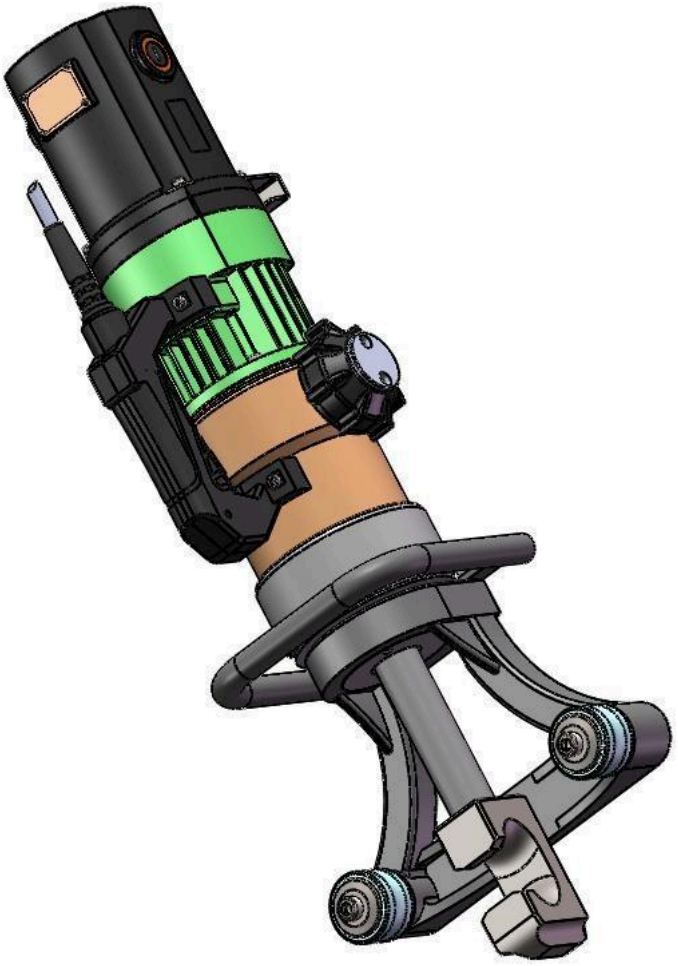
PortaForce PF32SB Portable Rebar Bender/Straightening Machine

Parts Assembly Instruction Manual



Introduction

Assembly Work Instructions provide clear guidance for assembly personnel to perform tasks accurately and efficiently, ensuring both product quality and production efficiency. This document specifies the assembly procedures, requirements, and safety precautions for reference during operation. It establishes a standard format for assembly instructions in accordance with the content requirements defined by the task.

Assembly Preparation

1. **Assembly Parts List**
   Compile a complete list of all components required for assembly, referencing product specifications and design drawings. Include part names, quantities, and technical specifications to ensure accuracy.

2. **Tool and Equipment Preparation**
   Prepare all tools and equipment necessary for the assembly process based on the parts list. This may include hand tools (e.g., wrenches, screwdrivers) and power tools, ensuring all are in proper working condition.

3. **Work Environment Preparation**
   Verify that the assembly area is clean, organized, and free of obstructions. Ensure adequate lighting and ventilation to maintain a safe and efficient working environment.

Assembly Procedure

1. **Step 1: Preparation**
   a. Verify that all parts are complete; promptly replace or supplement any damaged or missing components.
   b. Clean all parts to ensure surfaces are free of dust, debris, and contaminants.

2. **Step 2: Assembly**
   a. Assemble components in the sequence specified by the assembly parts list and design drawings.
   b. Utilize the appropriate tools and equipment to ensure correct installation, alignment, and secure connections.

3. **Step 3: Debugging and Testing**
   a. Perform functional tests and debugging on the assembled product to verify proper operation.
   b. Confirm that all connections are secure, and check for loose components, leaks, or misalignments.

4. **Step 4: Quality Inspection**
   a. Conduct a thorough inspection to ensure the assembled product meets all specifications and requirements.
   b. Evaluate appearance, dimensions, functionality, and other relevant criteria, and document the inspection results accurately.

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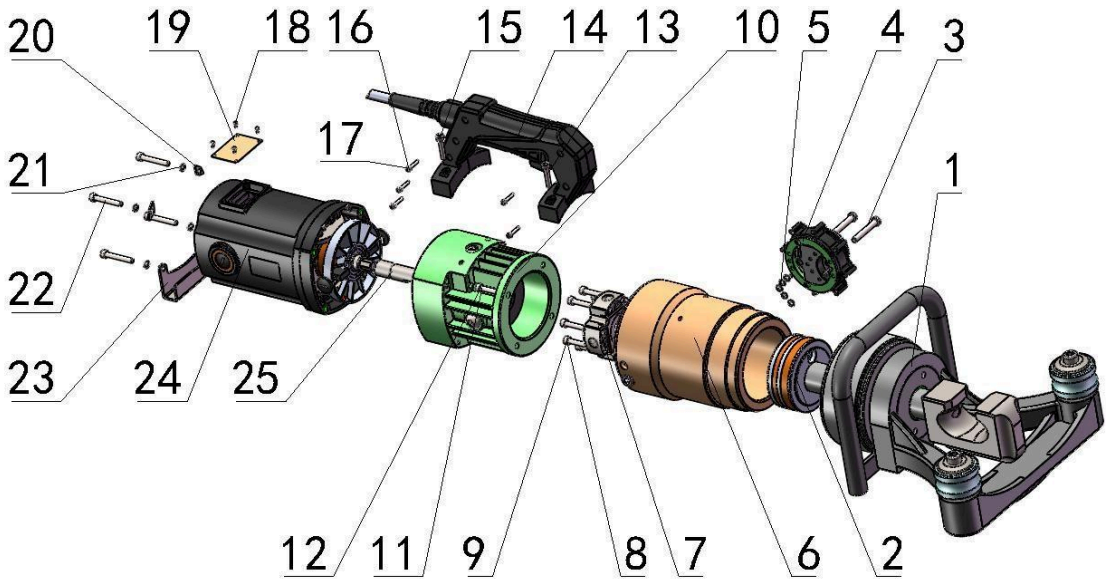
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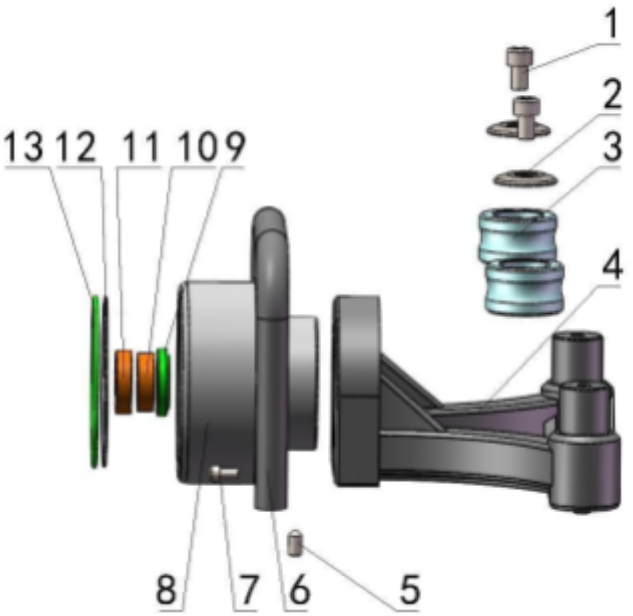
I. Assembly of the Complete Machine



Serial Number	Name	Quantity	Coding
1	Headframe assembly	1	/
2	Pushshaft assembly	1	/
3	Hex socket head cap screws	2	24010015
4	Reversing valve assembly	1	/
5	O-ring	5	25010007
6	Hydraulic cylinder assembly	1	/
7	Four-pillar assembly	1	/
8	Spring Washer	4	24140001
9	Hex socket head cap screws	8	24010004
10	Aluminum housing assembly	1	*
11	Hex socket head cap screws	4	24010006
12	Spring Washer	4	24140001
13	Hex socket head cap screws	2	24010006
14	Handle assembly	1	1
15	Hex socket head cap screws	2	24010009
16	Hex socket head cap screws	5	24010008
17	flat pad	5	24130003

18	Phillips head pan head self-tapping screws	4	24090013
19	Brushed nameplate	1	27100002
20	Brushed irregular-shaped gasket	2	23180012
21	Spring Washer	4	24140001
22	Hex socket head cap screws	4	24010007
23	Brushed Rear Seat Support	1	23160002
24	Rear shell assembly	1	/
25	Eccentric shaft	1	23040002

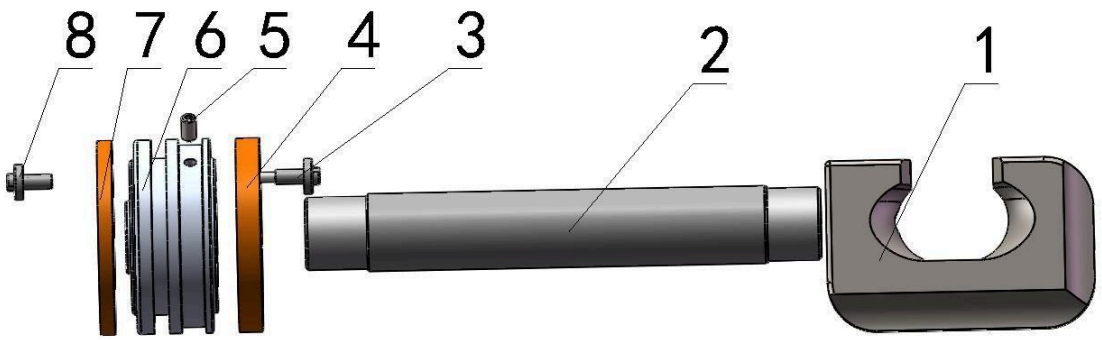
II. Headframe Assembly



Serial Number	Name	Quantity	Coding
1	Hex socket head cap screws	2	24010066
2	Universal guide wheel pressure plate	2	23180022
3	Guide wheel	2	23170023
4	Bending machine support	1	23070030
5	Hex socket set screw	1	24070006
6	Bending machine handle	1	23100024

7	Hex socket head cap screws	2	24010013
8	Bending machine oil cylinder front cover	1	23140042
9	Dust ring	1	25050012
10	bakelite support ring	1	25090003
11	Lip seal	1	25020030
12	PTFE retaining ring	1	25070002
13	O-ring	1	25010083

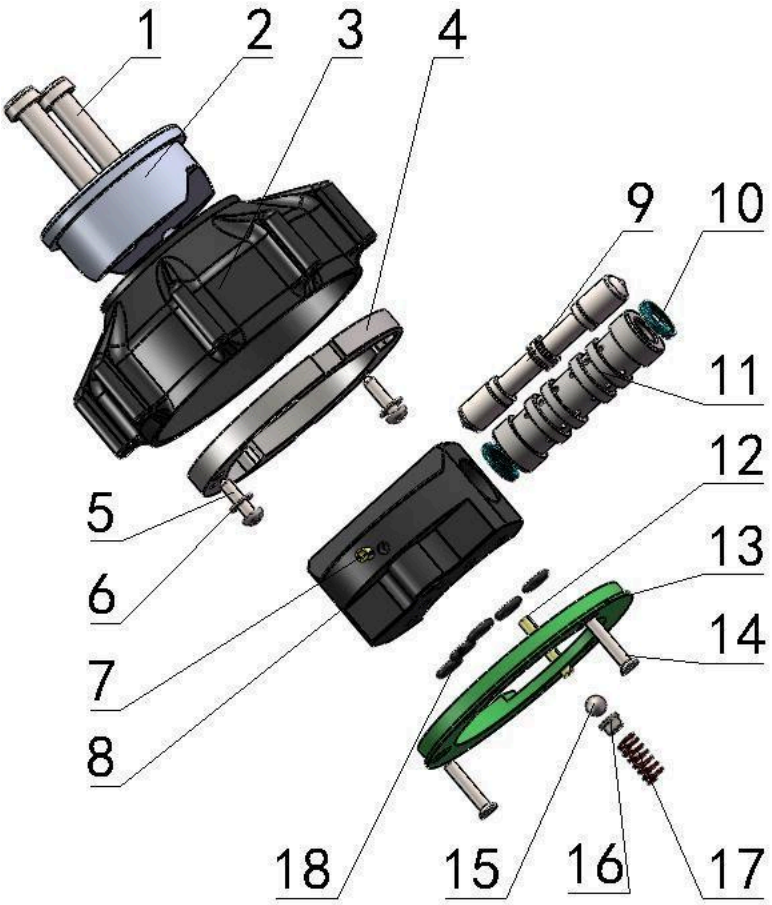
III. Push-shaft assembly



Serial Number	Name	Quantity	Coding
1	Bending machine hook	1	23070014
2	Brushed piston shaft of bending machine	1	23040041
3	Public pressure relief return shaft	1	23040076
4	Bakelite support ring	1	25090009
5	Hex socket set screw		24070002
6	Brushed piston bending machine	1	23040040

7	Glyd seal ring	1	25030001
8	Mother pressure relief return shaft	1	23040077

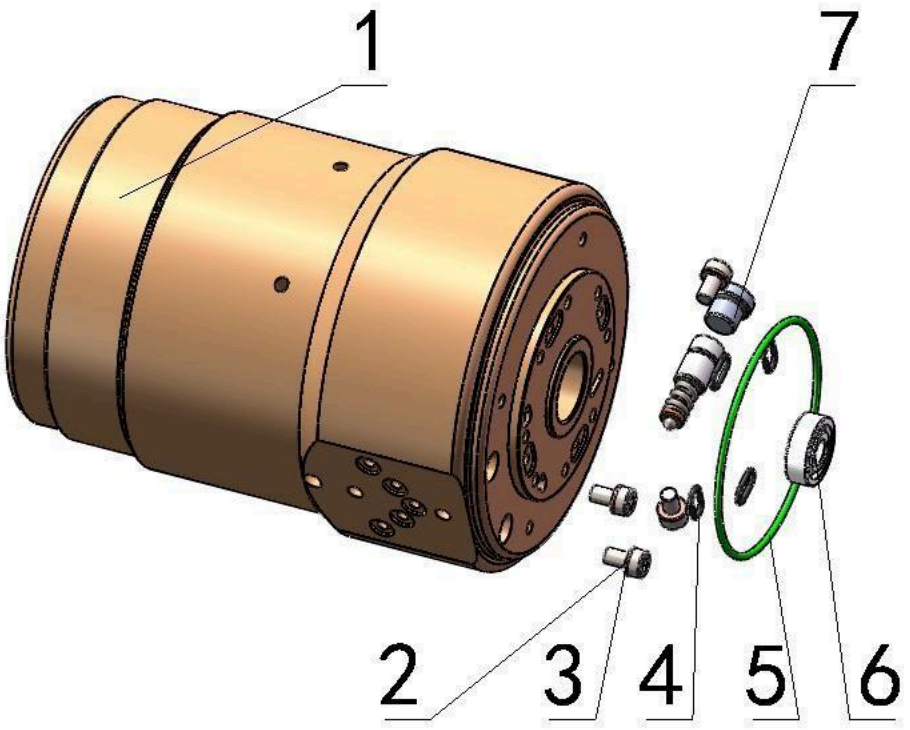
IV. Assembly of Type A Reversing Valve on Bending Machine



Serial Number	Name	Quantity	Coding
1	Hex socket head cap screws	2	24010015
2	Bending machine with manual brush reversing Valve assembly mounting block	1	23180039
3	Star-shaped handwheel handle	1	23100029
4	Dual-plunger directional valve retaining ring	1	23170013
5	Phillips head pan head self-tapping screws	2	24090003
6	flat pad	2	24130003
7	Flexible cylindrical pin	1	23150018
8	Type A directional valve body	1	23050023
9	AB type reversing valve core	1	23050045
10	Star-shaped seal	2	25040004
11	AB type reversing valve sleeve	1	23050046
12	Flexible cylindrical pin	1	23150017
13	Bending machine with manual brush reversing Universal Valve Positioning Disc	1	23170014
14	Phillips head countersunk screws	2	24040006
15	steel balls	1	23050009
16	Pressure holding spring seat	1	23160013
17	Compression spring	1	23130037
18	O-ring	5	25010007

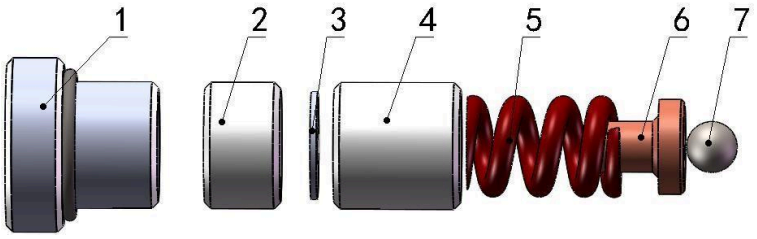
V. Hydraulic Cylinder Assembly

5.1 Hydraulic Cylinder Assembly



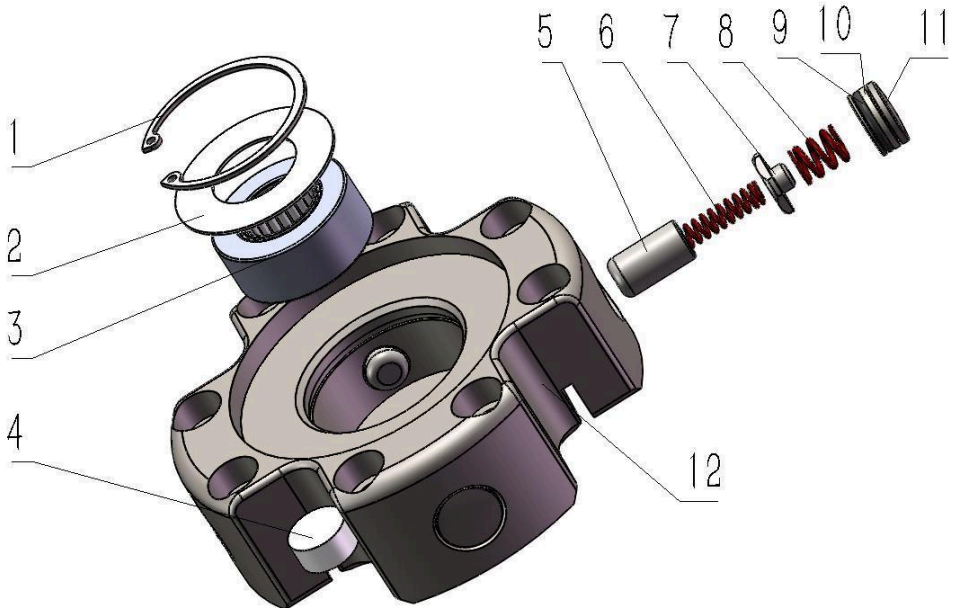
Serial Number	Name	Quantity	Coding
1	Bending machine oil cylinder	1	23030021
2	Hex socket head cap screws	4	24010032
3	Flat washer (copper)	4	24130005
4	O-ring	4	25010002
5	O-ring	1	25010001
6	Deep groove ball bearings	1	608
7	Pressure regulating valve assembly	1	/

5.2 Pressure regulating valve assembly



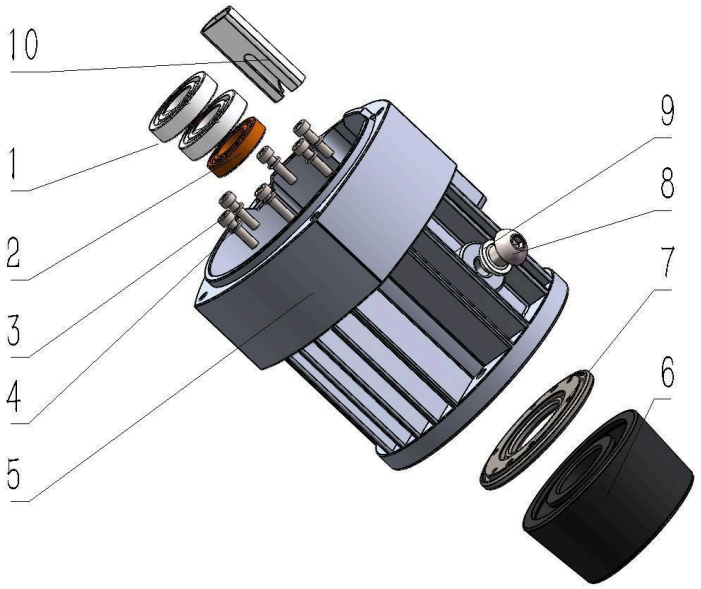
Serial Number	Name	Qty	Coding
1	Internal hexagonal ED ring sealing plug	1	25100001
2	Hex socket set screw	1	24060014
3	flat pad	1	24130003
4	Hex socket set screw	1	24060015
5	Compression spring	1	23130011
6	Spring of pressure regulating valve assembly for cutting machine	1	23160006
7	steel balls	1	23050010

VI. Four-plunger assembly



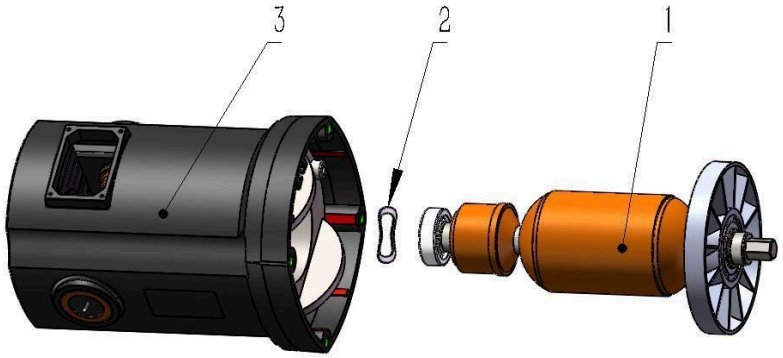
Sequence Number	Product Name	Quantity	Product Code
1	Hole retaining ring	1	24160001
2	Four-plunger assembly wear plates	1	23180003
3	needle roller bearings	1	26030001
4	Magnetic pin	2	23150001
5	Four-plunger assembly plunger	4	23020001
6	Compression spring	4	23130004
7	Four-plunger assembly, plunger one-way valve plate	4	23180002
8	Compression spring	4	23130005
9	O-ring	4	25010002
10	PTFE retaining ring	4	25070001
11	Four-plunger assembly plunger cap	4	23140004
12	Four-plunger pump body	1	23010001

VII. General-purpose aluminum housing assembly



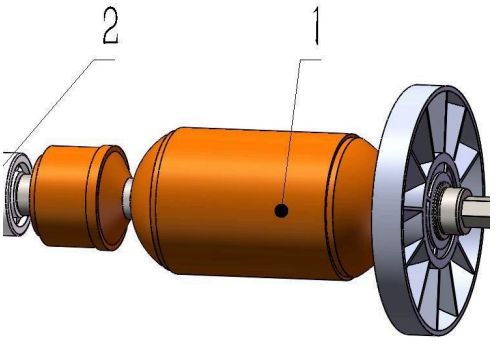
Serial Number	Product Name	Quantity	Product Code
1	Deep groove ball bearings	2	26010002
2	skeleton oil seal	1	25060001
3	Hex socket head cap screws	6	24010005
4	Spring Washer	6	24140002
5	Universal aluminum casing (split type)	1	23120001
6	Brushed Circular Oil Bag	1	23090001
7	Brushed Annular Oil Bag Pressure Plate	1	23180004
8	Hex socket head cap screws	1	24030010
9	Combination gasket (full enclosure)	1	25080009
10	Universal aluminum shell power cord support and protective sleeve	1	23170003

VIII. Rear Sheet Assembly



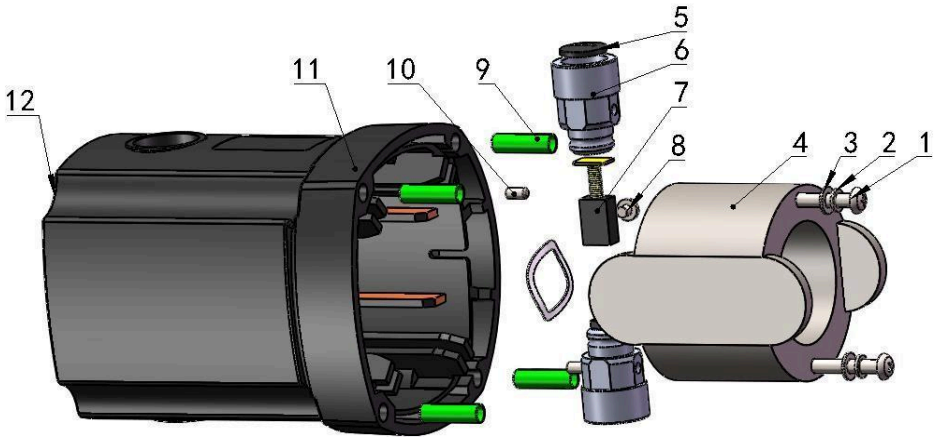
Serial Number	Name	Quantity	Coding
1	1.8kW Rotor Assembly	1	22040003
2	Wave-shaped gasket	1	24990005
3	1.8kW stator assembly	1	22040008

8.1 1.8kW Rotor Assembly



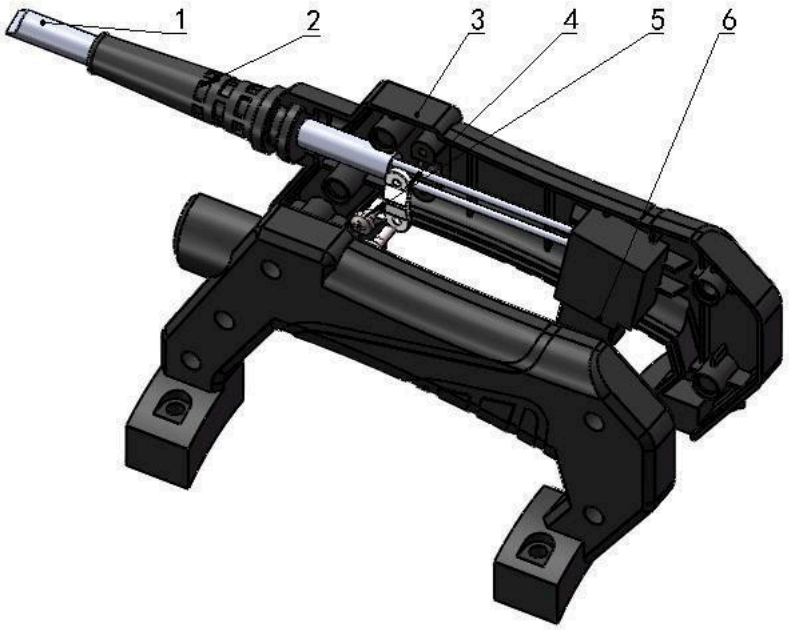
Serial Number	Name	Quantity	Coding
1	1.8KW motor rotor (split unit)	1	23060004
2	Deep groove ball bearings	1	26010020

8.2 1.8kw stator assembly



Serial Number	Name	Quantity	Coding
1	Socket head cap screw (partial thread)	2	24010035
2	Spring Washer	2	24140001
3	Flat washer (copper)	2	24130001
4	1.8KW motor stator	1	23060005
5	Brush holder cap	2	23140007
6	Brushed carbon brush holder	2	23160004
7	carbon brush	1	23190002
8	Phillips head pan screws	2	24050001
9	Flexible cylindrical pin (non-standard)	4	23150010
10	Hex socket set screw	2	24070001
11	Universal plastic back cover	1	23120006
12	rubber stopper	1	23150007

IX. Handle Assembly



Serial Number	Name	Quantity	Coding
1	Universal rubber power cord	1	23210001
2	1.8KW power cord with rubber sheath	1	23170005
3	Plastic handle	1	23100004
4	Power cord fixing plate	1	23180006
5	Phillips head pan head self-tapping screws	2	24090001
6	Universal push button switch	1	23200001