

ATTN: Dave

CLEATFORMER

CLEAT FORMING MACHINE

PRODUCTION PRODUCTS, INC.
SHEET METAL MACHINERY & SUPPLY
30487 POTOMAC WAY
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SET-UP

The machine is shipped with oil. Use a standard 10W or 20W hydraulic oil. Maintain oil level to the middle of the sight gauge. Minor adjustments to set the cleat length may be required prior to using your new cleatmaster. The cleatformer is equipped with back gauge pins mounted on a common adjustment bar. On each side of the machine, locate the bolts (see drawing) that hold the bar in position. Located next to the bolt is a pin that is used to limit the adjustment. (This prevents adjusting the bar too far and avoids damage to the machine.) Loosen the two (2) bolts by turning counter clockwise. Move the bar towards the front of the machine to make a smaller cleat, and towards the back to make larger cleats. Tighten bolts.

FRONT HOLD DOWN BAR

The machine is equipped with an adjustable material hold down bar. This provides holding pressure on the material during the bending process. Use the drawing and following procedure to make minor adjustments:

- 1.) For all 24" models, loosen the four (4) Allen bolts on the front of the hold down bar. (2 on the right side and 2 on the left side) 36" models have two (2) additional bolts located in the center of the hold down bar that also need to be loosened.
- 2) Place a piece of material the thickness you will be bending under the hold down bar.
- 3.) Located on the top of the block that mounts the hold down bar to the sides of the machine is a 1/4" hex head bolt. Using a 7/16" open end wrench, turn clockwise to move the hold down bar closer to the table. (This will result in a tighter bend) If the bend is too tight, turn the bolt

counter clockwise. This will allow you to raise the hold down bar.
(This will make a greater opening in the bend)

4.) After the adjustments have been made, tighten the four (4) Allen bolts (six (6) bolts for the 36" model) that secure the hold down bar to the mounting blocks. (The 1/4" top hex head bolt should be snug, not tight. This bolt is only used to prevent the hold down bar from moving up in the event the four Allen bolts are not tight.

OPERATION

Plug the machine into a grounded outlet and turn the power switch on. The machine will go through a "self test", and may take up to 15 seconds to complete. Next to the power switch is a "reset" push button. By pressing this button, the machine goes through a short time delay, then moves the machine to the ready position. It is not necessary to hold the button down, just a momentary push then release. You are now ready to begin bending cleats.

BENDING CLEATS

Position the material so the edge to be bent is firmly against the pin gauge. Step on the foot switch to start the bending process. The foot switch only needs to be pressed to start the bending phase of the process. Once the cycle has started, you may release the foot switch and the machine will continue and retract automatically. When the machine completes the cycle, remove the material and repeat the process. The machine is equipped for a variable bend. This adjustment is on the right side of the machine. (See drawing) Raise the adjustment to make less than a 180 degree bend. To make a 180 degree bend, lower the limit adjustment to the bottom. If the folding bar extends, but does not retract

, raise the limit until it makes contact, then the machine will complete the cycle.

MAINTENANCE

CAUTION: ALL POWER MUST BE DISCONNECTED BEFORE ANY MAINTENANCE IS PERFORMED!

Your new cleatformer only requires minor maintenance, however it must be performed. The table slides in and out on brass guides. Maintain lubrication on this slide to minimize any wear. Use a standard grade grease and brush to apply on the brass slide. On each side of the machine, are two (2) grease zerks. (See drawing) These serve two functions. One is to apply grease directly to the cam followers on the folding bar. With the machine in the home or ready position, (folding bar is retracted) pump 3 shots of grease in each zerk. The other is to check the tightness of the cam bearings. To check the bearings, remove the grease zerks, insert a 1/4" allen wrench through the hole, into the bearing and check that it is tight. Additionally, the back cover and table cover must be removed, to allow proper cleaning. Remove any debris from the slides and cam follower slots. Wipe any excess grease away. Servicing of the machine is mandatory to insure proper operation. Lack of service will lead to premature failure of the cam followers on the folding bar, and brass table slide. The above maintenance must be performed monthly. Failure to keep the machine clean and lubricated will void the warranty.

The hydraulic unit requires no special maintenance. Any leaks must be repaired to avoid losing fluid. The fluid reservoir has a sight glass on the front, and the fluid level must be maintained in the middle. Use a standard AW-68 or equivalent grade hydraulic oil when servicing this machine.

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ELECTRICAL

The electrical controls are located on the rear of the machine. No adjustments are necessary.

SERVICE

If you require service or aid in troubleshooting, contact the factory.

Warranty

Each machine is pre-run and inspected prior to shipment. We agree that for a period of 12 months from the shipment date to replace, at our option, any machine(or component part thereof) proving defective providing that such machine or part is returned, freight prepaid,to our plant for examination.

This warranty does not include repair and replacement costs required because of misuse, abuse or lack of maintenance,or normal wear and tear. Furthermore, we can not be responsible for the cost of repairs made or attempted outside of our factory.

With respect to standard apparatus furnished, but not manufactured by us, such as electrics, pneumatics, and hydraulics, etc, we will extend to purchaser the same warranty or guarantee as is supplied to us, by that respective manufacturer.

There are no warranties expressed or implied, or merchantability,

fitness or otherwise which extend beyond the foregoing warranty.

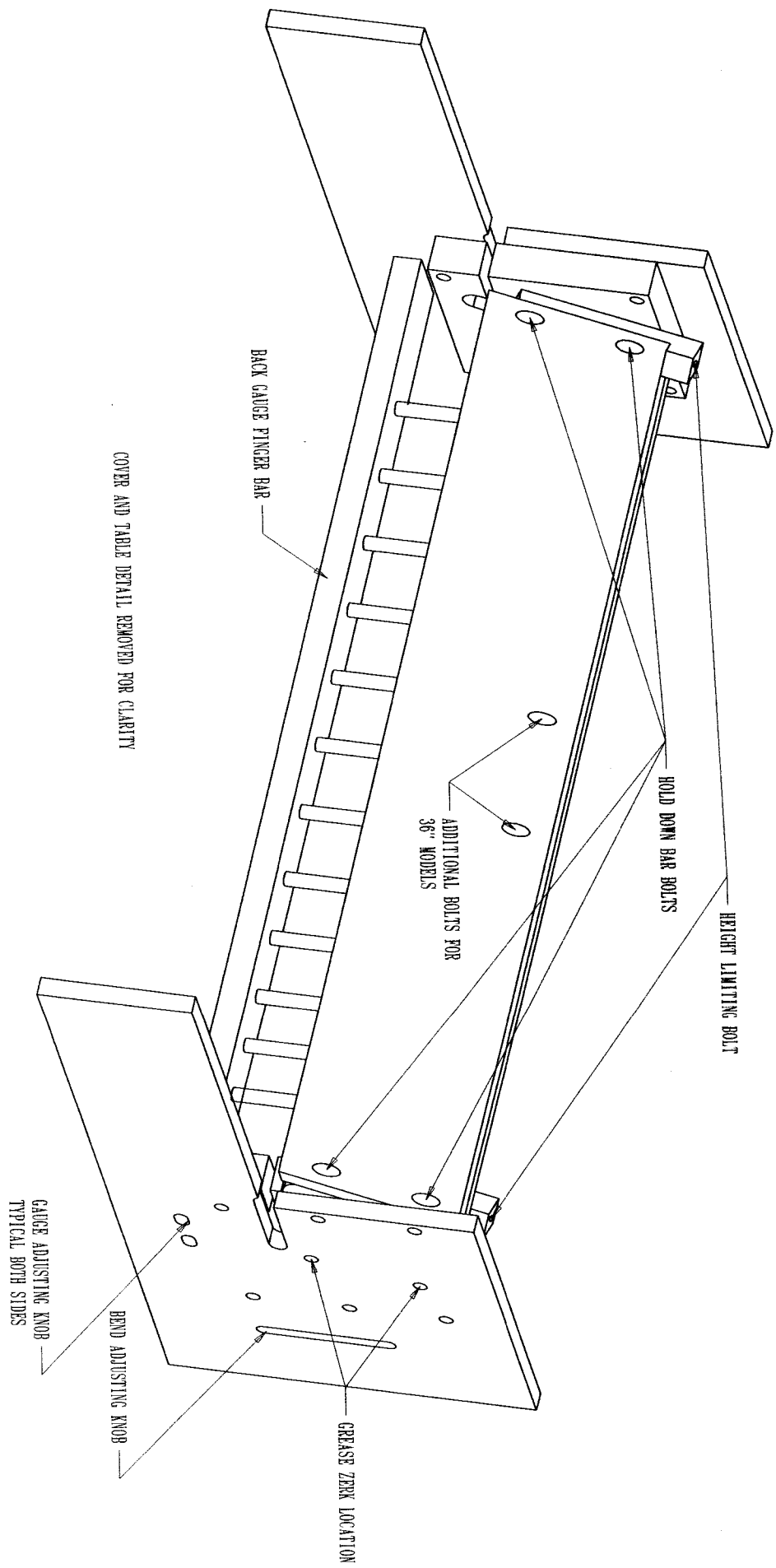
Purchaser's sole and exclusive remedy and manufacture's limit of liability for any and all losses or damages resulting from defective equipment or from any other cause, shall be at manufacture's option, the repair, or replacements of such equipment. In no event shall the pruchaser have any remedy or manufacturer any liability in excess of the purchase price of the equipment with respect to which the losses or damages occurred, and the purchaser shall have no remedy or manufacturer any liabilty for consequential or special damages.

This warranty becomes effective from the date of shipment.

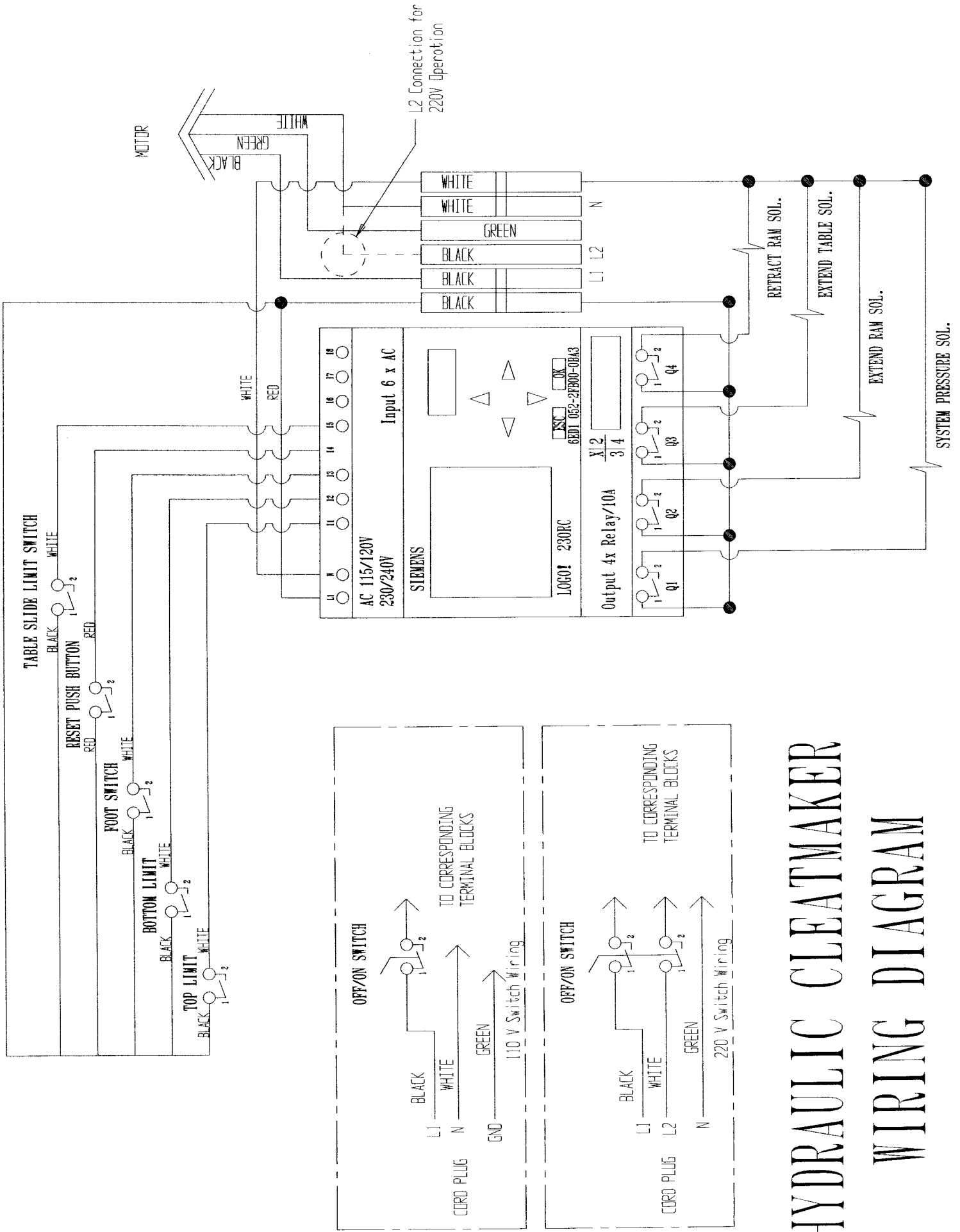
Machine model HCm 24

Serial Number 052

Date Shipped _____



BLACK



HYDRAULIC CLEATMAKER WIRING DIAGRAM