HOW TO USE (CUTTING)

1. Normal cutting (Fig. 5)
   (1) Turn the lever in the direction of the arrow mark and open the cover.
   (2) Set the setting dial at the "cut" position. (Turn the setting dial all the way clockwise.) (Fig. 6)
   (3) Set the unit in the position shown in Fig. 5.
   (4) Set the rebar to be cut on the lower cutter.
   (5) When the rebar is set, make sure that the reaction stopper B is hooked to the rebar.
   (6) Pull the switch trigger and cut the rebar.

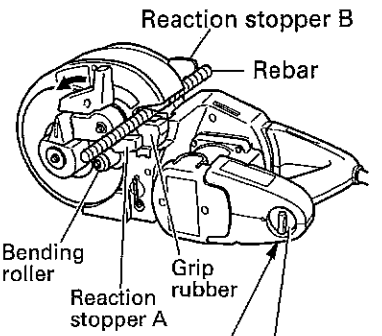


Fig. 5

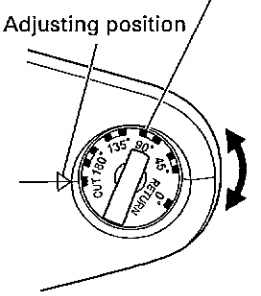


Fig. 6

⚠ WARNING:

- **While turning switches, never put your hand close to the cutter, reaction stopper, or bending roller.**
- **Bringing your hand close to these components can result in serious injury.**
- **Do not cut any rebar exceeding the maximum capacities of the unit described in the specifications.**
- **Never cut any hard materials such as PC(Precast concrete) steel. Materials of this type are likely to scatter into pieces and cause injuries.**
- **The rebar you are cutting may have a hard spot in it. Quality may vary within each rebar. Do not attempt to cut NON-GRADE rebar.**
- **Replace the worn grip rubber with new one when replacing the cutter.**
- **Note that the unit is not a hand held tool. Be absolutely sure to use the unit only after placing it on stable spots such as floor, ground, etc.**

⚠ CAUTION:

Even after the cutting has been completed, continue pulling the switch trigger until the motor starts to run in the reverse direction and the cutter starts to return. If the switch trigger is released too early, the cutter will not return and the trigger will have to be pulled again.

2. Removing the rebar during cutting operation. (Fig. 7)
   If the switch trigger is released in the middle of cutting, the cutter can come to a stop at a halfway position, jumming the rebar in the unit.
   When this occurs, you can either pull the switch trigger again and cut off the rebar, or you can free the rebar by bringing the upper cutter back up to the home position by carrying out the following procedure. (Fig. 7)

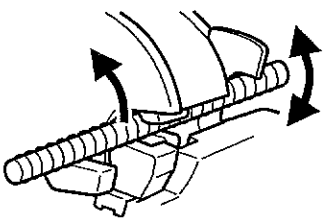


Fig. 7

○ Removing (Fig. 8)
Set the setting dial to the "RETURN" position as shown in Fig. 8 and pull the switch trigger again.

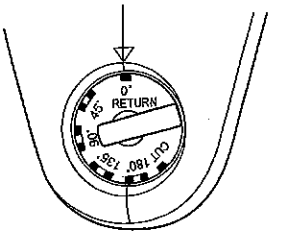


Fig. 8

SERVICE LIFE AND REPLACEMENT OF THE CUTTER

1. Service life of cutter (Fig. 9)
Repeated cutting of the rebar can result in the "wear and tear", "deformation", "nicked edges", etc. Using the cutter under such circumstances will not only damage the machine but also there will be a fear of the broken cutter fragments flying around.
Replace it with a new cutter after cutting no more than 5,000 pieces of rebar.
2. Before removing the cutter
(1) Pull the switch lightly and let the upper cutter move slowly. When the hexagon socket bolt that fixes the upper cutter comes out of the cam cover, turn the switch OFF and stop the motor.
(2) Unplug the power cord from the receptacle.
3. Removal
○ If you remove the hexagon socket bolt using the provided Allen key, you can remove the cutter. (Pushing the cutter guard up in the direction of the arrow shown in Fig. 10, facilitates removal of the upper cutter.)
○ Removal of the lower cutter can be easily made if the lower cutter is wrenched with a Phillips head screwdriver as shown in the following diagram. (Fig. 11)

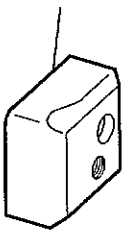


Fig. 9

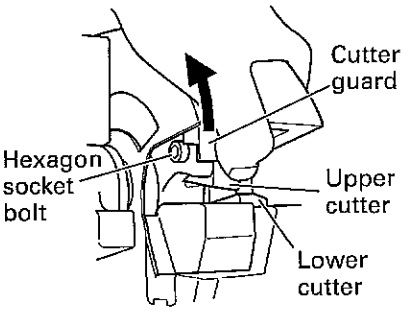


Fig. 10

⚠ WARNING:

- **To prevent accidents, always be sure to turn the switch OFF and unplug the power cord from the receptacle.**
- **If you remove the hexagon socket bolt using the provided Allen key, you can remove the cutter. (Pushing the cutter guard up in the direction of the arrow shown in Fig. 10, facilitates removal of the upper cutter.)**

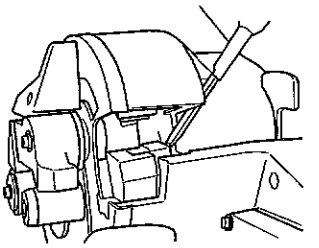


Fig. 11

4. Mounting
   (1) Get rid of dust around the cutter installing section and clean it up.
   (2) Align the hole of a new cutter and the position of a pin, and insert into the installing section.
   (3) Also replace the hexagon socket bolt (packed along with the cutter) with a new one simultaneously, completely tighten it using the attached Allen key, and then fix the cutter.

⚠ CAUTION:

- **Install the cutter and accessories securely according to the instruction manual. If you fail to install them properly, they may come off and cause an injury.**
- **Be sure to unplug the power cord from the receptacle when the cutter is checked, cleaned, and replaced. Failure to do so can result in a serious injury.**

HOW TO USE (BENDING)

1. Setting bending angles by setting dial
   The bar can be bent according to the angles indicated on the setting dial, as shown in Fig. 12.

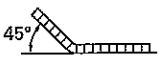
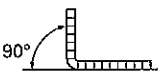
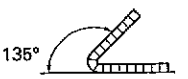
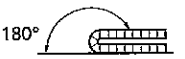
Dial indication	45°	90°	135°	180°
Condition of rebar				

Fig. 12

In bending the rebar of #3(3/8"), #4(1/2"), and #5(5/8") diameters, a difference takes place in the bending angle even in the same dial position depending upon the difference of rebar's thickness. Slightly change a position of the setting dial depending upon the rebar's diameter even with the same bending angle as shown in Fig. 13.

Adjusting position

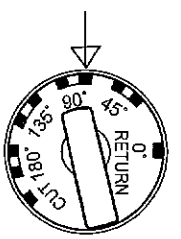


Fig. 13

Size of rebar	Colors of indicated marks
#3(3/8")	White
#4(1/2")	Red
#5(5/8")	Yellow

NOTE: Even at the same dial setting position, the bending angle can sometimes differ if the diameter or hardness of the rebar is different. Use the angle marks merely as a rough guideline.

2. Ordinary bending
   (1) Set the unit in the position with the turntable up as shown in Fig. 14.
   (2) Make sure that the cover is closed.
   (3) Set the setting dial at the desired angle. (Fig. 13)
   (4) Place the rebar on the center plate and set it correctly as shown in Fig. 14.
   (5) Pull the switch trigger and bent the rebar.
   (6) Continue pulling the switch trigger untill the motor makes reverse rotation and the bending roller starts to return. (Once the bending roller starts to return, it will automatically return all the way to the home position even if the switch trigger is released.)(Fig. 15)

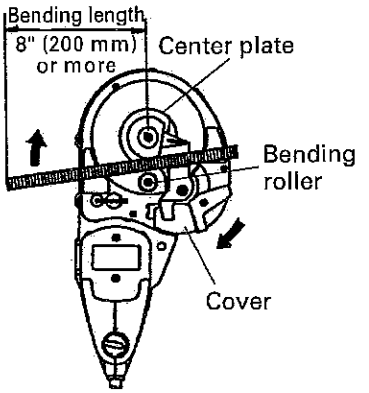


Fig. 14

⚠ WARNING:

- **Make absolutely sure that the cutter cover is closed when you don't carry out the cutting work. If the cover is kept open, the cutter can jam on foreign objects and cause serious accidents. (Fig. 16)**
- **Never bring your hand close to the bending roller during operation.**
- **If you bend the rebar with a large angle while placing your hand onto it, there is a fear of getting your hand caught in by the fold-back reaction of the rebar. Never place your hand onto the position where the rebar may fold back.**
- **Do not bend any rebar exceeding the maximum capacities of the unit described in the specifications. Never bend any hard materials such as PC(Precast concrete) steel. Materials of this type are likely to scatter into pieces and cause injuries.**
- **The rebar you are bending may have a hard spot in it. Quality may vary within each bar. Do not attempt to bend NON-GRADE Rebar.**

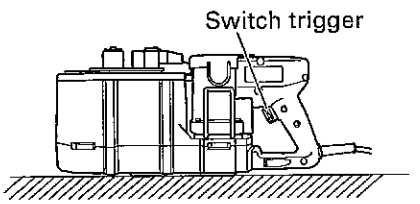


Fig. 15

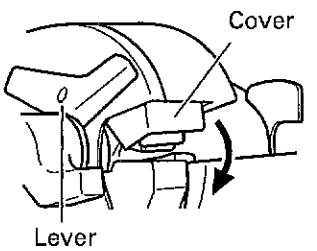


Fig. 16

- ○ **Never place your hand onto the bending side of the rebar. If you do so, your hand may be caught in the mechanical parts.**
- ○ **Install the deflection guard for operation with the bending length of a rebar 20" (inside dimension of the deflection guard) or less to protect the persons around the rebar cutter/bender in case rebar splinters into pieces and deflects during bending. (Fig. 21)**
- ○ **Remove the deflection guard when bending a rebar whose bending length and the fixed length are more than 20" to prevent damage to the deflection guard.**
- ○ **Replace the deflection guard with new one if it is damaged. Damaged deflection guard cannot protect the persons around the rebar cutter/bender in case a rebar splinters into pieces and deflects during bending.**
- ○ **Note that the unit is not a hand-held tool. Be absolutely sure to use the unit only after placing it on a stable spots such as floor, ground, etc.**
- ○ **Begin operation only after marking sure that there are no people within the turning range of the material to be bent.**
- ○ **The minimum required bending length is 8" (200 mm).**
  If the bending length is not long enough, the rebar can come off during bending operation, or it can break into fragments and scatter dangerously. (Fig. 14)
- ○ **Place the rebar on the center plate and set it so that it is horizontal with the turntable surface.**
  If the side that is to be bent is set inclined upward, the rebar can come loose from the bending roller while bending causing it to fly off. (Fig. 17)

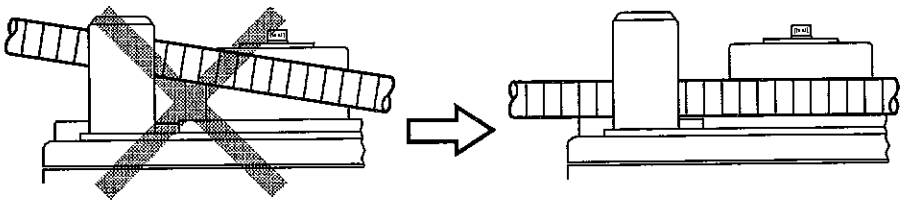


Fig. 17

- ○ **When bending multiple rebars at one time, some may come off the bending roller and guide, etc., and therefore exercise caution and set them horizontally.**
- ○ **Bend less than every 3 pieces of rebar with a #3(3/8") diameter, less than every 2 pieces with a #4(1/2") diameter, and every 1 piece with a #5(5/8") diameter.**
- ○ **Remember that the cutter moves even during the bending operation, thereby, close the cutter cover without fail.**

3. How to install deflection guard

The deflection guard is provided to protect the persons around the rebar cutter/bender in case a rebar splinters into pieces and deflects during bending. Install the deflection guard to the VB16Y for operation with the bending length of a rebar 20" (inside dimension of the deflection guard) or less.

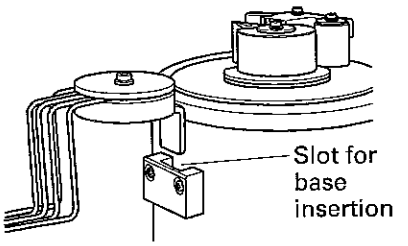


Fig. 18