

BENDER/BRAKE

**Model: CB-24
CB-30**



OPERATION MANUAL

Save This Manual

You will need the manual for the safety warning and precautions, assembly instructions, operating and maintenance procedures, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep the manual and invoice in a safe and dry place for future reference.

Safety Warning and Precautions

Warning: When using tool, basic safety precautions should always be followed to reduce the risk of person injury and damage to equipment.

Read all instructions before using this tool!

1. **Keep work area clean.** Cluttered area invites injuries.
2. **Observe work area conditions.** Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep work area well lighted. Do not use electrically powered tools in the presence of flammable gases or liquids.
3. **Keep children away.** Children must never be allowed in the work area. Do not let them handle machines, tools, or extension cords.
4. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
5. **Do not force tool.** It will do the job better and more safety at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool capacity.
6. **Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair cover to contain long hair.
7. **Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machine.
8. **Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. The handles must keep clean, dry and free from oil and grease at all times.
9. **Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
10. **Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper

operation. Any part that is damaged should be properly repaired or replaced by a qualified technician.

11. **Replacement parts and accessories.** When servicing, use only identical replacement parts, Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from the distributor.
12. **Do not operate tool if under the influence of alcohol or drugs.** Read warning labels on prescriptions to determine if your judgment of reflexes is impaired while taking drugs. If there is any doubt, do not operate the tool.

I . Characteristic, General Specifications and Working Instruction:

1) Characteristic:

- A manually operated tool that forms uniform drive cleat edges on rectangular ductwork in seconds without set-up or adjustment.
- The upper handle forms the cleat and the lower handle opens the tool for easy removal of the material.
- Torrington needle bearings are used.
- A quick-release is built into the lower handle, which has 3-positions available.

2) General Specifications:

Item No.	373911	373914
Model	CB-24	CB-30
Max. bending	24" / 610mm	30" / 760mm
Max. bending thickness	20Ga / 1.0mm	20Ga / 1.0mm
Packing size(cm)	82 x 27 x 31	96 x 27 x 31
N.W. / G.W(kg)	26 / 28	30 / 32

3) Working Instruction:

Warning:

Before operate the machine, have to fix it firmly. Pay attention to rotate in place while bending, then working after steady. Keep other person away when using it, In order to avoid injury touch bending parts with hand is forbid.

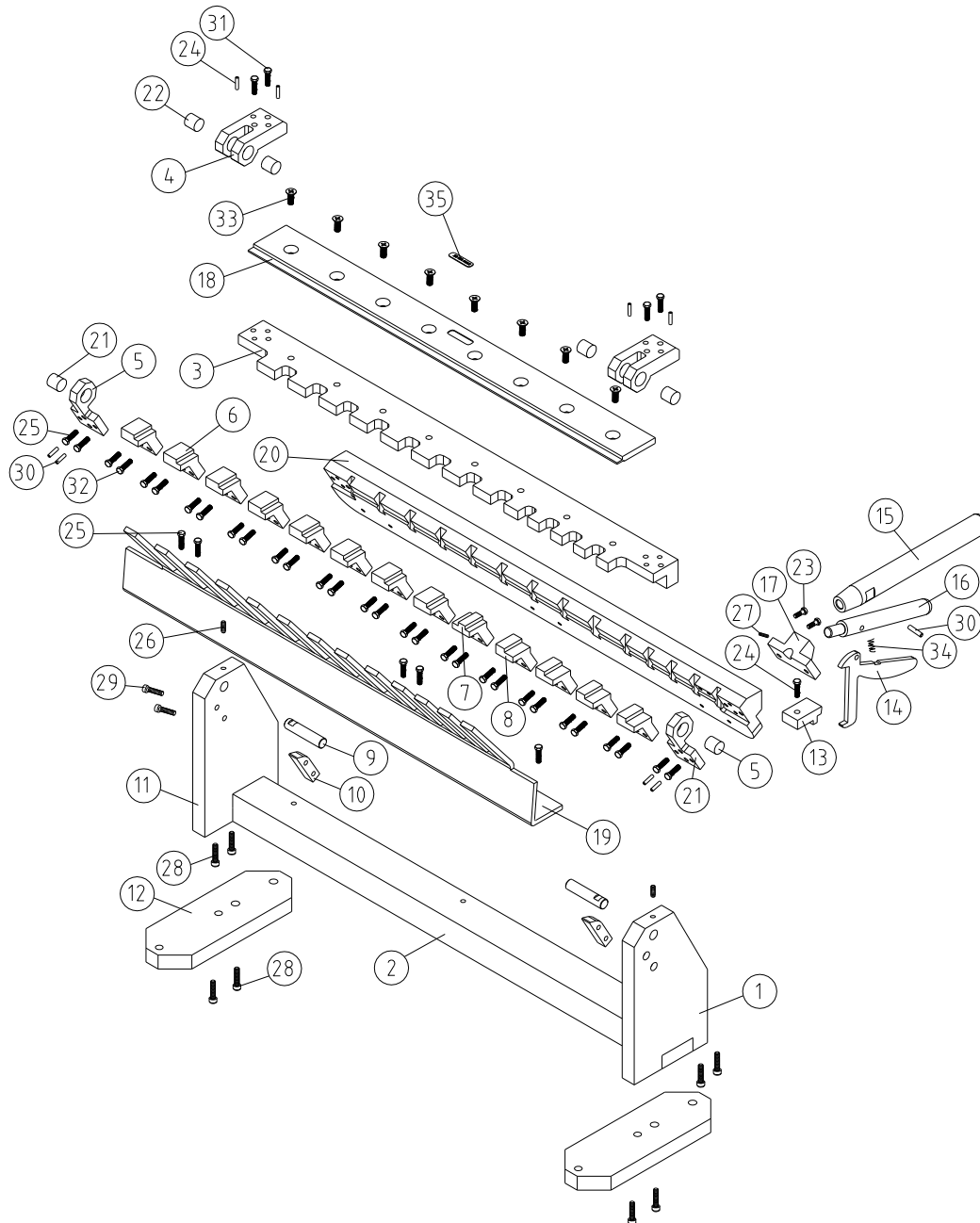
Do not exceed the capacity of the cleat bender 20 ga.(0.39) mild steel. Do not use the cleat bender to bend rods, nails or wires.

Working Instruction:

1. The segmented base of your cleat bender is designed so that duct sections and fittings of almost any dimension will fit into the bender with one or both legs formed to right angles. Your duct or fittings should be notched at the corners to properly form your driver cleat pockets. Recommended notch depth is $\frac{7}{16}$ to $\frac{1}{2}$ inch. Recommended notch angles are 30 to 45 degrees.
2. Insert your notched duct flange under the upper blade of the cleat bender (as picture 1). Raise the top handle to its complete arc point approximately 150 degrees. Leave the top handle in this position and release the lower handle by depressing the latch and raising the handle at the same time. Raise the lower handle to its complete arc point. At this time push the duct section into the throat of the cleat bender to release the formed drive cleat flange. When released, withdraw the duct section from the tool. Return both handles to their normal down position. If desired, the top leaf of the cleat bender can now be used to close the drive cleat edge to +180 degrees. Your drive cleat edge is now complete.
3. The cleat bender can also be used to make the actual drive cleats used in joining dual sections together. The drive cleat blanks should be sheared or slit into appropriate width, approximately $2 \frac{1}{8}$ inches. The bending procedure is the same as for the drive cleat edges on ducting with the exception that the lower handle does not have to be released to remove the cleat after each bend, Use the top leaf of the cleat bender to close the drive cleat edge to 180 degrees.

II.. Exploded figure and parts list CB-24

Exploded Figure

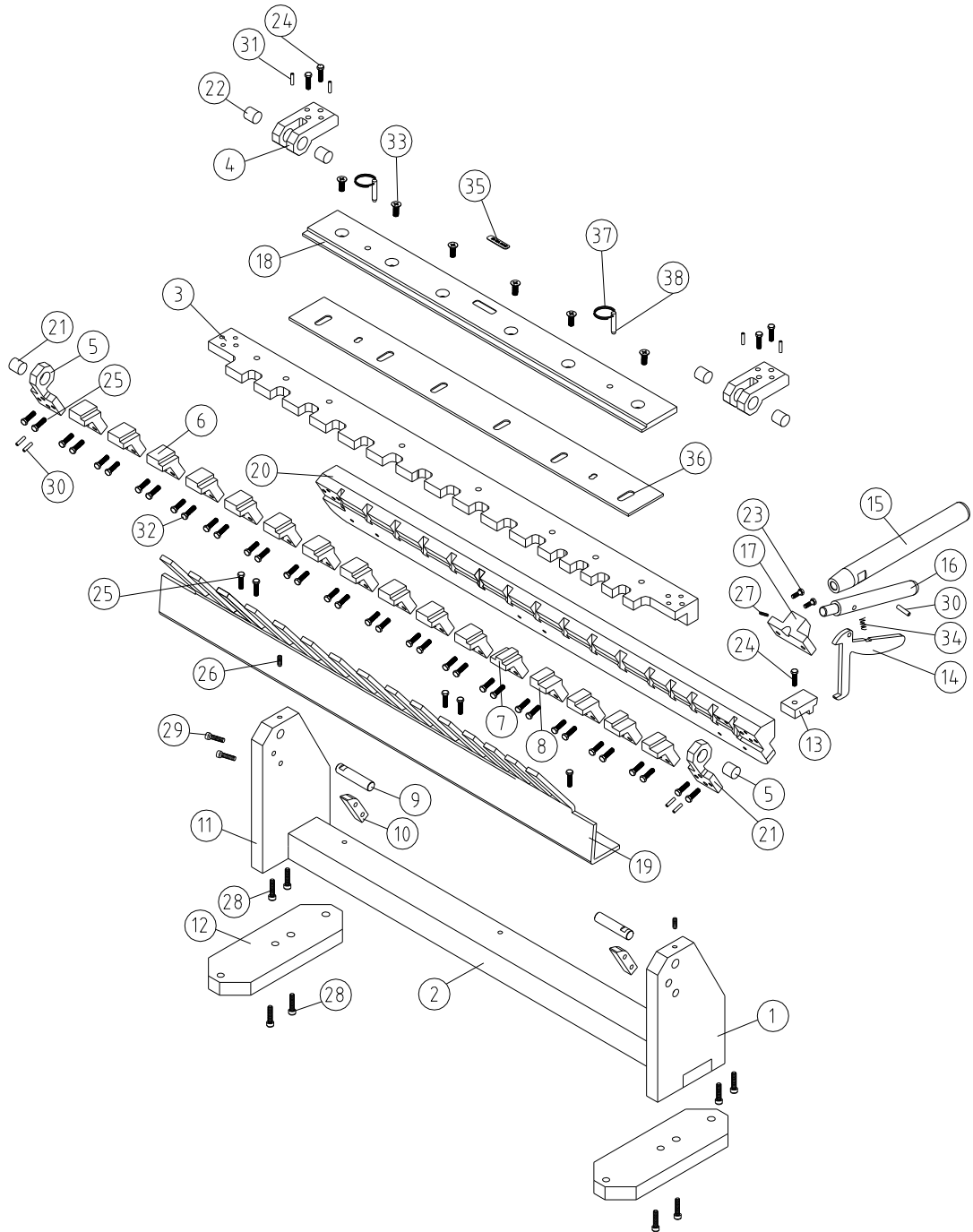


Parts Lis

Item No.	Description	Qty
1	Right junction plate	1
2	Intermediate plate of stand	1
3	Dead plate of bending blade	1
4	Rotary fixed block of upper bending plate	2
5	Rotary fixed block of lower bending plate	2
6	Stop block 3#	8
7	Stop block 2#	1
8	Stop block 1#	4
9	Rotary shaft	2
10	Limited block	2
11	Left junction plate	1
12	Baseboard of stand	2
13	Fixed block of locking handle	1
14	Locking handle	1
15	Long handle	1
16	Short handle	1
17	Fixed block of handle	1
18	Bending blade	1
19	Rear back plate	1
20	Lower folded plate	1
21	Multi-roll bearing HK1410	2
22	Multi-roll bearing HK1412	4
23	Hex sunk screw M6X20	2
24	Hex bolt M6X30	5
25	Hex bolt M6X25	4
26	Hex set screw M6X12	2
27	Hex set screw M6X16	1
28	Hex column screw M10X25	8
29	Hex column screw M6X25	4
30	Round pin 6X18	1
31	Round pin 6X32	4
32	Hex bolt M6X30	26
33	Hex sunk screw M8X20	8
34	Pressure spring	1
35	Brand	1

II .. Exploded figure and parts list CB-30

Exploded Figure



Parts Lis

Item No.	Description	Qty
1	Right junction plate	1
2	Intermediate plate of stand	1
3	Dead plate of bending blade	1
4	Rotary fixed block of upper bending plate	2
5	Rotary fixed block of lower bending plate	2
6	Stop block 3#	11
7	Stop block 2#	1
8	Stop block 1#	4
9	Rotary shaft	2
10	Limited block	2
11	Left junction plate	1
12	Baseboard of stand	2
13	Fixed block of locking handle	1
14	Locking handle	1
15	Long handle	1
16	Short handle	1
17	Fixed block of handle	1
18	Bending blade	1
19	Rear back plate	1
20	Lower folded plate	1
21	Multi-roll bearing HK1410	2
22	Multi-roll bearing HK1412	4
23	Hex sunk screw M6X20	2
24	Hex bolt M6X30	5
25	Hex bolt M6X25	4
26	Hex set screw M6X12	2
27	Hex set screw M6X16	1
28	Hex column screw M10X25	8
29	Hex column screw M6X25	4
30	Round pin 6X18	1
31	Round pin 6X32	4
32	Hex bolt M6X30	32
33	Hex sunk screw M8X20	6
34	Pressure spring	1
35	Brand	1
36	Slotted holes plate	1
37	Collar	2
38	Pin	2

Note: This manual is only for your reference. Owing to continuous improvement of the machines, Changes may be made at any time without obligation on notice.