



metal craft™

Wrought Iron Handicrafts, Inc.
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Rochester MN 55901-1336
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800-456-7738 phone
info@metalcraftusa.com email

The ultimate dream machine for fabricators and ornamental metal workers. Complete with lockable flip-flop base (to allow for use in horizontal or upright positions) and measuring bar (for accurate and repeatable punching and shearing).

www.metalcraftusa.com

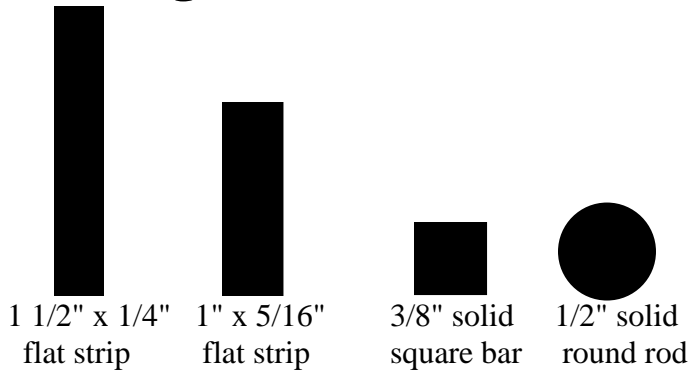
Heavy Duty

Punching

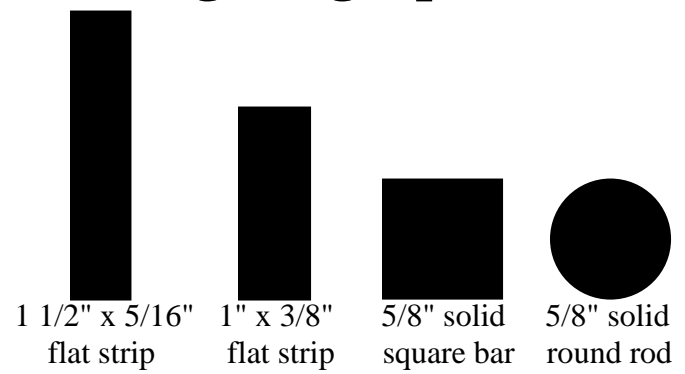
- 3/16" diameter round hole in up to 3/16" thick (flat strip metal).
- 1/4" diameter round hole in up to 1/4" thick (flat strip metal).
- (will do 1/8" diameter round hole in up to 1/8" thick flat strip metal - with optional 1/8" punch block and pin purchased).

SPECIFICATIONS:
Pro XL5+
Metal Bender

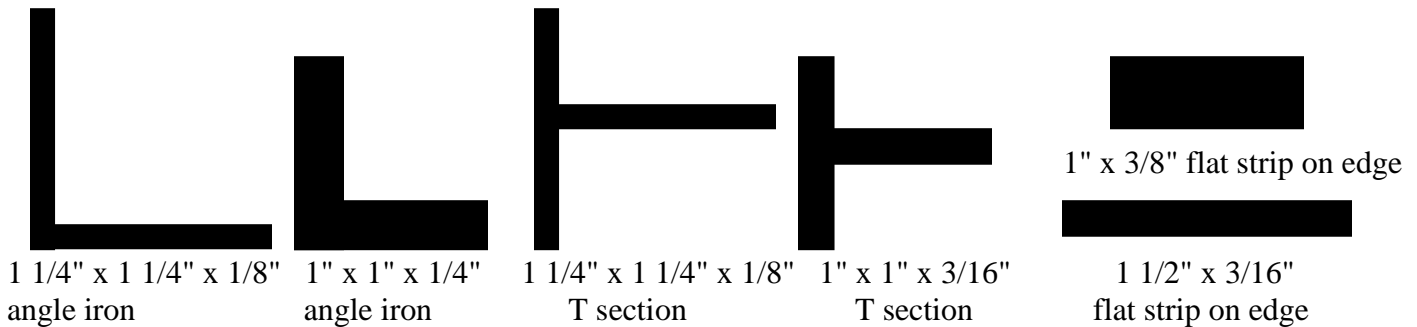
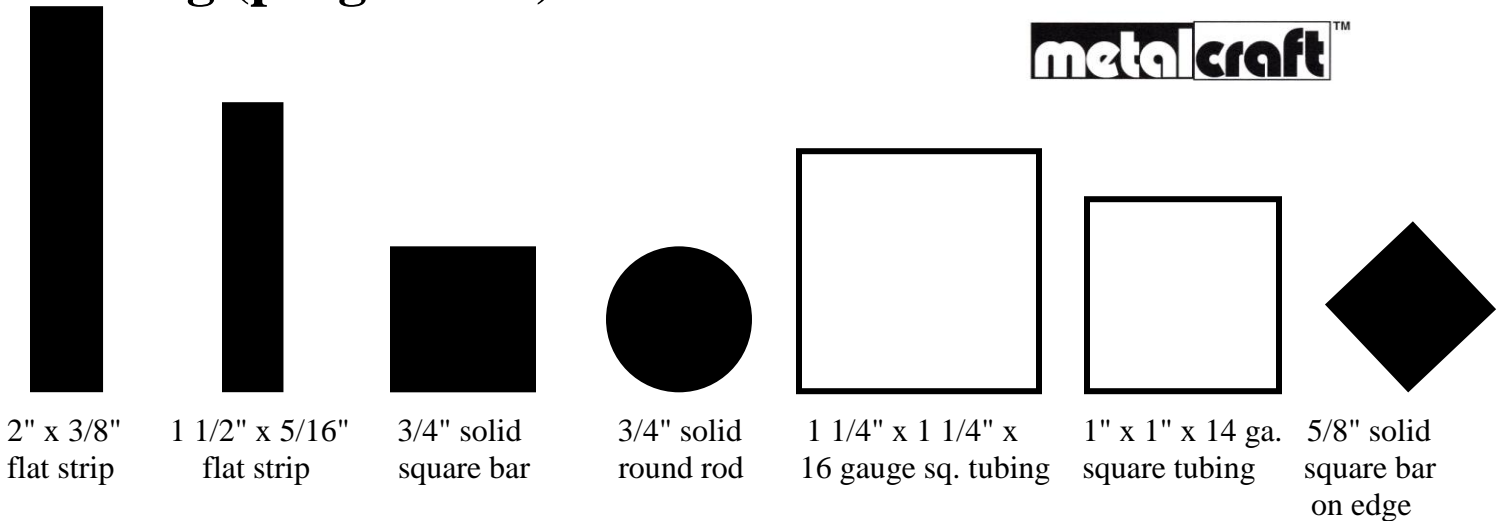
Cutting



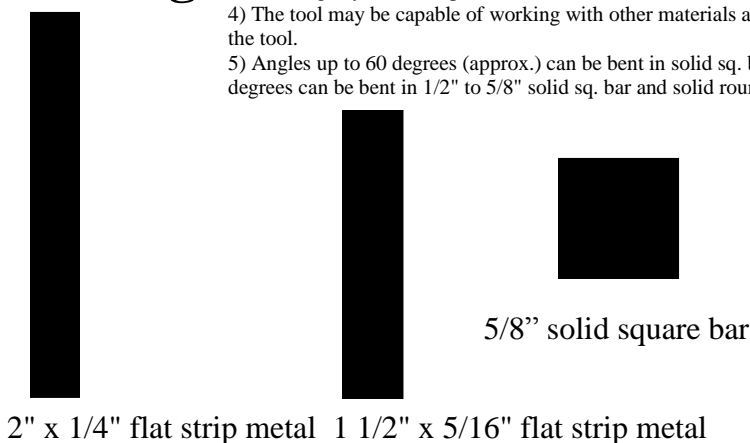
Bending (single pass)



Bending (progressive)



Rolling



- 1) Metal sizes stated are maximum capacity.
- 2) These sizes are for Hot Rolled Mild Steel & Annealed Bright Mild Steel.
- 3) Working beyond the capacities stated or with materials of greater strength or hardness may reduce the operational life of the machine.
- 4) The tool may be capable of working with other materials and/or profiles but exercise care when testing these materials and/or profiles on the tool.
- 5) Angles up to 60 degrees (approx.) can be bent in solid sq. bar and solid round rod – up to 1/2" during single pass bending. Angles of 90 degrees can be bent in 1/2" to 5/8" solid sq. bar and solid round rod.

1/2" solid square bar rolled into 11 1/4" dia. circle.

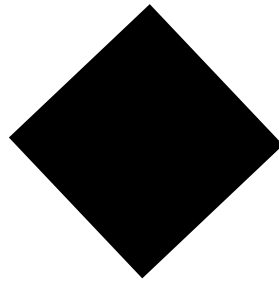


Option1: (recommended) Pedestal for XL5+ Metal Bender

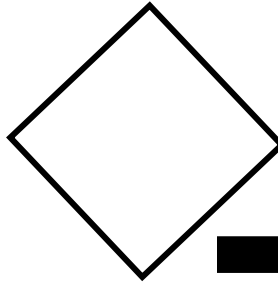


Option2: Embossing & End Forging Kit

Embossing (pointed profile to create V's)



1" x 1"
solid sq. bar

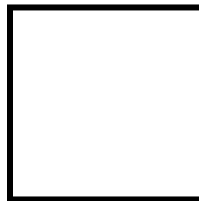


1" x 1" x 16 gauge
hollow sq. tubing



2 3/4" x 3/16"
flat strip metal

Embossing (curved profile to create notches)

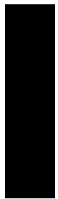


1" x 1" x 16 gauge
hollow square tubing



2 3/4" x 1/8" flat strip metal

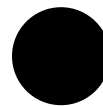
End Forging Small Pattern



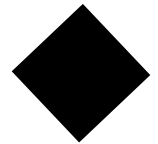
1" wide material before
it is heated & tapered



1/2" solid square bar before
it is heated & tapered

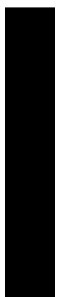


1/2" solid round rod before
it is heated & tapered



1/2" solid square
bar before it is
heated & tapered

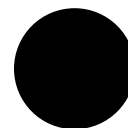
End Forging Large Pattern



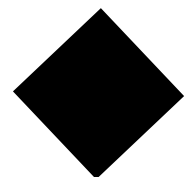
1 1/2" wide material before
is heated & tapered



5/8" solid square bar before
it is heated & tapered



5/8" solid round rod before
it is heated & tapered



5/8" solid sq. bar
on edge before it
is heated & tapered

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Option3: On Edge Bending Kit



1" x 1/8" flat strip metal

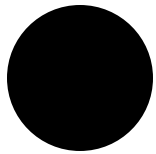


1" x 3/16" flat strip metal

Max sizes stated for Edge Bending are for use with special bending pillar provided. Larger thicknesses up to 3/8" can be bent with care on the standard XL5+ Metal Bender using the single pass bending head but flat strip may need to be heated to maintain a flat bend.

Option4: Tube/Rod Rolling Kit

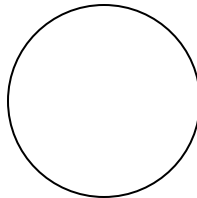
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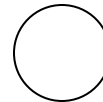
3/4" diameter
solid round rod
maximum size



3/8" diameter
solid round rod
minimum size



1" diameter x 16 gauge
wall thickness round
tubing. Maximum size.



1/2" diameter x 16 gauge
wall thickness round
tubing. Minimum size.

Option4 comes with individual tubing components (5 complete sets) for thin wall tubes with O.D.'s of : 1/2", 5/8", 3/4", 7/8", and 1"

Option5: Micro Bending Kit



5/8" x 1/8"
flat strip metal



9/16" x 1/8"
joint strap material



3/4" x 1/8"
joint strap material

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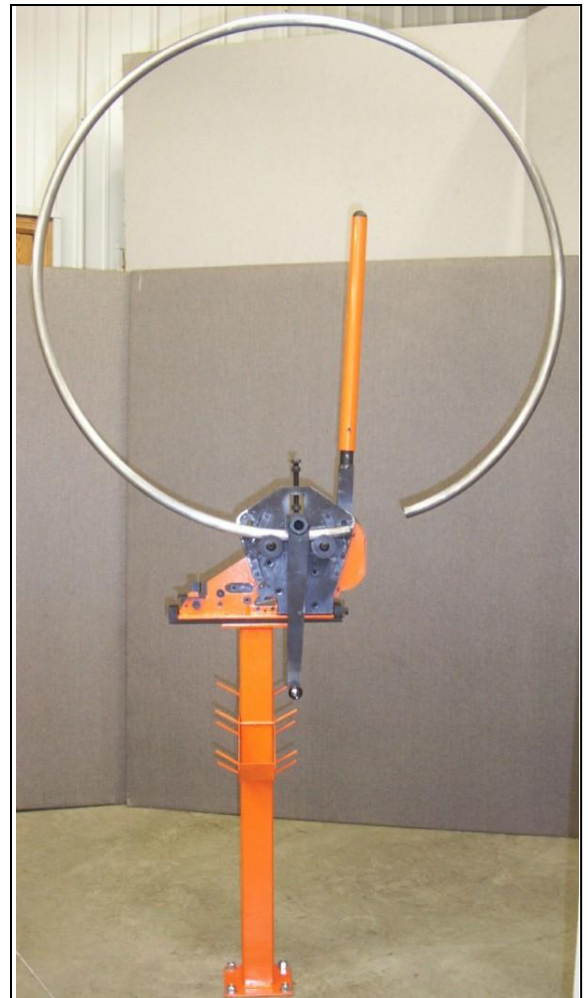
www.metalcraftusa.com website

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info@metalcraftusa.com email

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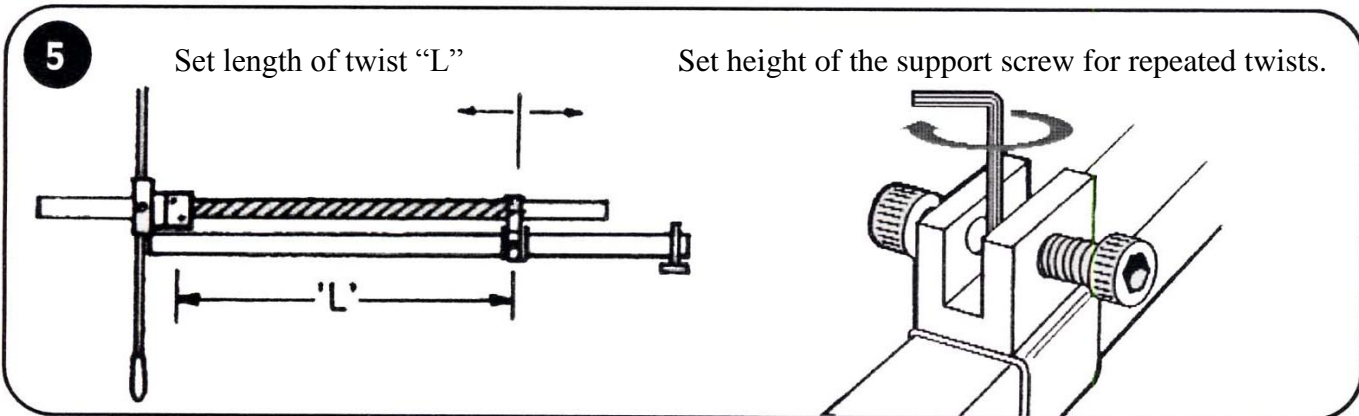
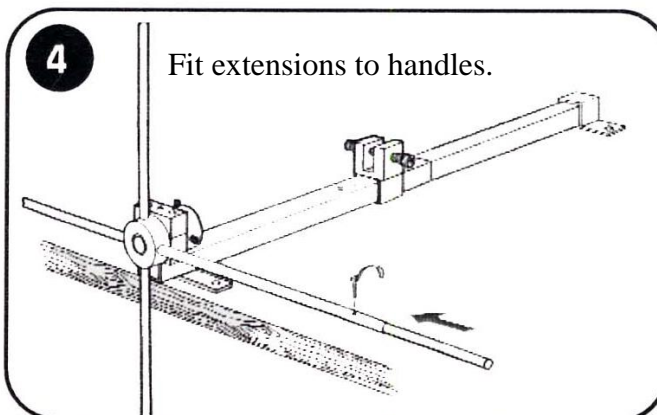
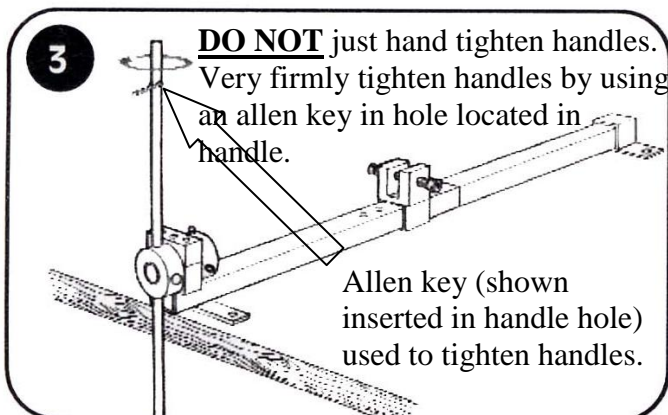
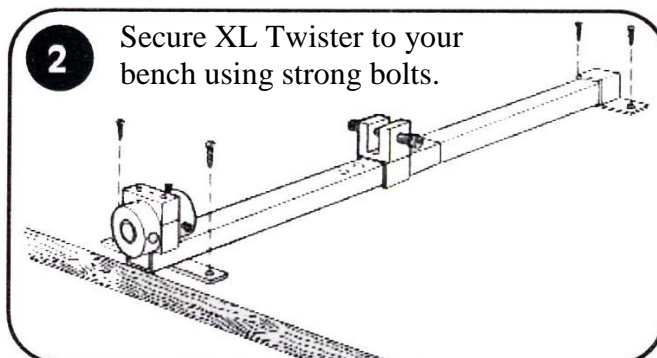
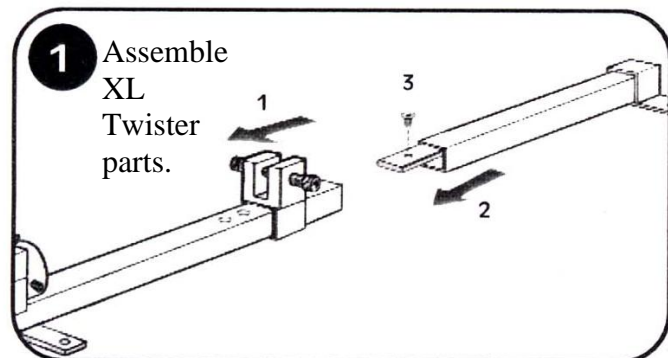
Picture of
XL5+ Metal
Bender on
optional
pedestal. 12
feet of 1"
tubing rolled
into a circle.



XL TWISTER

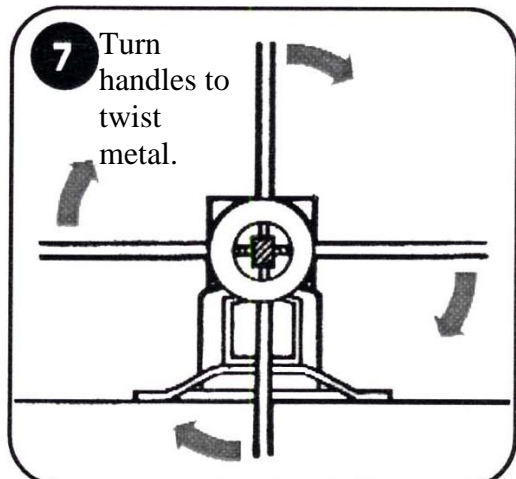
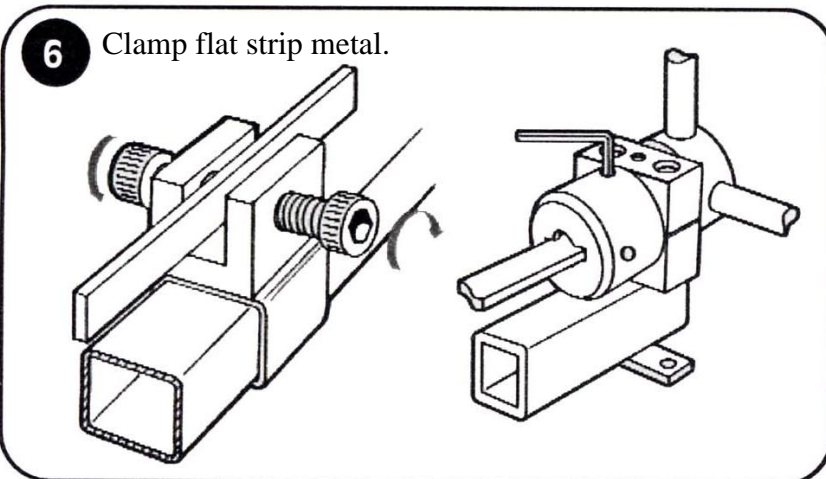
Please keep these instructions in a safe place for any future reference to the parts diagrams.

Important – ensure all moving parts are regularly lubricated.



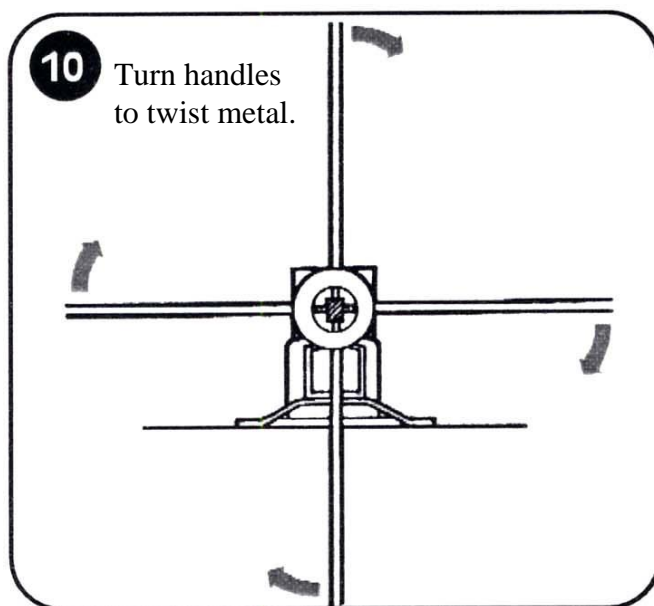
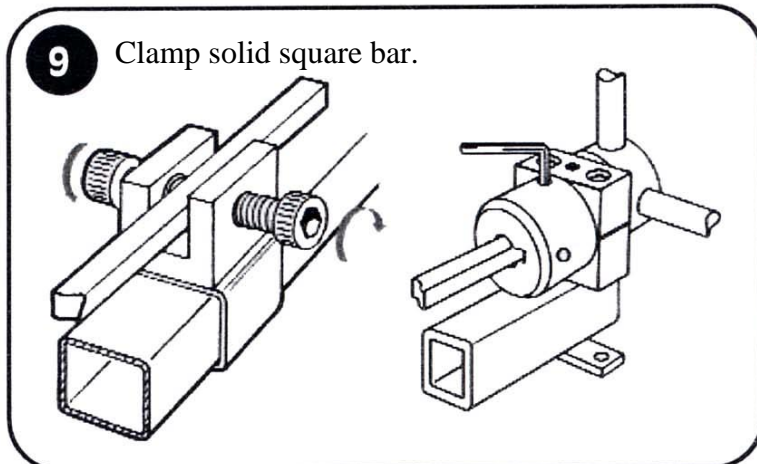
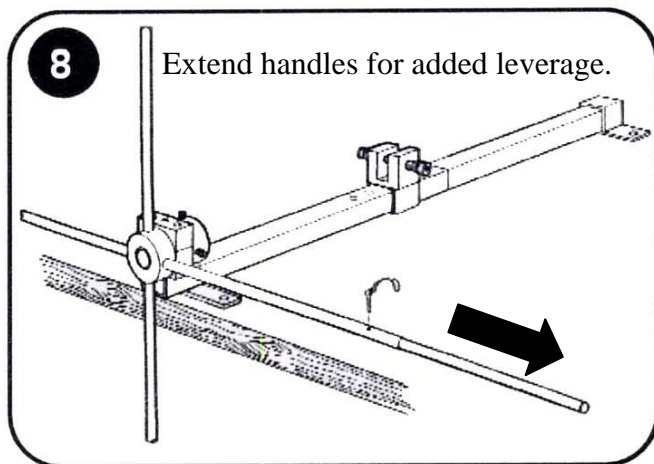
Twisting Flat Strip Metal

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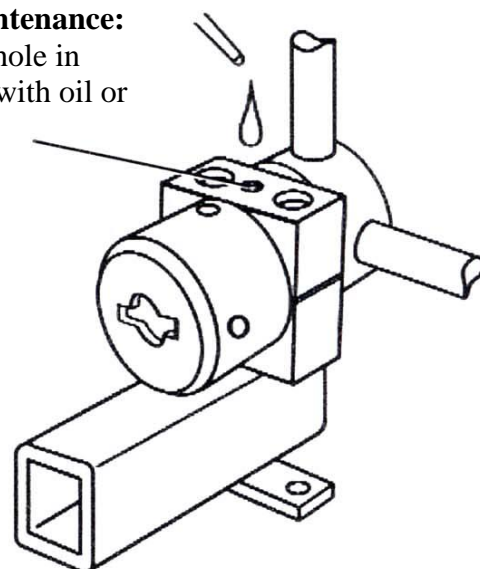
Twisting Solid Square Bar

Wrought Iron Handicrafts, Inc.



Routine Maintenance:

Lubricate oil hole in boss housing with oil or grease.



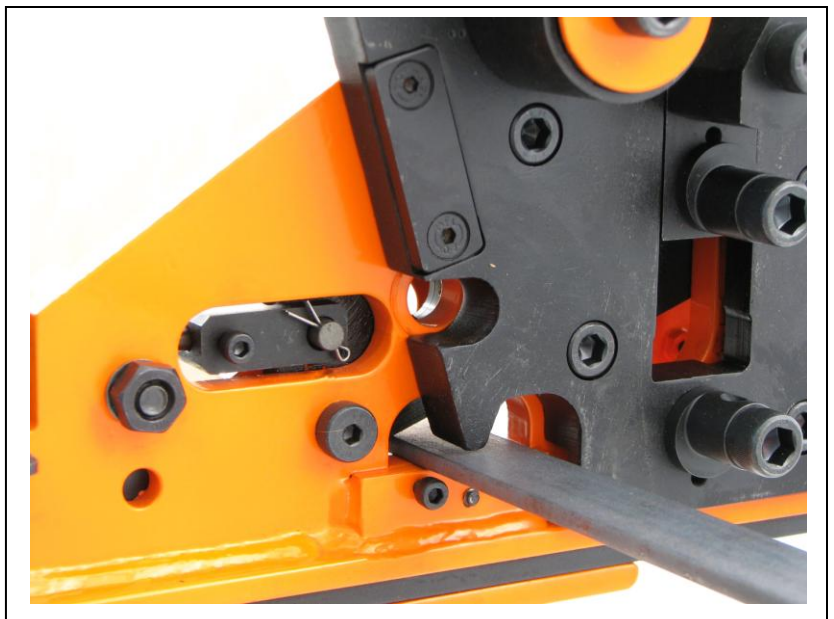
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MAXIMUM SIZE METAL FOR XL TWISTER	LENGTH	
	Minimum	Maximum
1 1/2" x 5/16" Flat Strip Metal and 5/8" Square Bar.	3 1/4"	41 1/2"

Longer twists may be achieved by moving twisted section through the XL Twister and then twisting the next section.

- Note
- 1) These sizes are for Hot Rolled Mild Steel & Annealed Bright Mild Steel.
 - 2) Working beyond the capacities stated above or with materials of greater strength or hardness will reduce the operational life of the machine.

DUE TO A POLICY OF CONTINUAL DEVELOPMENT & IMPROVEMENT, WROUGHT IRON HANDICRAFTS, INC. RESERVES THE RIGHT TO MODIFY METALCRAFT TOOLS WITHOUT PRIOR NOTIFICATION.



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