

# RMT

# — GABRO

Hilton Road  
Cobbs Wood Industrial Estate  
Ashford Kent TN23 1EW  
Manufacturers of sheet metal and woodworking machinery

## R.M.T.

INSTRUCTION MANUAL

PNEUMATIC PRESS BRAKE

2 ft. — 4 ft. — 5 ft.

SPARES LIST

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**RMT - GABRO LTD**

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Cobbs Wood Industrial Estate  
Ashford Kent TN23 1EW  
Telephone: (0233) 628976 Fax: 0233 643534

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**MJALLEN** GROUP COMPANY

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Telephone: Ashford (01233) 628976 Fax: (01233) 643534

## RECEIVING AND INSTALLATION

### ITEM 1.

Handle with care. Machines mounted on support table are top heavy. Remove skid by lifting machine from top with a sling and spreader bar to prevent strain on housings. Support table may be damaged if lift truck forks are inserted.

Securely fasten machine to a level floor or table through bolt holes in base.

Prior to use, clean machine and lightly oil exposed metal surfaces. Check and tighten all screws and bolts which may loosen during transportation and handling.

### ITEM 2.

#### AIR LINE CONNECTION

A 1/2" Filter, Lubricator, Regulator is supplied mounted on right hand side of machine. This is fitted with a shut off valve. When this is slid to down position, this exhausts all air from machine. When it is slid to up position, this activates the machine. When the machine is not in use shut off air pressure.

Main air supply line should be 1/2" inside diameter to provide unrestricted flow.

Regulate Air Pressure 80 PSI 6.5 SQC

ITEM 3      OPERATING CONTROLS

Ram movement is controlled with foot valve. The ram may be advanced slowly, stopped or retracted at any point in the stroke. The speed control valve mounted on the back of the machine is preset at the factory so that ram speed does not exceed 30mm per second maximum. The ram speed may also be slowed by adjusting speed control valve. Premature release of foot pedal may cause bending variations.

ITEM 4      TOOLING

Only tools supplied by the manufacturer or the manufacturers representative or a reputable supplier to be used on the machine. Each machine is fitted with a punch and four way die. Other standard press brake dies may also be used with the machine. Align the bottom die with the adjustment and clamps or the set screws which grip the lower die adaptor when using extra high box forming punches, remove lower die holder and place four way die directly on bed to increase available die space. Maximum gap after adjustment must not exceed 6 m/m.

ITEM 5      STROKE LENGTH ADJUSTMENT

The ram travel is limited by adjusting screw and stop tube. Turn handle counter clockwise to reduce the stroke length. Lock securely with lever. Short stroke can speed production and reduce air consumption.

Punching applications require careful adjustment to reduce shock when punches break through. Adjust screw to stop ram travel as soon as punching is completed. Limit punching tonnage to 5 tons maximum.

ITEM 6      BED ADJUSTMENT

Bed rests on adjustment screws and is fastened to side frame with bolts and end clamps. Full range of adjustment requires repositioning end bolts in second set of holes in side frame. Centre adjustment bolt which is safety locked must be firmly tightened. Retighten end bolts and clamps after each adjustment. Maximum gap after adjustment must not exceed 6 m/m.



RECOMMENDED LUBRICANTS

ALL GREASE POINTS:

MOBIL GREASE SPECIAL  
PNEUMATIC SYSTEM  
GARGOYLE ARTICLIGHT OIL

THESE ARE MOBIL OIL COMPANIES PRODUCTS, BUT ANY EQUIVALENT  
MANUFACTURERS PRODUCTS CAN BE USED.

ITEM 13. NOISE LEVELS - ALL MACHINES

PEAK NOISE LEVEL WHEN MACHINE EXHAUSTING - 85 dB

ITEM 20. HAZARD AREAS

These are anywhere near top punch and bottom die and  
also near rear cylinders and stroke adjustment screw  
when machine is being operated.

MISUSE

This press brake must only be used for their intended  
purpose. Incorrect use may result in damage to machine  
and tooling or injury to operators.

B312 3 FOOT PARTS LIST

B312 4 FOOT PARTS LIST

B312 2 FOOT PARTS LIST

ITEM	PART N°	N° OFF	DESCRIPTION
1	PB501	2	MAIN BODY ASSEMBLY
2	PB502	2	SIDE PLATE
3	PB503	1	COUNTER WEIGHT ASSEMBLY
4	PB504	1	FRAME ANGLE SPACER FRONT
5	PB505	1	FRAME ANGLE SPACER REAR
6	PB506	16	FRAME CLAMPING SCREWS
7	PB507	1	TIE BAR
8	PB508	2	TIE BAR CLAMPING SCREWS
9	PB509	1	BED
10	PB510	1	BED SAFETY NUT
11	PB511	1	BED SAFETY WASHER
12	PB512	2	BED CLAMPING ANGLE
13	PB513	2	BED CLAMP SCREWS
14	PB514	2	BED JACKING SCREW
15	PB515	1	DIE HOLDER PLUS 15 OFF SCREWS
16	PB516	2	DIE CLAMP
17	PB517	2	DIE CLAMP SCREWS
18	PB518	8	DIE CENTRALISING BLOCK
19	PB519	16	DIE CENTRALISING BLOCK SCREWS
20	PB520	8	DIE CENTRALISING BLOCK ADJ SCREWS
21	PB521	2	DIE GUARD
22	PB522	4	DIE GUARD SCREWS
23	PB523	1	RAM
24	PB524	4	RAM LINK
25	PB525	2	RAM LINK PIN
26	PB526	2	RAM LINK PIN RETAINING SCREW
27	PB527	2	RAM LINK SHOULDER BOLT
28	PB528	4	RAM LINK SHOULDER BOLT LOCK NUT
29	PB529	2	GIB STRIP BRACKET
30	PB530	2	GIB STRIP BRACKET CLAMP
31	PB531	4	GIB STRIP BRACKET CLAMP SCREWS
32	PB532	4	GIB STRIP ADJUSTING SCREWS
33	PB533	4	GIB STRIP ADJUSTING SCREW LOCK NUT
34	PB534	2	GIB STRIP FRONT
35	PB535	2	GIB STRIP REAR
36	PB536	4	GIB STRIP FIXING DOWEL FRONT
37	PB537	4	GIB STRIP FIXING DOWEL REAR
38	PB538	30	TOOLING LOCKING SCREWS
39	PB539	2	BENDING BACK STOP SLIDE
40	PB540	2	BENDING BACK STOP SLIDE SCREW
41	PB541	2	BENDING BACK STOP PILLAR
42	PB542	2	BENDING BACK STOP INSERT
43	PB543	2	BENDING BACK STOP STUD
44	PB544	2	BENDING BACK STOP KNOB
45	PB545	2	BENDING BACK STOP WASHER (L)
46	PB546	2	BENDING BACK STOP SCREW
47	PB547	1	BENDING BACK STOP
48	PB548	2	BENDING BACK STOP ANGLE
49	PB549	2	BENDING BACK STOP ANGLE WASHER
50	PB550	2	BENDING BACK STOP ANGLE SCREW
51	PB551	2	CYLINDER TUBE
52	PB552	2	CYLINDER SEAL
53	PB553	2	CYLINDER BUFFER PLATE
54	PB554	8	CYLINDER BUFFER
55	PB555	2	CYLINDER PUSH ROD TUBE
56	PB556	2	CYLINDER PUSH ROD
57	PB557	2	CYLINDER WIPER
58	PB558	4	CYLINDER CIRCLIP
59	PB559	2	CYLINDER PIVOT PIN
60	PB560	2	CYLINDER PIVOT PIN FIXING SCREW
61	PB561	8	CYLINDER FIXING SCREWS
62	PB562	1	ANCHOR PIN
63	PB563	2	ANCHOR PIN CIRCLIPS
64	PB564	1	STROKE ADJUSTER BODY
65	PB565	1	STROKE ADJUSTER SCREW
66	PB566	1	STROKE ADJUSTER SCREW NUT
67	PB567	2	MOUNTING BRACKET
68	PB568	4	MOUNTING BRACKET FIXING SCREW
69	PB569	1	SPACER TUBE
70	PB570	1	LOCKING LEVER WITH KNOB
71	PB571	1	HANDLE

ITEM	PART N°	N° OFF	DESCRIPTION
1	PB401	2	MAIN BODY ASSEMBLY
2	PB402	2	SIDE PLATES
3	PB403	1	COUNTER WEIGHT ASSEMBLY
4	PB404	1	FRAME ANGLE SPACER FRONT
5	PB405	1	FRAME ANGLE SPACER REAR
6	PB406	16	FRAME CLAMPING SCREWS
7	PB407	1	TIE BAR
8	PB408	2	TIE BAR CLAMPING SCREW
9	PB409	1	BED
10	PB410	1	BED SAFETY NUT
11	PB411	1	BED SAFETY WASHER
12	PB412	2	BED CLAMPING ANGLE
13	PB413	2	BED CLAMP SCREWS
14	PB414	2	BED JACKING SCREWS
15	PB415	1	DIE HOLDER PLUS 12 OFF SCREWS
16	PB416	2	DIE CLAMP
17	PB417	2	DIE CLAMP SCREWS
18	PB418	8	DIE CENTRALISING BLOCK
19	PB419	16	DIE CENTRALISING BLOCK SCREWS
20	PB420	8	DIE CENTRALISING BLOCK ADJ SCREW
21	PB421	2	DIE GUARD
22	PB422	4	DIE GUARD SCREWS
23	PB423	1	RAM
24	PB424	4	RAM LINK
25	PB425	2	RAM LINK PIN
26	PB426	2	RAM LINK PIN RETAINING SCREW
27	PB427	2	RAM LINK SHOULDER BOLT
28	PB428	4	RAM LINK SHOULDER BOLT LOCK NUT
29	PB429	2	GIB STRIP BRACKET
30	PB430	2	GIB STRIP BRACKET CLAMP
31	PB431	4	GIB STRIP BRACKET CLAMP SCREW
32	PB432	4	GIB STRIP ADJUSTING SCREW
33	PB433	4	GIB STRIP ADJUSTING SCREW LOCK NUT
34	PB434	2	GIB STRIP FRONT
35	PB435	2	GIB STRIP REAR
36	PB436	4	GIB STRIP FIXING DOWEL FRONT
37	PB437	4	GIB STRIP FIXING DOWEL REAR
38	PB438	24	TOOLING LOCKING SCREW
39	PB439	2	BENDING BACK STOP SLIDE
40	PB440	2	BENDING BACK STOP SLIDE SCREW
41	PB441	2	BENDING BACK STOP PILLAR
42	PB442	2	BENDING BACK STOP INSERT
43	PB443	2	BENDING BACK STOP STUD
44	PB444	2	BENDING BACK STOP KNOB
45	PB445	2	BENDING BACK STOP WASHER (L)
46	PB446	2	BENDING BACK STOP SCREW
47	PB447	1	BENDING BACK STOP
48	PB448	2	BENDING BACK STOP ANGLE
49	PB449	2	BENDING BACK STOP ANGLE WASHER
50	PB450	2	BENDING BACK STOP ANGLE SCREW
51	PB451	2	CYLINDER TUBE
52	PB452	2	CYLINDER SEAL
53	PB453	2	CYLINDER BUFFER PLATE
54	PB454	8	CYLINDER BUFFER
55	PB455	2	CYLINDER PUSH ROD TUBE
56	PB456	2	CYLINDER PUSH ROD
57	PB457	2	CYLINDER WIPER
58	PB458	4	CYLINDER CIRCLIP
59	PB459	2	CYLINDER PIVOT PIN
60	PB460	2	CYLINDER PIVOT PIN FIXING SCREW
61	PB461	8	CYLINDER FIXING SCREW
62	PB462	1	ANCHOR PIN
63	PB463	2	ANCHOR PIN CIRCLIPS
64	PB464	1	STROKE ADJUSTER BODY
65	PB465	1	STROKE ADJUSTER SCREW
66	PB466	1	STROKE ADJUSTER SCREW NUT
67	PB467	2	MOUNTING BRACKET
68	PB468	4	MOUNTING BRACKET FIXING SCREW
69	PB469	1	SPACER TUBE
70	PB470	1	LOCKING LEVER WITH KNOB
71	PB471	1	HANDLE

ITEM	PART N°	N° OFF	DESCRIPTION
1	PB201	2	MAIN BODY ASSEMBLY
2	PB202	2	SIDE PLATE
3	PB203	1	COUNTER WEIGHT ASSEMBLY
4	PB204	1	FRAME ANGLE SPACER FRONT
5	PB205	1	FRAME ANGLE SPACER REAR
6	PB206	16	FRAME CLAMPING SCREW
7	PB207	1	TIE BAR
8	PB208	2	TIE BAR CLAMPING SCREW
9	PB209	1	BED
10	PB210	1	BED SAFETY NUT
11	PB211	1	BED SAFETY WASHER
12	PB212	2	BED CLAMPING ANGLE
13	PB213	2	BED CLAMP SCREW
14	PB214	2	BED JACKING SCREW
15	PB215	1	DIE HOLDER PLUS 6 OFF SCREWS
16	PB216	2	DIE CLAMP
17	PB217	2	DIE CLAMP SCREW
18	PB218	6	DIE CENTRALISING BLOCK
19	PB219	12	DIE CENTRALISING BLOCK SCREW
20	PB220	6	DIE CENTRALISING BLOCK ADJ SCREW
21	PB221	2	DIE GUARD
22	PB222	4	DIE GUARD SCREW
23	PB223	1	RAM
24	PB224	4	RAM LINK
25	PB225	2	RAM LINK PIN
26	PB226	2	RAM LINK PIN RETAINING SCREW
27	PB227	2	RAM LINK SHOULDER BOLT
28	PB228	4	RAM LINK SHOULDER BOLT LOCK NUT
29	PB229	2	GIB STRIP BRACKET
30	PB230	2	GIB STRIP BRACKET CLAMP
31	PB231	4	GIB STRIP BRACKET CLAMP SCREWS
32	PB232	4	GIB STRIP ADJUSTING SCREW
33	PB233	4	GIB STRIP ADJUSTING SCREW LOCK NUT
34	PB234	2	GIB STRIP FRONT
35	PB235	2	GIB STRIP REAR
36	PB236	4	GIB STRIP FIXING DOWEL FRONT
37	PB237	4	GIB STRIP FIXING DOWEL REAR
38	PB238	12	TOOLING LOCKING SCREW
39	PB239	2	BENDING BACK STOP SLIDE
40	PB240	2	BENDING BACK STOP SLIDE SCREW
41	PB241	2	BENDING BACK STOP PILLAR
42	PB242	2	BENDING BACK STOP INSERT
43	PB243	2	BENDING BACK STOP STUD
44	PB244	2	BENDING BACK STOP KNOB
45	PB245	2	BENDING BACK STOP WASHER (L)
46	PB246	2	BENDING BACK STOP SCREW
47	PB247	1	BENDING BACK STOP
48	PB248	2	BENDING BACK STOP ANGLE
49	PB249	2	BENDING BACK STOP ANGLE WASHER
50	PB250	2	BENDING BACK STOP ANGLE SCREW
51	PB251	2	CYLINDER TUBE
52	PB252	2	CYLINDER SEAL
53	PB253	2	CYLINDER BUFFER PLATE
54	PB254	8	CYLINDER BUFFER
55	PB255	2	CYLINDER PUSH ROD TUBE
56	PB256	2	CYLINDER PUSH ROD
57	PB257	2	CYLINDER WIPER
58	PB258	4	CYLINDER CIRCLIP
59	PB259	2	CYLINDER PIVOT PIN
60	PB260	2	CYLINDER PIVOT PIN FIXING SCREW
61	PB261	8	CYLINDER FIXING SCREW
62	PB262	1	ANCHOR PIN
63	PB263	2	ANCHOR PIN CIRCLIP
64	PB264	1	STROKE ADJUSTER BODY
65	PB265	1	STROKE ADJUSTER SCREW
66	PB266	1	STROKE ADJUSTER SCREW NUT
67	PB267	2	MOUNTING BRACKET
68	PB268	4	MOUNTING BRACKET FIXING SCREW
69	PB269	1	SPACER TUBE
70	PB270	1	LOCKING LEVER WITH KNOB
71	PB271	1	HANDLE

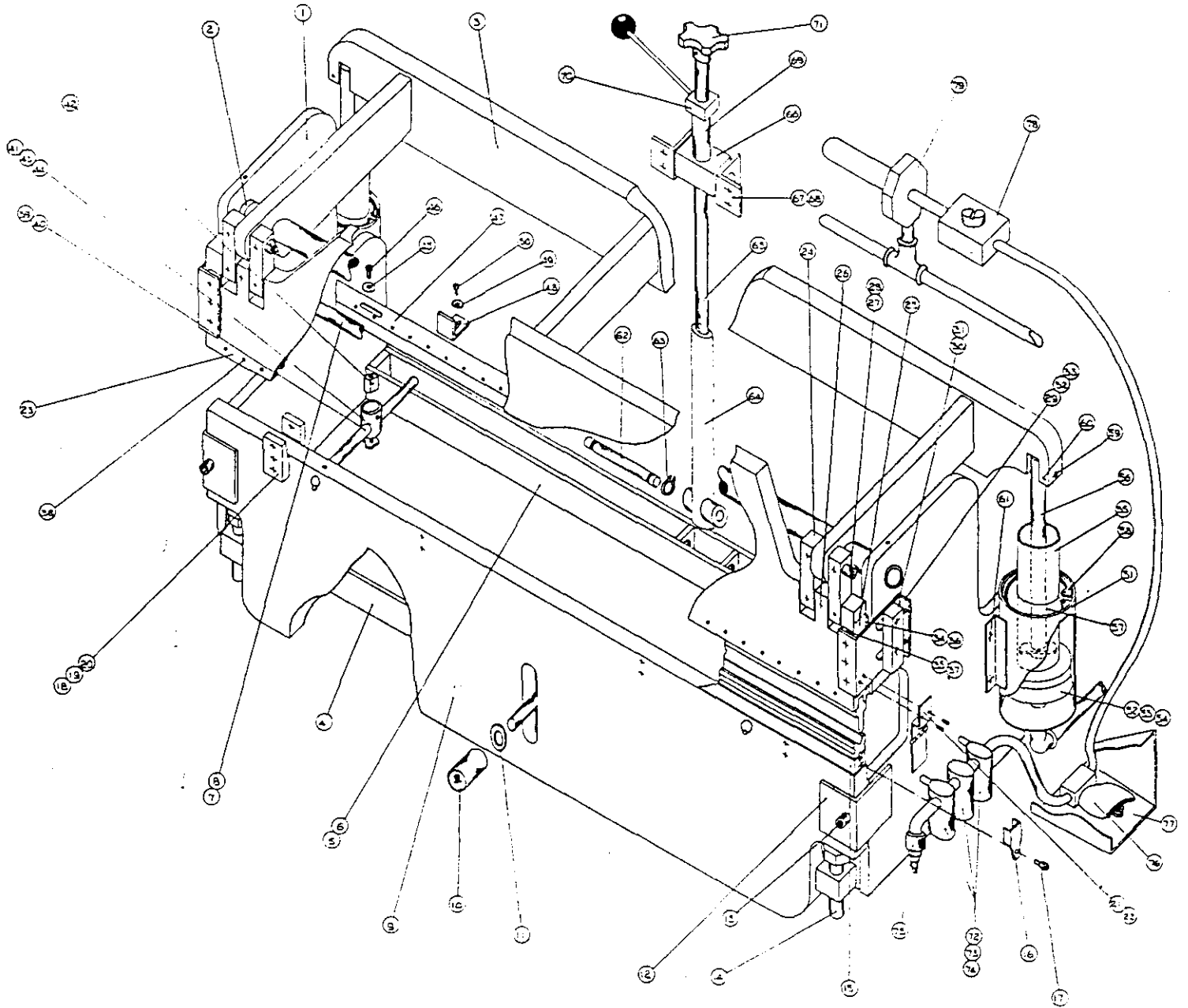
PNEUMATIC ITEMS STANDARD TO ALL MACHINES

72	PB5472	1	FILTER
73	PB5473	1	LUBRICATOR
74	PB5474	1	REGULATOR
75	PB5475	1	SHUT OFF VALVE
76	PB5476	1	FOOT PEDAL
77	PB5477	1	FOOT PEDAL GUARD
78	PB5478	1	SPEED CONTROL
79	PB5479	1	MUFFLER

# RMT - GABRO LTD

Hilton Road  
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 Ashford Kent TN23 1EW  
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RMT  
*Pneumatic Press Brake*  
2 ft. — 4 ft. — 5 ft.  
Exploded View

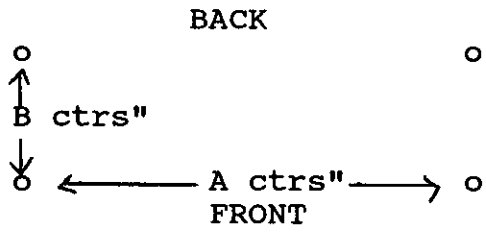


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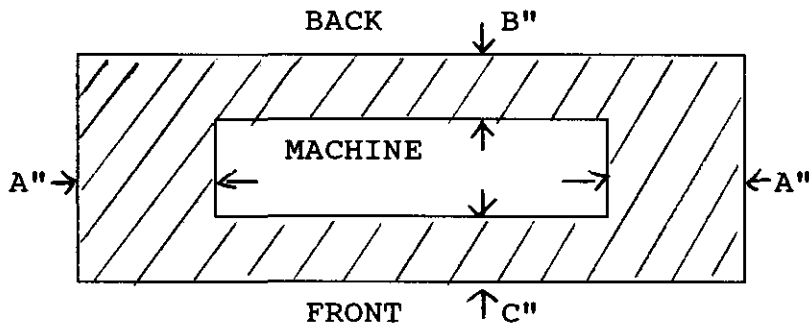
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ITEM 14 FLOOR STAND MOUNTING PLAN



Machine Size	A"	B"
2ft	25-1/2"	14"
4ft	49-1/2"	14"
5ft	61-1/2"	14"
Bolt Size	10 mm	10 mm

ITEM 15 WORKSTATION AREA

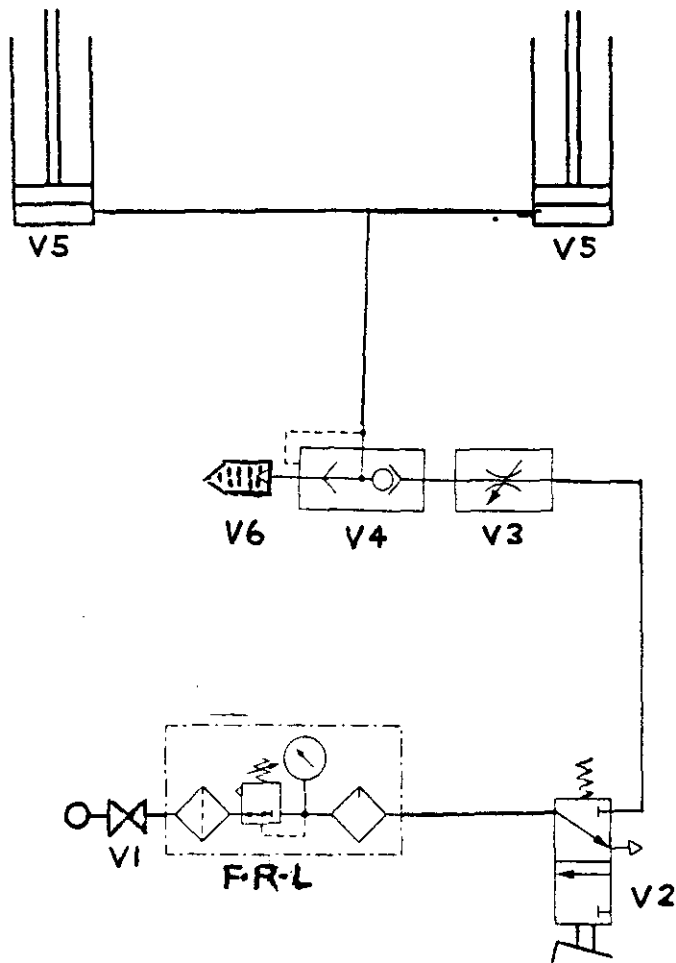


Machine Size	A"	B"	C"
2ft	20"	20"	36"*
4ft	20"	20"	36"*
5ft	20"	20"	36"*

Shipping Weight KG with floor stand	B212 2ft.	B412 4ft.	B512 5ft
	320	544	680

C"\* this size will depend on size of sheet being formed.





RMT-GABRO PRESS BRAKE CIRCUIT DIAGRAM			
REF.	PART NO.	DESCRIPTION	QTY
V1	M7238	SHUT OFF VALVE	1
V2	03068102	FOOT VALVE	1
V3	3250LCB	FLOW CONTROL VALVE	1
V4	3340C	QUICK EXHAUST VALVE	
V5		CYLINDER ASSY PB251A	2
V6	3062B	SILENCER	1
F.R.L.		FILTER, REGULATOR LUBRICATOR	1

**SIGNS &  
LABELS**



**HAZARD  
AREA**

MODEL TYPE \_\_\_\_\_  
SERIAL No. \_\_\_\_\_  
YEAR OF MANUFACTURE \_\_\_\_\_  
MAX. WORKING PRESSURE 80 PSI - 6.5KG SQ. C  
PHASE \_\_\_\_\_ VOLTS \_\_\_\_\_ Hz \_\_\_\_\_  
WEIGHT KGS \_\_\_\_\_  
CE \_\_\_\_\_  
RMT - GABRO LIMITED  
HILTON ROAD, COBBS WOOD INDUSTRIAL  
ESTATE, ASHFORD, KENT. TN23 1EW.  
TELEPHONE: 01233 - 628976  
FAX: 01233 - 664909

## **WARNING!**

**NEVER** place hands under ram or within die area.  
**SHUT-OFF** air pressure when machine is not in use.

# **SAFETY REGULATION:**

# **MAXIMUM GAP 6mm.**

# RMT - GABRO

Hilton Road  
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Ashford Kent TN23 1EW  
Manufacturers of sheet metal and woodworking machinery

C.L. DATE 12/94 ISSUE 1

## RMT-GABRO MACHINE ASSEMBLY CHECK LIST

MACHINE TYPE ..... SERIAL NO .....

### ASSEMBLY

1. CHECK ALL NUTS AND BOLTS ARE TIGHTENED (....)
2. CHECK ALL SEALS AND WASHER ARE SERVICEABLE AND FITTED CORRECTLY (....)
3. CHECK ALL MOVING PARTS MOVE FREELY AND CORRECTLY (....)
4. CHECK ALL BLADES/GRINDING WHEELS ARE OF SERVICEABLE CONDITION AND HAVE RELEVANT GAPS/CLEARANCES, AS STATED IN MACHINE MANUALS (REF..... DATE ..... ISSUE .....)
5. CHECK FOR AIR/OIL LEAKS (....)
6. CHECK MACHINE ACHIEVES SPECIFICATION i.e. TONNAGE, ETC. (REF ..... DATE ..... ISSUE .....)
7. CHECK ALL ADJUSTMENTS ARE FITTED CORRECTLY AND ARE WORKING. (....)
8. CHECK WIRING, MOTORS AND SWITCHGEAR ARE WORKING CORRECTLY. (REF ..... DATE ..... ISSUE .....)
9. CHECK ALL SAFETY GUARDS ARE IN PLACE AND FOR ADJUSTABLE TYPES, MOVE FREELY AND LOCK IN POSITION. (REF ..... DATE ..... ISSUE .....)
10. CHECK ALL NAME PLATE/SERIAL NO./WARNING LABELS AND C.E. MARK ARE ON MACHINE AND CLEARLY VISIBLE. (....)
11. CHECK MACHINE IS PACKED CORRECTLY AND PACKAGING IS MARKED CORRECTLY. (....)

ITEM 19

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**RMT - GABRO LTD.** Reg'd No. 999353 (member of the M.J. Allen Group)

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OPERATING INSTRUCTIONS AND PARTS LIST

RMT PRESS BRAKE

MODEL.....

S/N .....

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**WARNING**

**NEVER PLACE HANDS UNDER RAM OR WITHIN DIE AREA  
SHUT OFF AIR PRESSURE WHEN MACHINE IS NOT IN USE**

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