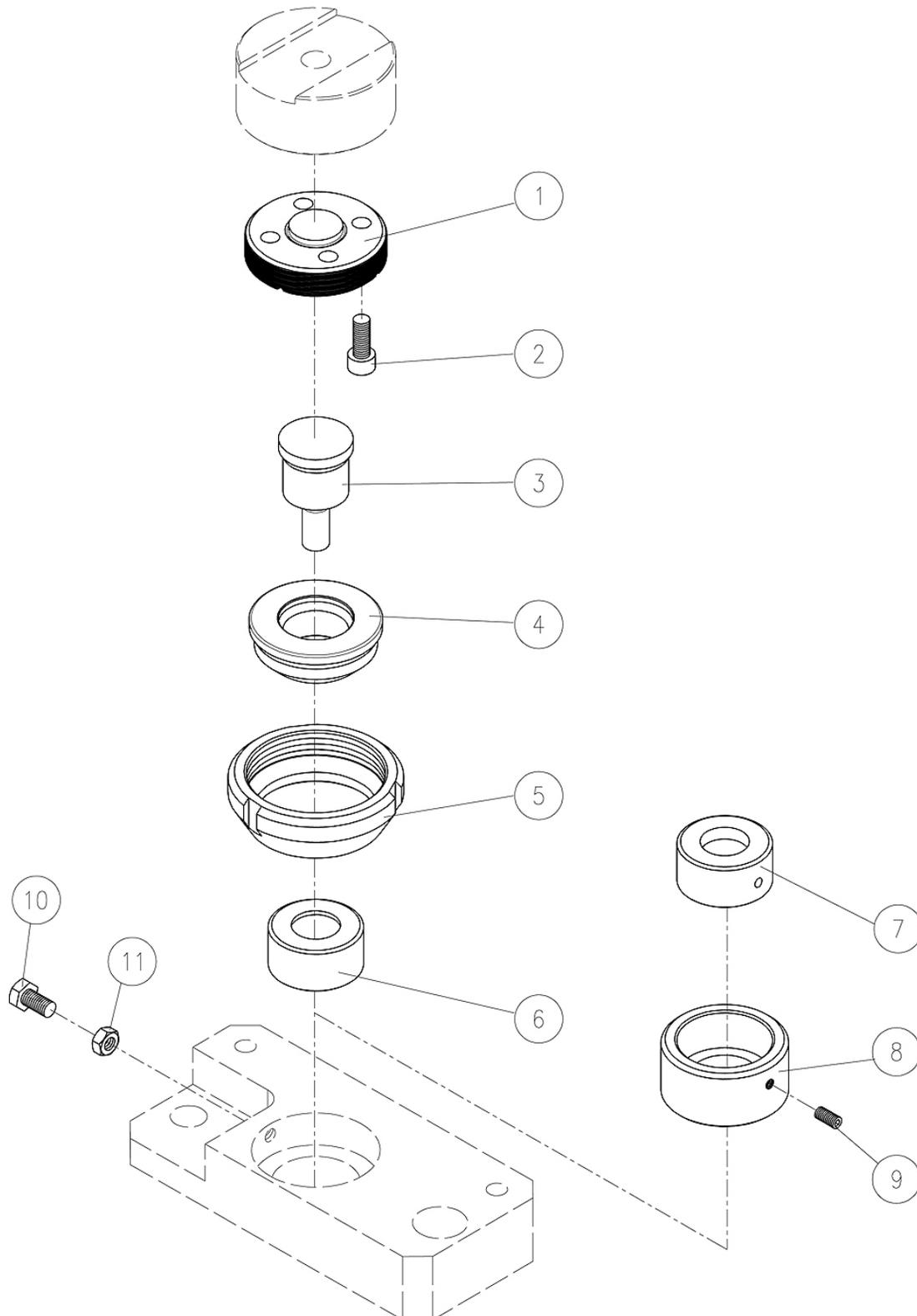
| Item | Description | Specification | Qty. |
|-------|----------------------------------|---------------|------|
| 35 | Foot switch | | 1 |
| 36 | Strain Relief | | 2 |
| 37 | Tube | | 1 |
| 38.1 | Control cabinet | | 1 |
| 38.2 | Main power switch | | 1 |
| 38.3 | Electrical Cabinet Door Latch | | 1 |
| 38.4 | Start button | | 1 |
| 38.5 | Normal / inch switch | | 1 |
| 38.6 | Punch / Shear switch | | 1 |
| 38.7 | Power lamp | | 1 |
| 38.8 | Emergency stop button | | 1 |
| 38.9 | Stop button | | 1 |
| 38.10 | Sponge Strip | 25*6-230L | 2 |
| 38.11 | Sponge Strip | 25*6-320L | 2 |
| 38.12 | Power label | | 1 |
| 38.13 | Start label | | 1 |
| 38.14 | Normal inch label | | 1 |
| 38.15 | Strain Relief | | 2 |
| 38.16 | Emergency stop label | | 1 |
| 38.17 | Stop label | | 1 |
| 38.18 | Punch shear label | | 1 |
| 38.19 | Strain Relief | | 6 |
| 38.20 | Power contactor | | 1 |
| 38.21 | Relay | | 1 |
| 38.22 | Fuse Holder | | 2 |
| 38.23 | Fuse Holder | | 1 |
| 38.24 | Transformer | | 1 |
| 38.25 | Rectifier | | 1 |
| 38.26 | Fuse | | 2 |
| 38.27 | Fuse | | 1 |
| 39 | Hex screw | 3/4" | 13 |
| 40 | Front base cover | | 1 |
| 41 | Base | | 1 |
| 42 | Cap screw | M4*0.7P*12L | 2 |
| 43 | Punch side emergency stop button | | 1 |



| Item | Description | Specification | Qty. |
|------|---------------------------|---------------|------|
| 44 | Round head screw | M4*0.7P*30L | 4 |
| 45 | Washer | 4.5*12*1t | 8 |
| 46 | Cap screw | M8*1.25P*25L | 2 |
| 47 | Micro switch holder-lower | | 1 |
| 48 | Micro switch | | 2 |
| 49 | Spring washer | M4 | 4 |
| 50 | Hex nut | M4*0.7P | 4 |
| 51 | Micro switch holder-upper | | 1 |
| 52 | Holder plate | | 2 |
| 53 | Cap screw | M6*1.0P*12L | 2 |
| 54 | Micro switch locking knob | M8*1.25P | 2 |
| 55 | Strain Relief | | 1 |
| 56 | Rear base cover | | 1 |
| 57 | Micro switch cord | | 2 |
| 58 | Switch Cord | | 2 |
| 59 | Emergency stop cord | | 1 |
| 60 | Power cord | | 1 |
| 61 | Motor cord | | 1 |
| 62 | Foot switch cord | | 1 |
| 63 | Rubber Pad | | 1 |
| 64 | Round head screw | M5*0.8P*12L | 3 |



DIE MOUNTING PARTS DIAGRAM





Die Mounting Parts List

| Item | Description | Specification | Qty. |
|------|-------------------------------|-------------------|------|
| 1 | RAM pressure plate | | 1 |
| 2 | Cap screw | M8*1.25P*20L | 4 |
| 3 | Round punch | | 1 |
| 4 | Punch adaptor for round punch | | 1 |
| 5 | Punch retaining ring | | 1 |
| 6 | Round die | | 1 |
| 7 | Round die | | |
| 8 | Die shoe for round die | | 1 |
| 9 | Hex screw | M8*1.25P*20L (13) | 1 |
| 10 | Hex nut | M8*1.25P (12) | 1 |
| 11 | Set screw | M6*1.0P*6L | 1 |



NOTES



NOTES



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