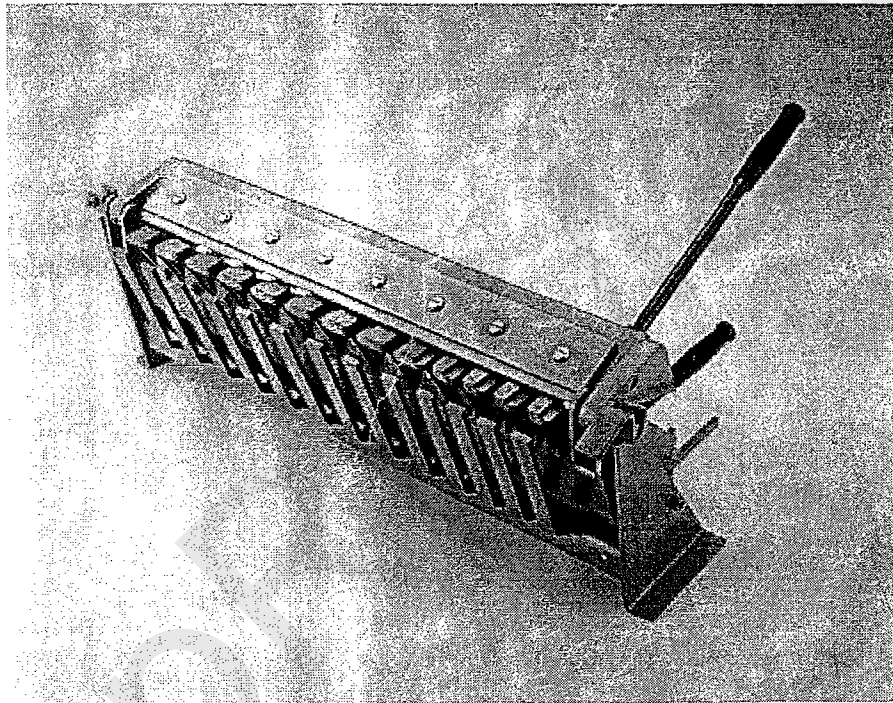


Operator's manual for the **18", 24", and 30"** **Cleat Bender**



NHFE
LOCKFORMER

SAFETY GUIDELINES



You are not ready to operate this equipment if you have not read and understood the safety information in this manual.



WARNING:

Wear proper gloves to prevent lacerations caused by sharp edges of stock as it forms the cleat.

Never operate this equipment unless all covers and guards are properly installed.

Be alert for loose, worn, or broken parts. Never operate this equipment unless it is in good working condition.

Remember that the information contained in this manual is only a portion of an adequate training program. It must be coupled with specific instructions for your application along with full information of national and local safety regulations that may apply.

Installation

Provide a clean, flat, well lighted installation site. Anchor the Cleat Bender to an immovable, level surface such as a table. Next screw in the handles as shown in Figure 1. The machine should be installed with the handles easily accessible by the operator. Remove any debris that may have accumulated during shipping, and or installation.

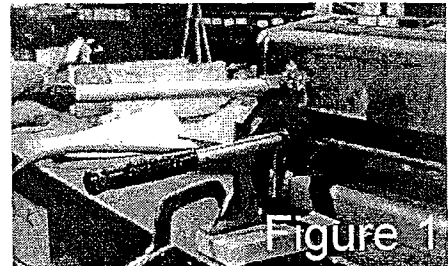


Figure 1

Operating Instructions

1) Insert the piece of material where a cleat bend is desired as shown in Figure 2. The material should be inserted in the front of the machine, making sure the material has been fully inserted under the flange.

2) Next while holding the handle on the base with one hand, and the handle on the rotating head with the other, spread the handles apart until they will spread no further. Bring the handles together again, and remove the piece of material.

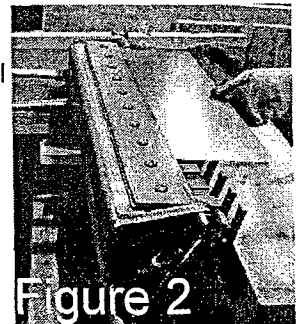


Figure 2

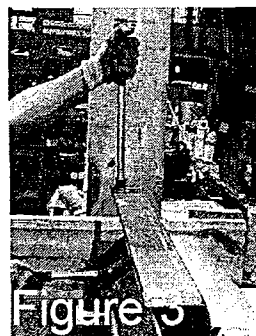
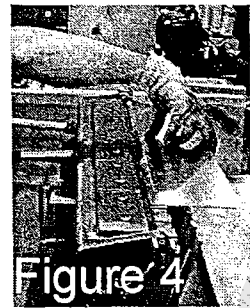


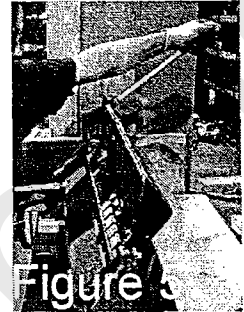
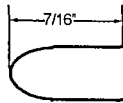
Figure 3

Operating Instructions Continued

3) Reinsert the piece of material as shown in Figure 4. The bend that was just formed should be up against the flange.



4) Repeat the procedure for forming the cleat. Separate the handles using moderate force in order to complete the cleat, be careful not to press the cleat into the material. After bringing the handles together again remove the piece of material. The finished cleat will look like the illustration just below.

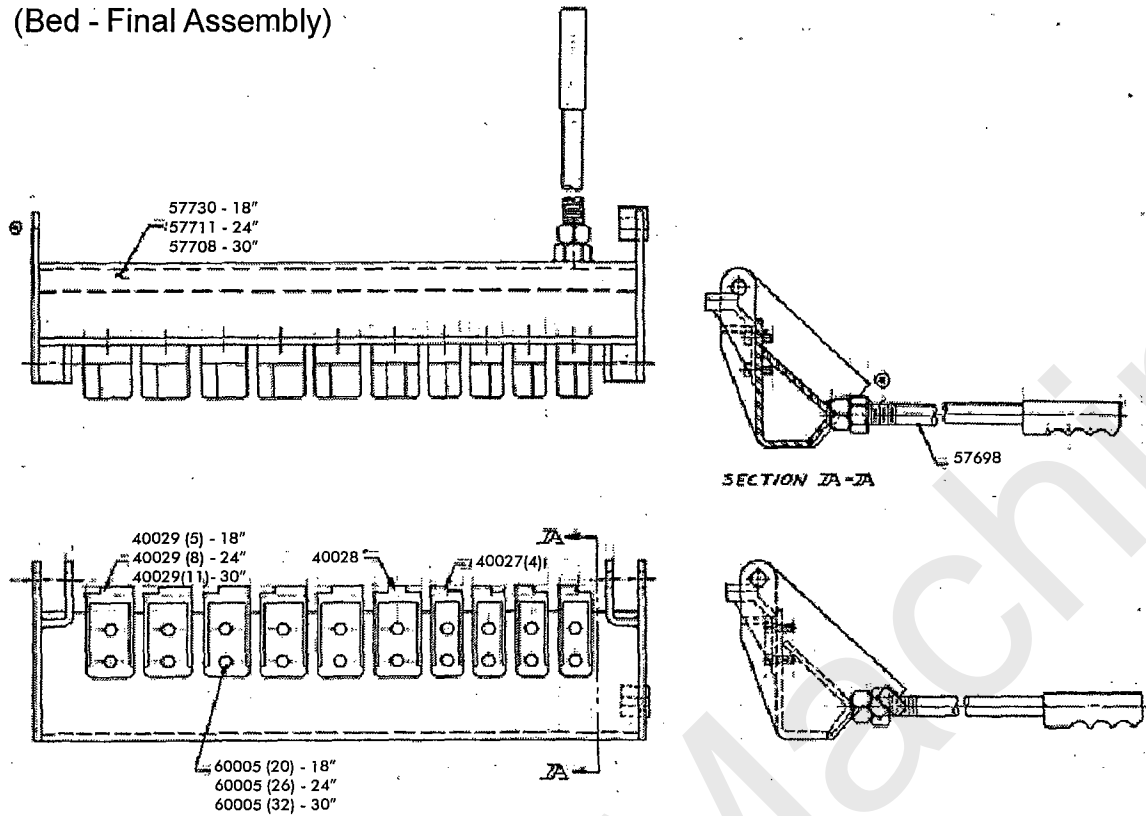


Cleat Bender Parts List

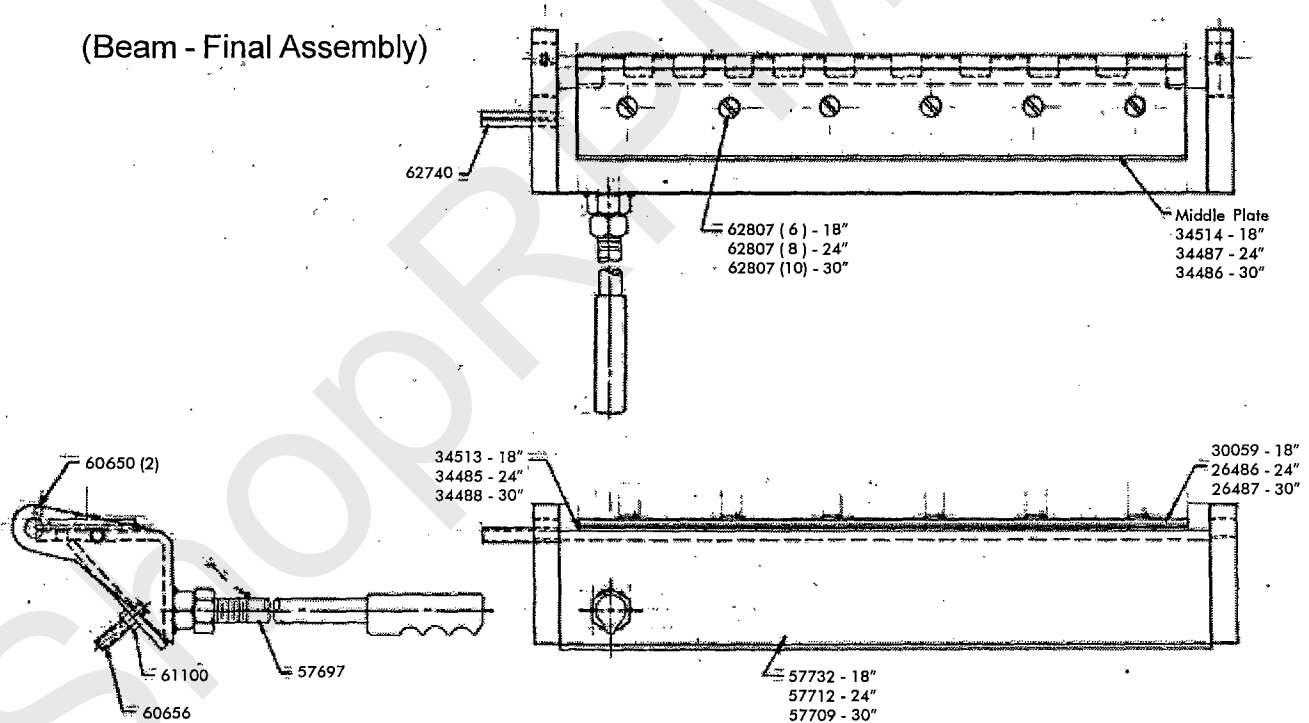
PART NUMBER	DESCRIPTION	QUANTITY	PART NUMBER	DESCRIPTION	QUANTITY	PART NUMBER	DESCRIPTION	QUANTITY
26487	Clamp Bar 30 Inch #7	1	40029	Pad 24 Inch MAIN #9	8	60005	Hex Head Cap Screw 1/4-20X3/4 30 Inch	32
26486	Clamp Bar 24 Inch #7	1	40029	Pad 18 Inch MAIN #9	5	60308	Socket Head Cap Screw 1/4-20X2-3/4	1
30059	Clamp Bar 18 Inch #7	1	42809	Pivot Pin 62653 #4	2	60650	Socket Set Screw 5/16-18X5/16	2
34486	Bend Plt 24 Inch #6	1	57697	Handle Assy	1	60656	Socket Set Screw 5/16-18X1-3/4	1
34485	Shim Plt 18 Inch #5	1	57698	Handle Assy	1	60853	Bolt 1/4-20X1-1/4	4
34513	Shim Plt 30 Inch #5	1	57708	Bed Assy 30 Inch #2	1	61061	Nut 1/4-20 Heavy S.F.	7
34488	Shim Plt 24 Inch #5	1	57711	Bed Assy 24 Inch #2	1	61100	Nut 5/16-18 Finished	1
34487	Bend Plt 24 Inch #6	1	57730	Bed Assy 18 Inch #2	1	61160	Nut 1/2-13 Heavy S.F.	1
34514	Bend Plt 18 Inch #6	1	57709	Bed Assy 30 Inch #3	1	61202	Nut 5/8-11 Heavy S.F.	1
40027	NARROW Pad 30 Inch #13	4	57712	Bed Assy 24 Inch #3	1	61203	Nut 5/8 Finished	1
40027	NARROW Pad 24 Inch #13	4	58684	Stand Wldt 18 Inch #1	1	62370	Washer Lock 1/4 Med	3
40027	NARROW Pad 18 Inch #13	4	57732	Beam Wldt 18 Inch #3	1	62740	Pin #98296A Exp 3/8, 2	1
40028	DUAL Pad 30 Inch #12	1	57761	Latch Weldment	1	62770	Plg Sprg #27107 Short	1
40028	DUAL Pad 24 Inch #12	1	60004	Hex Head Cap Screw 1/4-20X1-1/4	2	62807	Phs 5/16-18 3/4	8
40028	DUAL Pad 18 Inch #12	1	60005	Hex Head Cap Screw 1/4-20X3/4 18 Inch	20	57719	STAND WELD. #1 30"	1
40029	Pad 30 Inch MAIN #9	11	60005	Hex Head Cap Screw 1/4-20X3/4 24 Inch	26	57720	STAND WELD. #1 24"	1

Cleat Bender Illustrated Parts Breakdown

(Bed - Final Assembly)

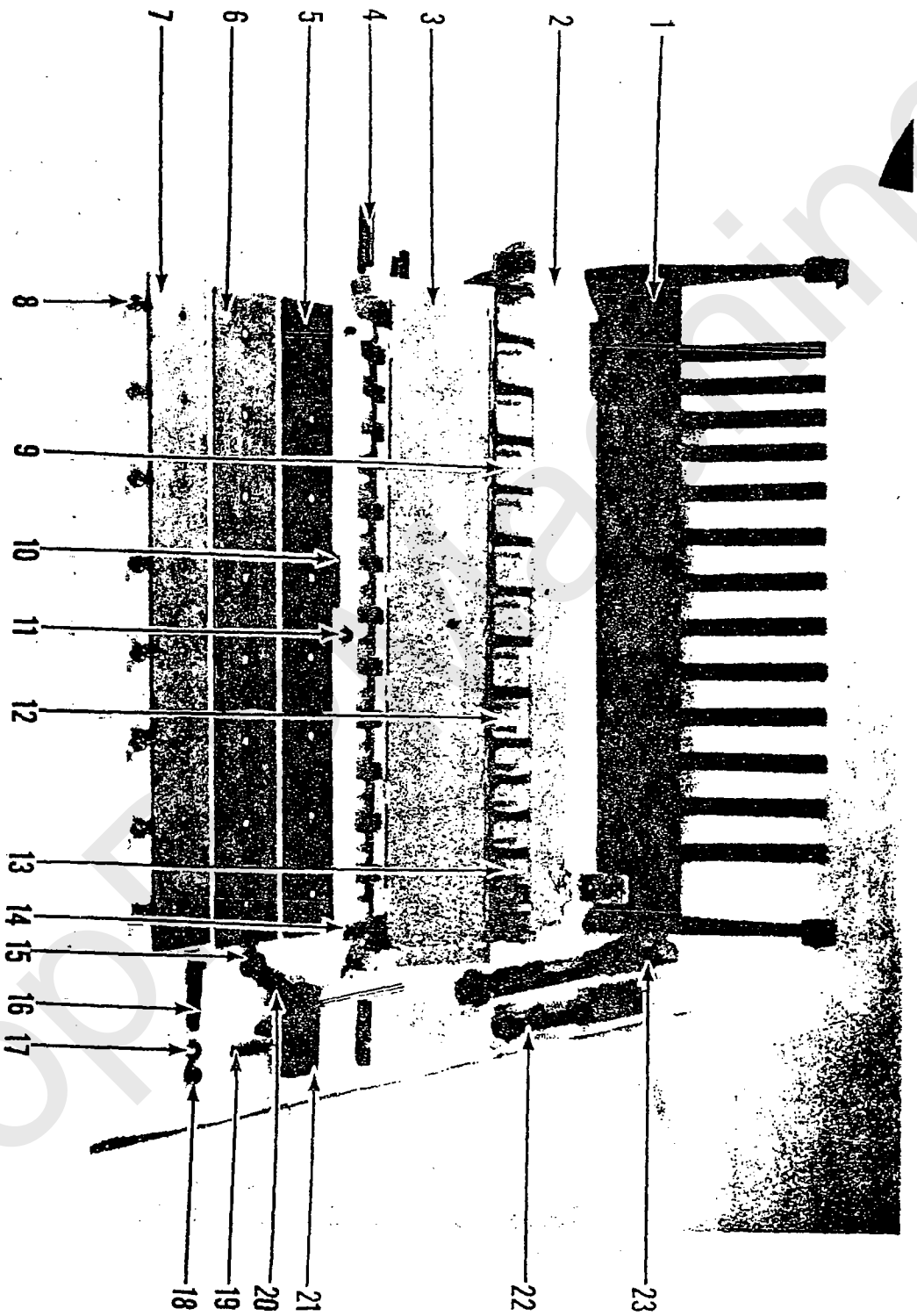


(Beam - Final Assembly)



NOTE: Above illustrations represent the 18" cleat bender. Part numbers and quantities are the same for 24" and 30" machines unless otherwise indicated.

18" 24" & 30" LOCKFORMER HAND OPERATED CLEAT BENDER PARTS LIST



NEW TRIGGER ASSEMBLY

