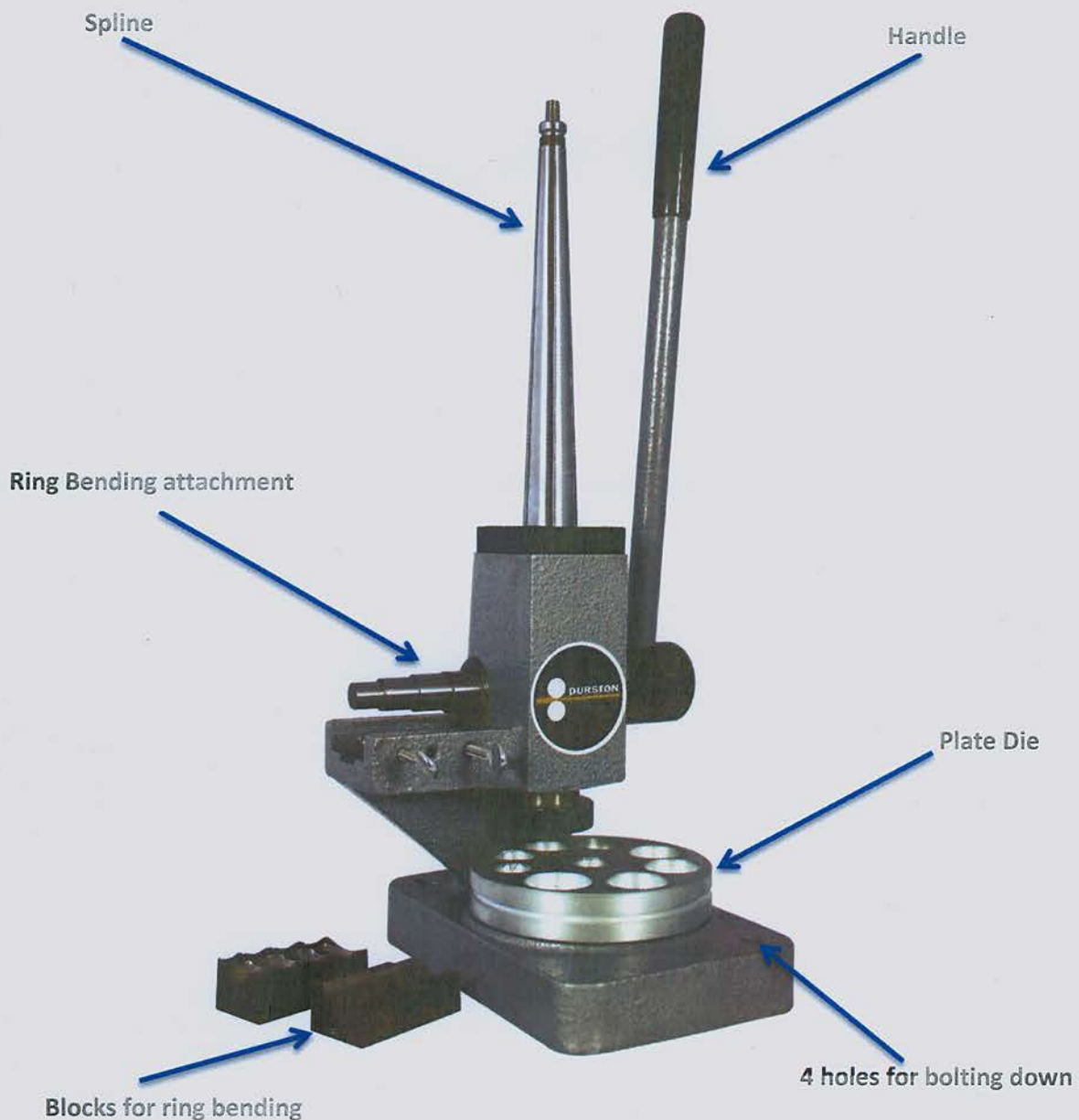


# DURSTON

## Rolling Mills

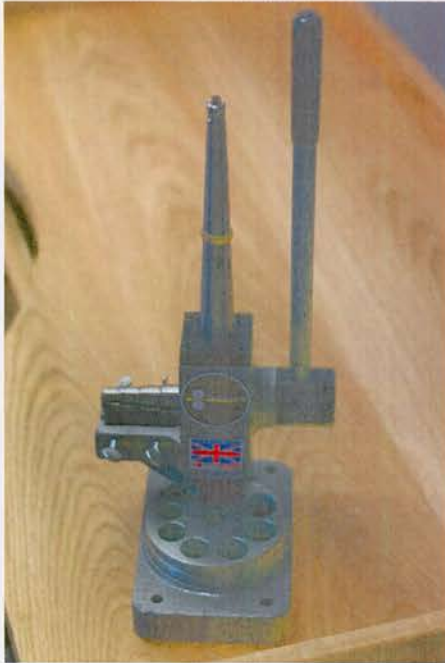
### Durston Ring Stretcher/Reducer/Bender – Instructions

Thank you for choosing your Durston Ring Stretcher, which will give you many years of trouble free and high performance use. Make sure that your Ring Stretcher is securely bolted down. Do not operate until the unit is secure, otherwise injury could occur.



High precision ring stretcher/reducer featuring an 8 spline mandrel and 16 polished countersunk dies. This high quality ring stretcher ensures exceptionally accurate ring sizing. Its countersunk polished steel reducing plate will reduce bands up to 12mm wide. Heavy duty cast iron construction with hardened steel shaft will bend up to 4mm thick includes 2 precision hardened and ground dies.

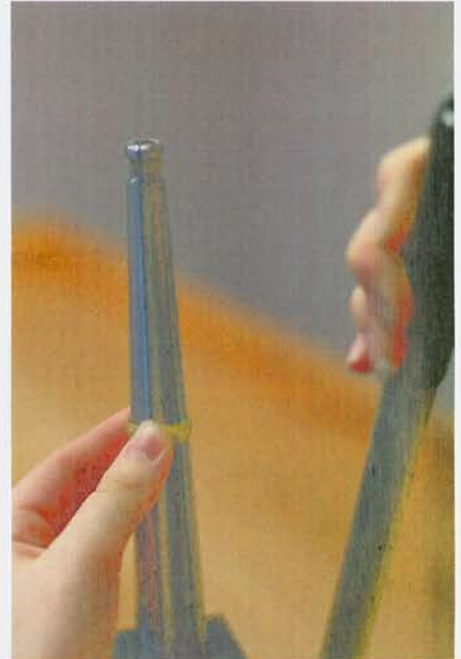
### Enlarging Rings



**1)** Place ring on splines / tapered shaft.



**2)** Gently pull lever towards you. Do not exert too much pressure. Push level back to upright position to take pressure off ring.



**3)** Slowly move lever up and down rotating the ring as you go. After several strokes turn ring around and repeat exercise so that both sides of the ring are stretched evenly.

### Reducing Rings



**1)** Make sure the lever is up right. Place ring in a die which is small than the diameter of the rig. Approximately 20-25% of the ring should stick up above surface.



**2)** Turn round the die plate until under the punch.



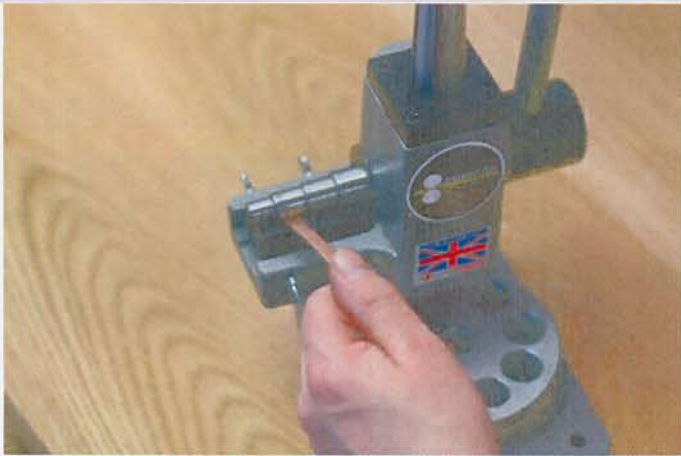
**3)** Slowly move the handle backwards and forwards until ring is flush with top of disc. Now turn ring over and repeat exercise.

**Note,** the reducing guide plate is often scratched on top and bottom, this is where it has been turning and rubbing against the casting, this is quite normal.



## Bending Rings

1) Place your material between the two parts and move the lever. You can make different shapes by moving the lever backwards and forwards the same time as moving your material through the die. You can change the die sets at any time and turn the material around to create different shapes.



## Caution

Please note that if the die plate is removed and the lever is pulled all the way forward, the plunger will fall out of the mesh. If this happens, simply pull the handle towards you (down) so that it is horizontal and push the plunger part up to engage teeth and then slowly lift lever.

Please note that the six splines are assembled in a certain order, so if you remove these, please make sure they are assembled exactly how they came off.