

Operating Instructions

Bramley Model SJ2 Swaging & Jennying Machine

**NEW model
with larger
throat
capacity**

Models SJ2, SJ2M



Licence Number
706519

BRAMLEY

Bramley Model SJ2 & SJ2M Swaging & Jennying Machine

Thank you for purchasing this high quality, industrial duty, swaging machine.

RR Bramley & Co Ltd have a proud history of engineering, celebrating our 100th year of business in 2021. We've been manufacturing machine tools under our Bramley brand since 1953, building an enviable reputation for quality, performance and durability.

With care and a little regular maintenance your new machine, like us, will provide years of dependable service.

Before use (SJ2 & SJ2M)

The machine has had rust preventative applied to all exposed parts. This should be thoroughly cleaned and replaced, as required, with a thin smear of light machine oil. Securely fasten to a stable work bench, or can be mounted to the Bramley Stand (part number BGP).

Lubrication

Apply grease regularly (fortnightly) to all 4 grease nipples (2 on the front, and 2 on the rear) provided. A few drops of oil onto the gears is also recommended.

Operation

The machine can be used in 2 settings:

1. By moving the Hook Plates down, heavy swaging and crimping of mild steel up to 1.6mm thickness can be carried out.
2. With the Hook Plates up, 380mm of usable throat will allow swaging of mild steel up to 1.2mm at any point to the maximum reach.

The Bottom Shaft slides forwards and backwards to allow easy centralising of the Top and Bottom Wheels. This can be done by first loosening the Clamp Bolts (16mm spanner required) and then using the Adjusting Lever on the other side of the machine to slide the Bottom Shaft to the desired position.

The Guide Plate can be positioned where required to operate as a depth stop with a range up to 275mm.

The Top Shaft pivots up and down and is lowered during operation by means of the Top Handle. This handle is slowly screwed down while rotating the shafts back and forth. Slowly forming the bend in this manner will help to overcome possible cutting or splitting of the sheetmetal.



All rollers (except the crimping rollers) use a collar that spaces the roller out to the end of the shaft. Fit keys (provided) to both shafts to drive the rollers.

The Crimping Rollers are fitted directly onto the shafts - no collars are required.

The Crimping Rollers only require one key to be fitted to the Bottom Roller.

If the Guide Plate is required for swaging further in the job (with the Hook Plates up), the Guide Plate will need to be removed to allow the Guide Bracket to slide further back (to a maximum of 275mm) before the Guide Bracket shafts interfere with the Crank Handle.

If greater guide depth is required shorter Guide Shafts need to be fitted, these are available for purchase separately as an accessory.

Once the desired form has been achieved the two wheels can be separated by unscrewing the Top Handle. The spring loaded Top Shaft will be raised automatically as this handle is unscrewed.



Showing Hook Plates in down position for heavy swaging work.

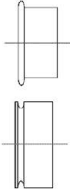
SJ2M - motorised version

Supplied with heavy-duty 750W (1HP), 3Ph motor and reduction gearbox to drive the rollers at 38 rpm, controlled via interlocked forward / reverse foot switches.

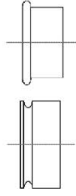


Standard Accessories

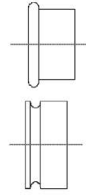
These come with the machine.



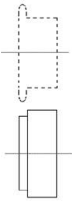
2mm Swage
or Wiring



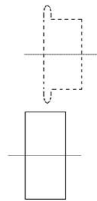
4mm Swage
or Wiring



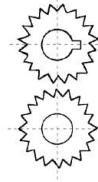
7mm Swage
or Wiring



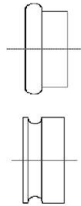
Jennying



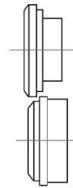
Closing



Crimping



10mm Swage
or Wiring



Necking

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