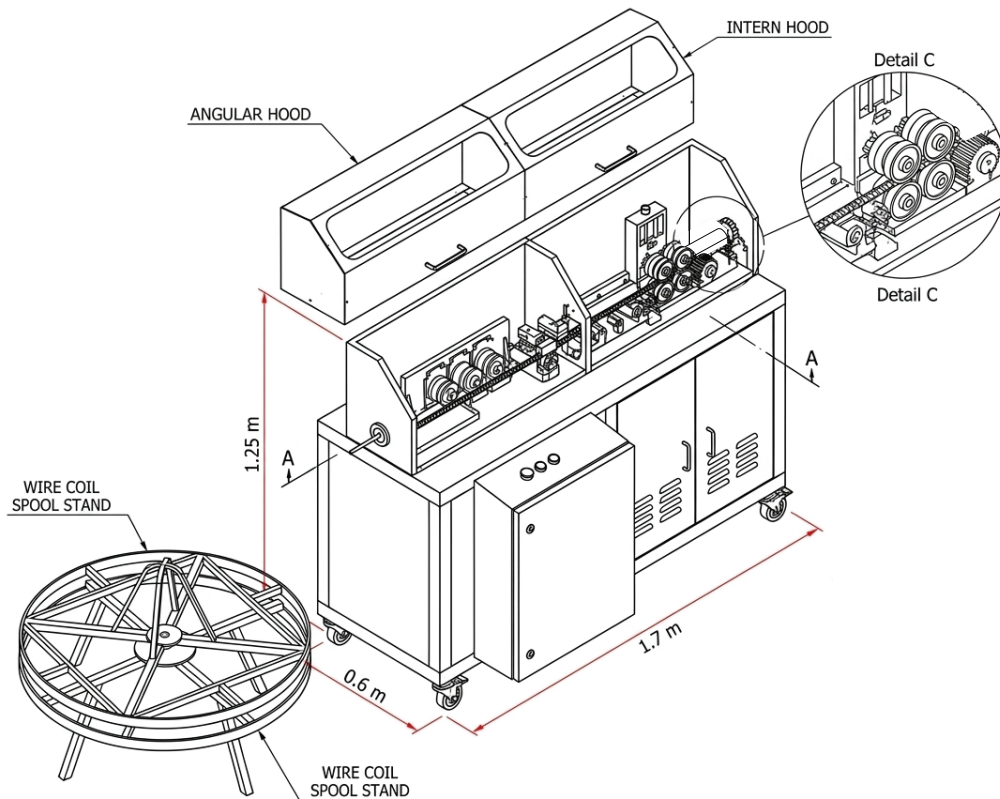


Instruction Manual

Morice Tech Rebar Straightening and Cutting Machine Manual



1. Safety
2. Machine overview & specs
3. Installation
4. Operating instructions
5. Maintenance & troubleshooting
6. Parts list
7. Warranty/support

1. Safety

Safety is the primary priority.

Operating stirrup construction equipment involves high-torque motors and high-pressure hydraulic/pneumatic systems.

- **Personal Protective Equipment (PPE):** Always wear a hard hat, safety goggles, steel-toed boots, and heavy-duty gloves.
- **Emergency Stop:** Familiarize yourself with the Red Emergency Stop button location before powering on the machine.
- **No Loose Clothing:** Do not wear loose clothing, jewelry, or unrestrained long hair near the feeding rollers.
- **Lockout/Tagout (LOTO):** Always disconnect the power supply before performing maintenance or cleaning.
- **Area Clearance:** Maintain a 2-meter safety zone around the wire payoff, feed path, and cutting area during operation.

2. Machine overview & specs

This machine is designed for the straightening and cutting of steel rebar for construction applications.

The rebar passes through the machine body and internal guide/straightening rollers in a straight path.

Once the rebar reaches the stopper switch, the cutting device is triggered automatically to cut the material to the required length.

Technical Specifications

Feature	Specification
Wire Diameter Range	1 bar, #3 or #4
Production Speed	7 seconds per straightening/cutting cycle
Power Consumption	3.75 KW
Control System	Mechanical stopper-switch based control.
Weight	248 Kg + 15 Kg

3. Installation

1: Foundation: Place the machine on a level reinforced concrete floor with a minimum thickness of 150 mm.

2: Leveling: Use a spirit level to ensure the machine frame is perfectly horizontal. Adjust the leveling feet as necessary.

3: Electrical Connection: To connect to a **single-phase 110/220V, 50/60 Hz.**

Ensure proper grounding (earthing) to prevent electrical shock.

4. Wire Payoff Setup: Align the wire decoiler with the machine's intake rollers at a distance of **5 to 8 meters**.

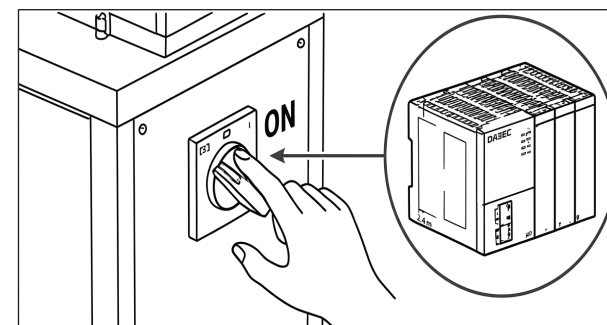
5: Pneumatic/Hydraulic Check: Check oil levels in the reservoir and ensure air lines are connected and leak-free.

4. Operating instructions

Step: 01

Power Up:

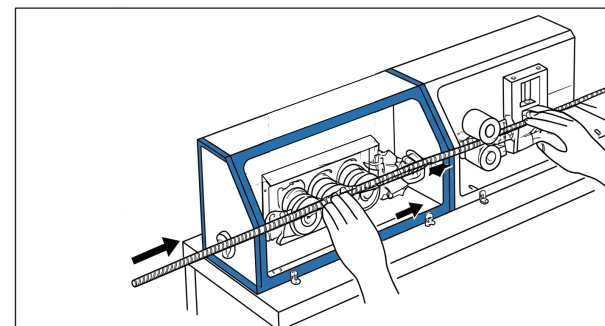
Turn on the main isolator switch and allow the machine to power up fully before operation.



Step: 02

Feed the Rebar:

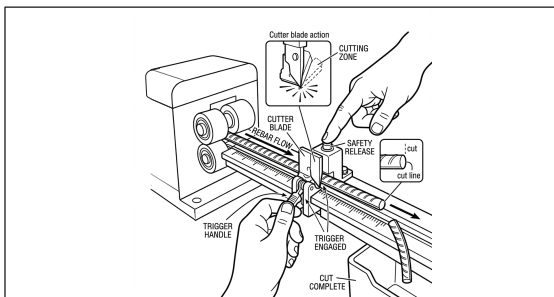
Manually feed the rebar through the machine body and the main internal rollers/guides until it travels straight forward and reaches the stopper switch.



Step: 03

Cutting Trigger Operation

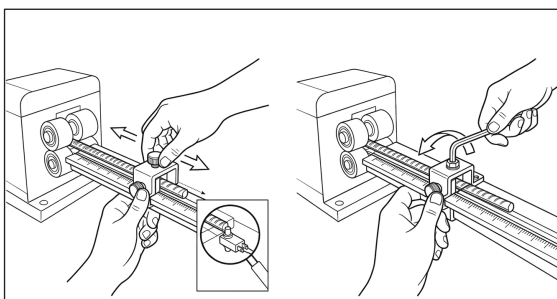
You don't need to enter the length. The rebar passes straight through the machine body and internal rollers until it contacts the stopper switch. Once the stopper switch is engaged, the cutting device is triggered automatically.



Step: 04

Adjust the Cut Length :

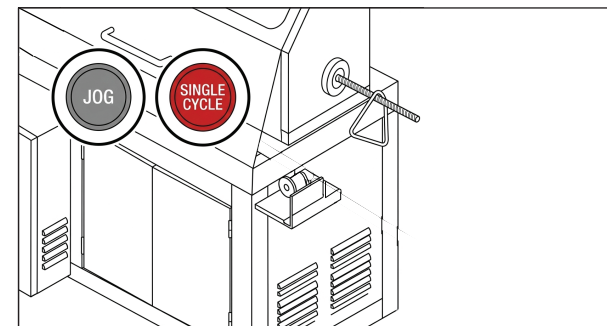
Adjust the required cut length by moving the stopper switch to the desired position based on the dimension needed. After positioning the stopper switch, secure it firmly before operation.



Step: 05

Test Run:

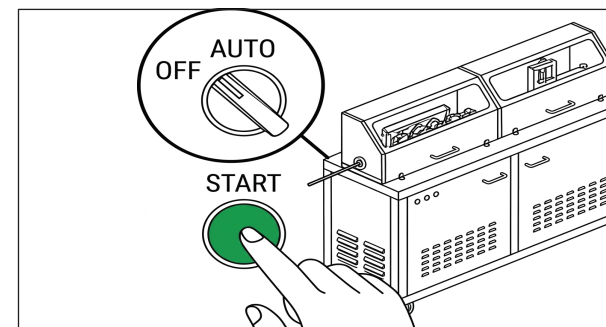
Run one trial cut to verify the actual cut length. Measure the cut piece and fine-adjust the stopper switch if necessary.



Step: 06

Auto Operation:

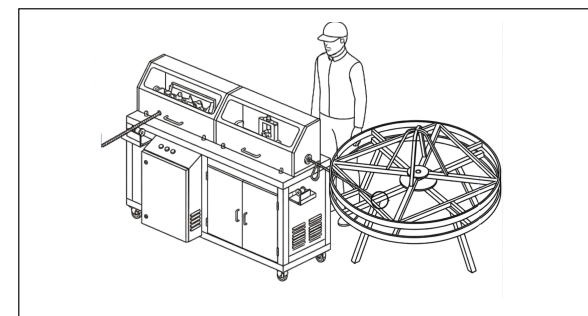
After confirming the correct cut length, start normal machine operation.



Step: 07

Monitoring:

Monitor the rebar feeding path during operation to ensure smooth travel and proper cutting performance. Check that no snagging, obstruction, or misalignment occurs.



5. Maintenance & troubleshooting

Regular Maintenance

Daily:

Clean dust and metal scales from the cutting area, feed rollers, and straightening rollers.

Weekly:

Grease all moving joints and linear guides.

Monthly:

Inspect hydraulic filters and check the tension of drive belts.

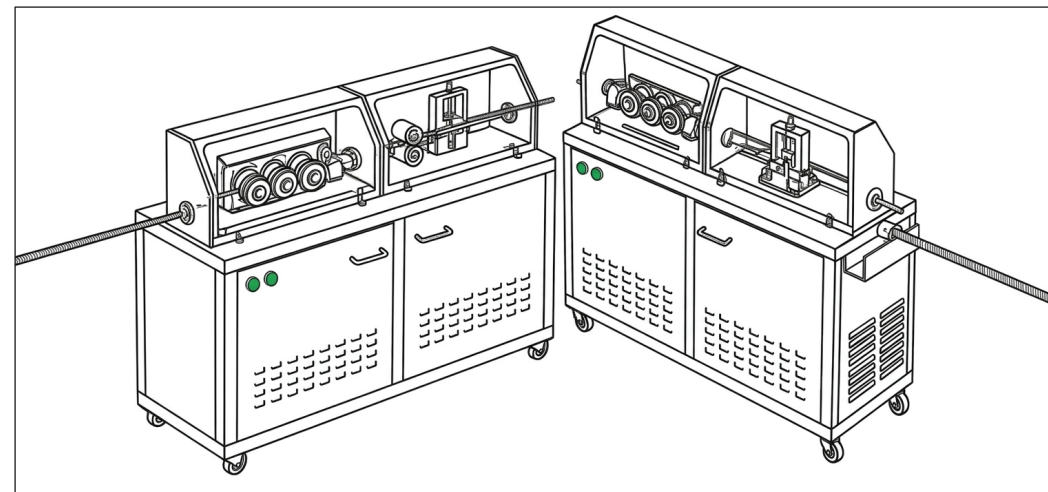
Troubleshooting

Problem	Possible Cause	Solution
Incorrect Cut Length	Mechanical wear/damage to feeding components.	Inspect and repair/replace feeding components.
Rebar Slippage	Feed rollers are worn or pressure is low.	Increase roller pressure or replace rollers.
Machine Won't Start	Emergency stop is engaged or Phase failure.	Release E-stop / Check 3-phase input.
Cut Not Triggering	This problem is highly sensor-dependent. Without specific sensors, this symptom might be difficult to troubleshoot directly with general mechanical advice. It is typically related to the control logic or a primary input signal.	Verify the overall machine state

6. Parts list

- Servo cutting/feeding motor
- Hydraulic solenoid valve block

(Refer to the attached exploded view diagrams in the physical appendix for exact bolt locations and assembly sequences.)



7. Warranty/support

Warranty Info

- **Structural Frame:** 24 Months
- **Electrical/Hydraulic Components:** 12 Months
- **Consumables (Blades/Rollers):** Not covered under standard warranty.

Customer Support

For technical assistance, spare parts ordering, or site visits:

Morice Tech

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Email: mlouiz@motck.com

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