

BENDER/BRAKE

Model: CHB-24

CHB-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 rugged toll built for increased productivity while getting the most consistent bends quickly.
- With two-way trunnion design, holds the bending apron steady at the base of the bend ensuring accuracy throughout the length of the sheet.
- This machine can be bench-mounted and adjusts for bends of 1/4 to 7/8 inches, 24 inches long.

2) General Specifications:

Item No.	373910	373913
Model	CHB-24	CHB-30
Max. bending	24" / 610mm	30" / 760mm
Max. bending thickness	20Ga / 1.0mm	20Ga / 1.0mm
Packing size(cm)	81 x 38 x 11	98 x 38 x 18
N.W./G.W.(kg)	30 / 32	34 / 36

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 use a heavier gauge material that the machine was designed for Maximum 20

Gauge Mild steel.

Working Instruction:

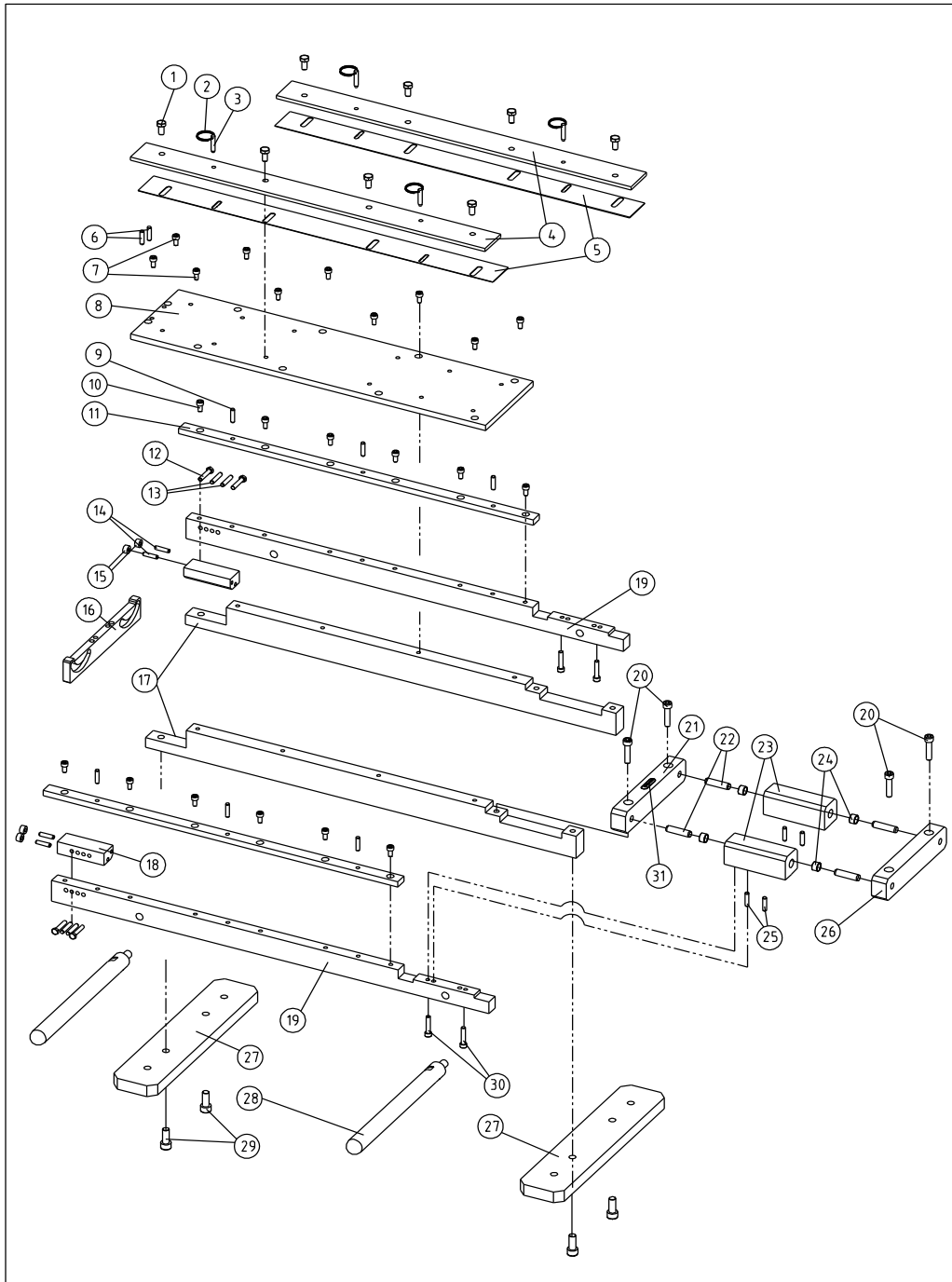
Place cheek bender unit in a position on the workbench so that there is sufficient clearance for bending the maximum size section. Be sure unit is placed so that the open end overhangs the table. When unit is in position, mount it to the workbench and place handles into desired position.

The shims are set to run a 1/4 flange. This can be changed by removing the 4 hex head bolts and sliding it to the desired position. The shim has 2 sets of dowel pin locating slots, which will allow you to adjust the flange length in 1/8" increments starting at 1/4" and going up to 1" This can be done with both the left and right sides if needed.

(The units are shipped with shims for 24 ga. Material. 20 ga. Shims are available from the factory)

II.. Exploded figure and parts list CHB-24

Exploded Figure

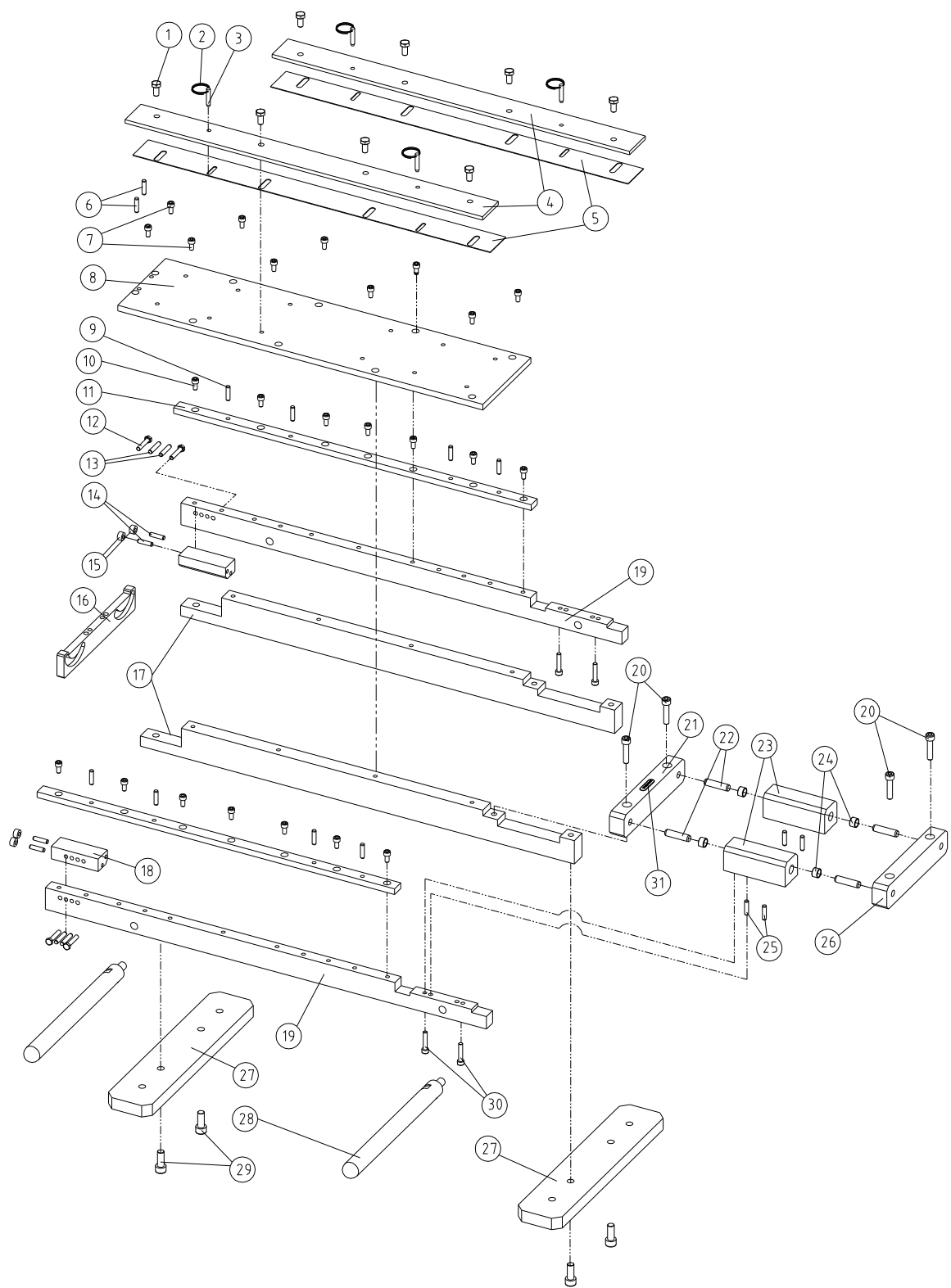


Parts List

Item No	Description	Qty
1	Bolt M8X16	8
2	Key ring 1X30	4
3	Pin	4
4	Binder plate	2
5	Limited plate	2
6	Round pin 6X24	2
7	Bolt M6X12	10
8	Work table	1
9	Round pin 6X24	6
10	Bolt M6X12	12
11	Spoke of bending plate	2
12	Bolt M6X30	4
13	Round pin 6X30	4
14	Round pin 6X24	4
15	Cover	4
16	Plate	1
17	Stand leg	2
18	Block	2
19	Knife rest	2
20	Bolt M8X35	4
21	Board	1
22	Round pin 10X24	4
23	Block	2
24	Needle bearing HK1012	4
25	Round pin 6X24	4
26	Plate	1
27	Base plate	2
28	Handle	2
29	Bolt M10X25	4
30	Bolt M6X30	4
31	brand	1

II.. Exploded figure and parts list CHB-30

Exploded Figure



Parts List

Item No	Description	Qty
1	Bolt M8X16	8
2	Key ring 1X30	4
3	Pin	4
4	Binder plate	2
5	Limited plate	2
6	Round pin 6X24	2
7	Bolt M6X12	10
8	Work table	1
9	Round pin 6X24	6
10	Bolt M6X12	12
11	Spoke of bending plate	2
12	Bolt M6X30	4
13	Round pin 6X30	4
14	Round pin 6X24	4
15	Cover	4
16	Plate	1
17	Stand leg	2
18	Block	2
19	Knife rest	2
20	Bolt M8X35	4
21	Board	1
22	Round pin 10X24	4
23	Block	2
24	Needle bearing HK1012	4
25	Round pin 6X24	4
26	Plate	1
27	Base plate	2
28	Handle	2
29	Bolt M10X25	4
30	Bolt M6X30	4
31	brand	1

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.