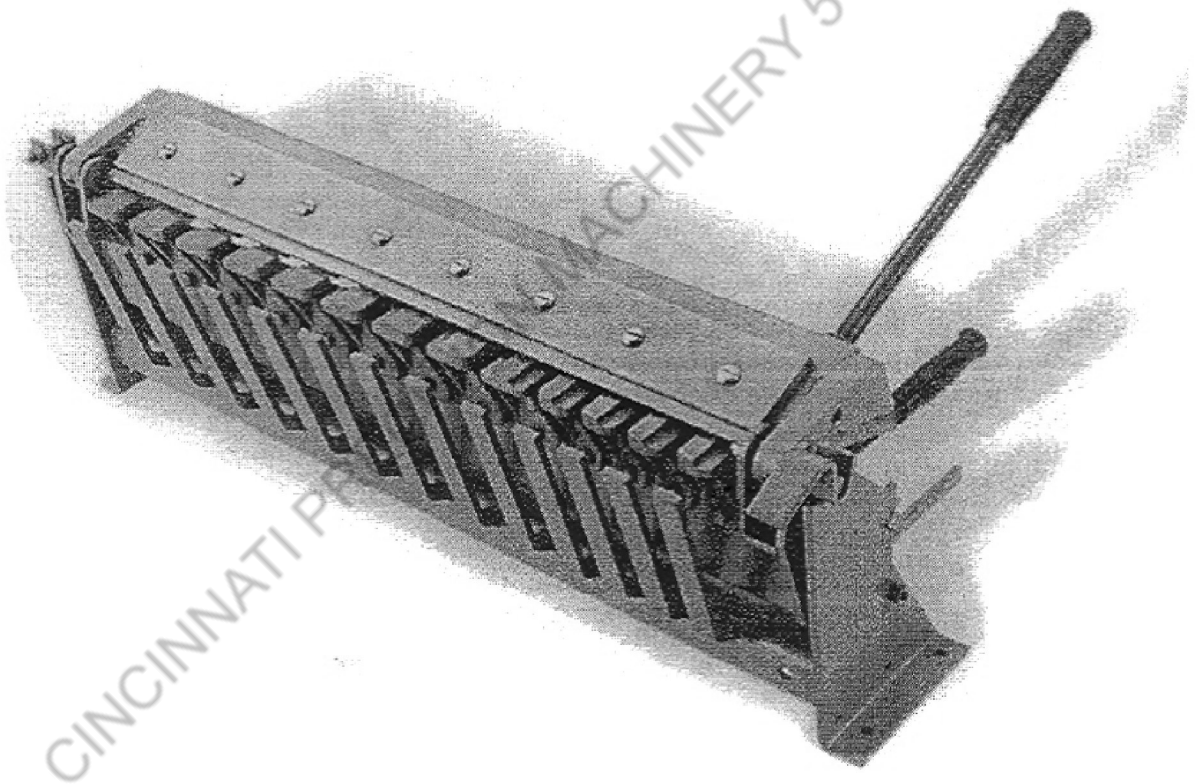


Operator's manual

Hand Cleat Bender **18", 24", & 30"**

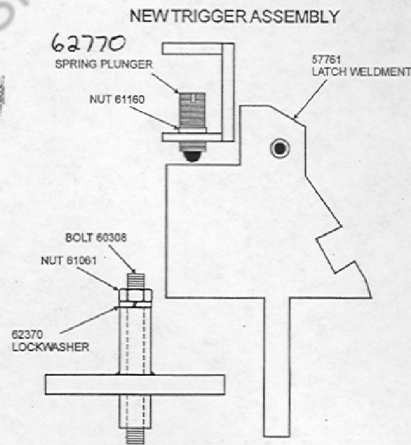
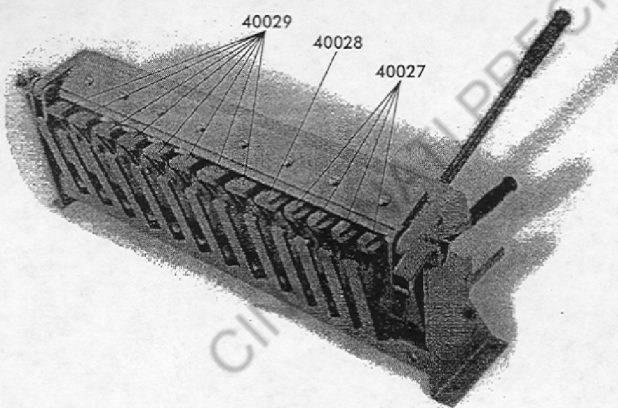


LOCKFORMER

Cleat Bender Parts List

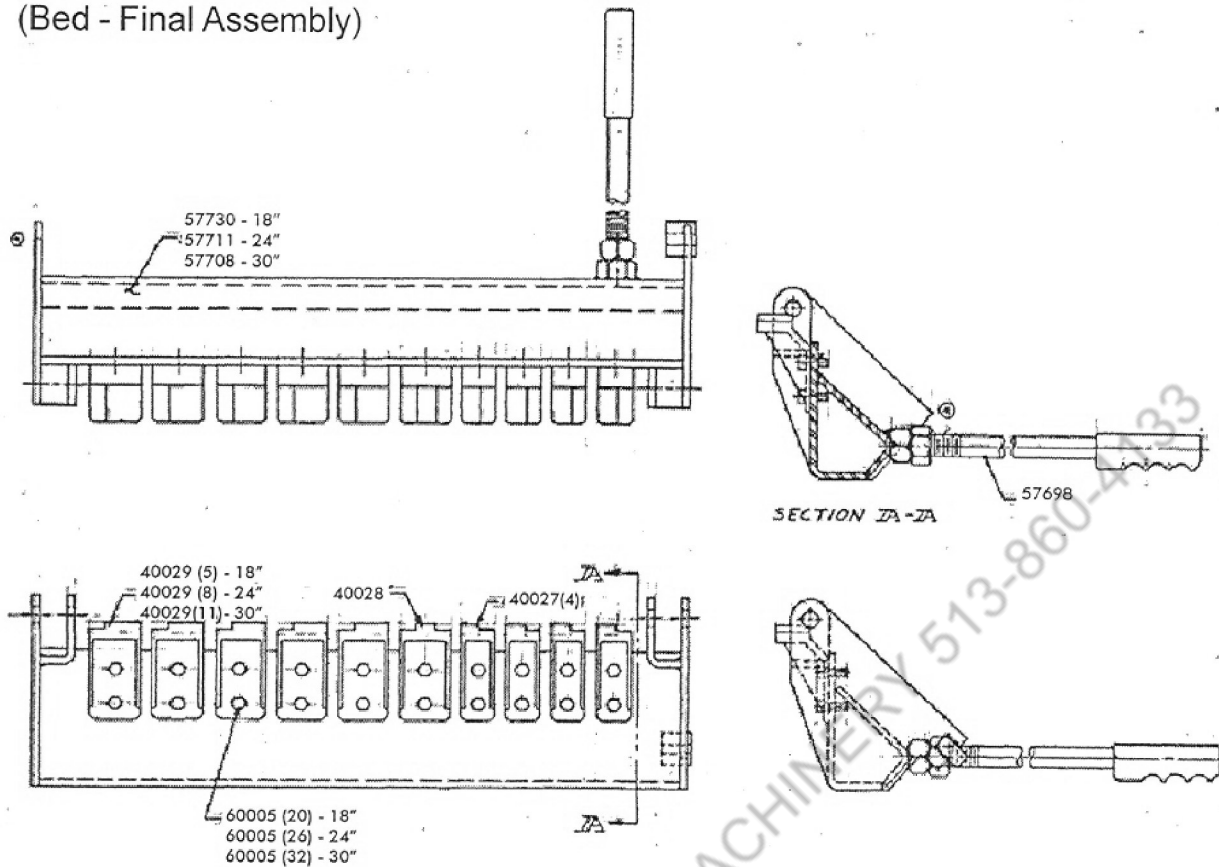
PART NUMBER	DESCRIPTION	QUANTITY
26486	Clamp Bar 24"	1
26487	Clamp Bar 30"	1
30059	Clamp Bar 18"	1
34485	Shim Plate 24"	1
34486	Bend Plate 30"	1
34487	Bend Plate 24"	1
34488	Shim Plate 30"	1
34513	Shim Plate 18"	1
34514	Bend Plate 18"	1
40027	Pad, Narrow	4
40028	Pad, Dual	1
40029	Pad, Main - 18"	5
40029	Pad, Main - 24"	8
40029	Pad, Main for 30"	11
42809	Pivot Pin 62653	2
57697	Handle Assembly	1
57698	Handle Assembly	1
57708	Bed Weldment & Mach - 30"	1
57709	Beam Weldment & Mach - 30"	1
57711	Bed Weldment & Mach - 24"	1
57712	Beam Weldment - 24"	1
57719	Stand Weldment - 30"	1
57720	Stand Weldment - 24"	1
57730	Bed Weldment & Mach - 18"	1
57732	Beam Weldment & Mach - 18"	1

PART NUMBER	DESCRIPTION	QUANTITY
57761	Latch Weldment	1
58684	Stand Weldment - 18"	1
60004	HHCS, 1/4-20, 1-1/4	2
60005	HHCS, 1/4-20, 3/4 - 18"	20
60005	HHCS, 1/4-20, 3/4 - 24"	26
60005	HHCS, 1/4-20, 3/4 - 30"	32
60308	SHCS, 1/4-20 x 2-3/4	1
60610	SSS, 1/4-20 x 1/4 - 24" & 30"	2
60650	SSS, 5/16-18 x 5/16	2
60656	SSS, 5/16-18 x 1-3/4	1
60748	SSS, 5/8-11 x 1-1/2 - 30"	1
60853	Bolt, Comdg, 1/4-20 x 1-1/4, GRS	4
61061	Nut, 1/4-20, Heavy S.F.	7
61100	Nut, Hex, 5/16-18, Finished	1
61160	Nut, 1/2-13, Heavy S.F.	1
61202	Nut, 5/8-11, HN, Heavy S.F. -18"	1
61203	Nut, 5/8-11, Finished (115/16AF)	1
62370	Wshr, Lock, 1/4, Mod	3
62636	Pin, Dwl, 3/8 x 2 - 24" & 30"	1
62740	Pin #98296A Exp 3/8, 2	1
62770	Plg Sprg #27107, Short	1
62807	PHS, 5/16-18 x 3/4 - 18"	6
62807	PHS, 5/16-18 x 3/4 - 24"	8
62807	PHS, 5/16-18 x 3/4 - 30"	10

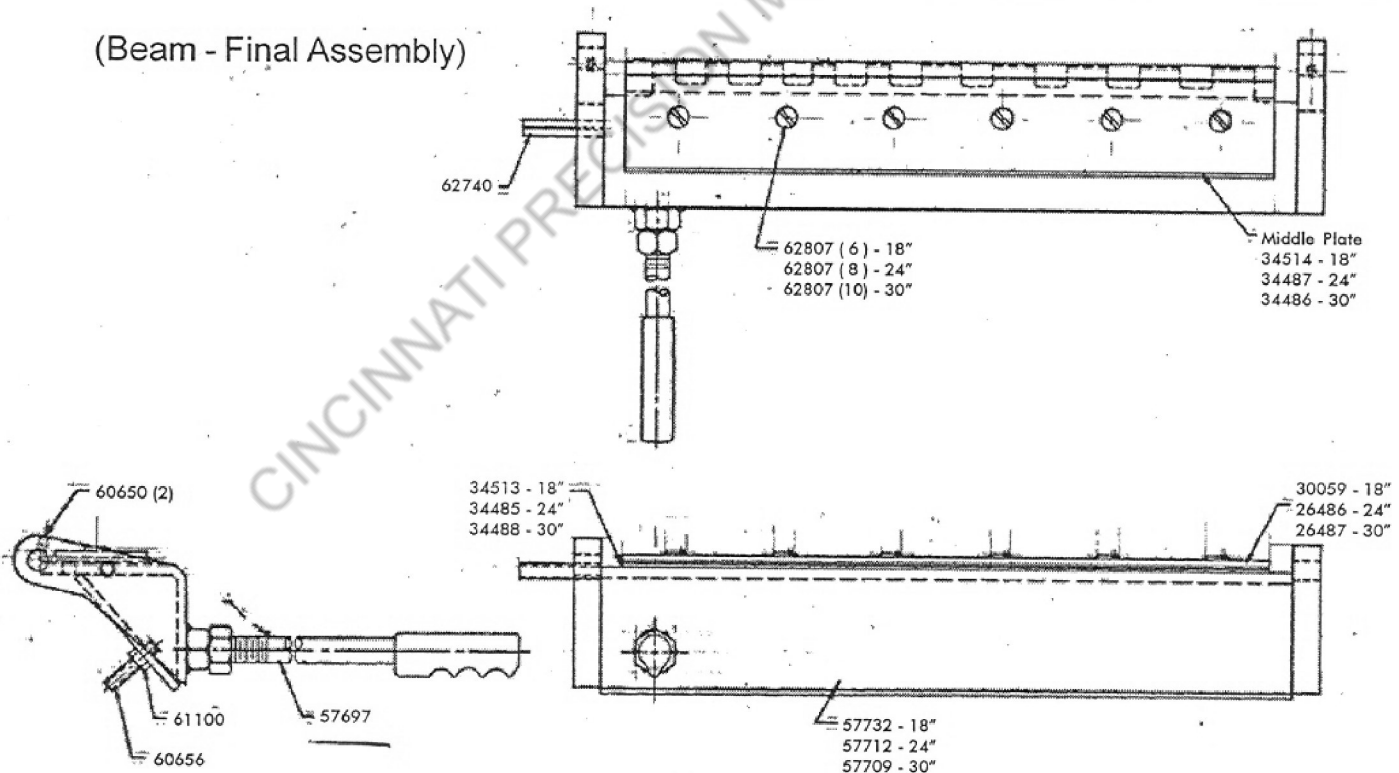


Cleat Bender Illustrated Parts Breakdown

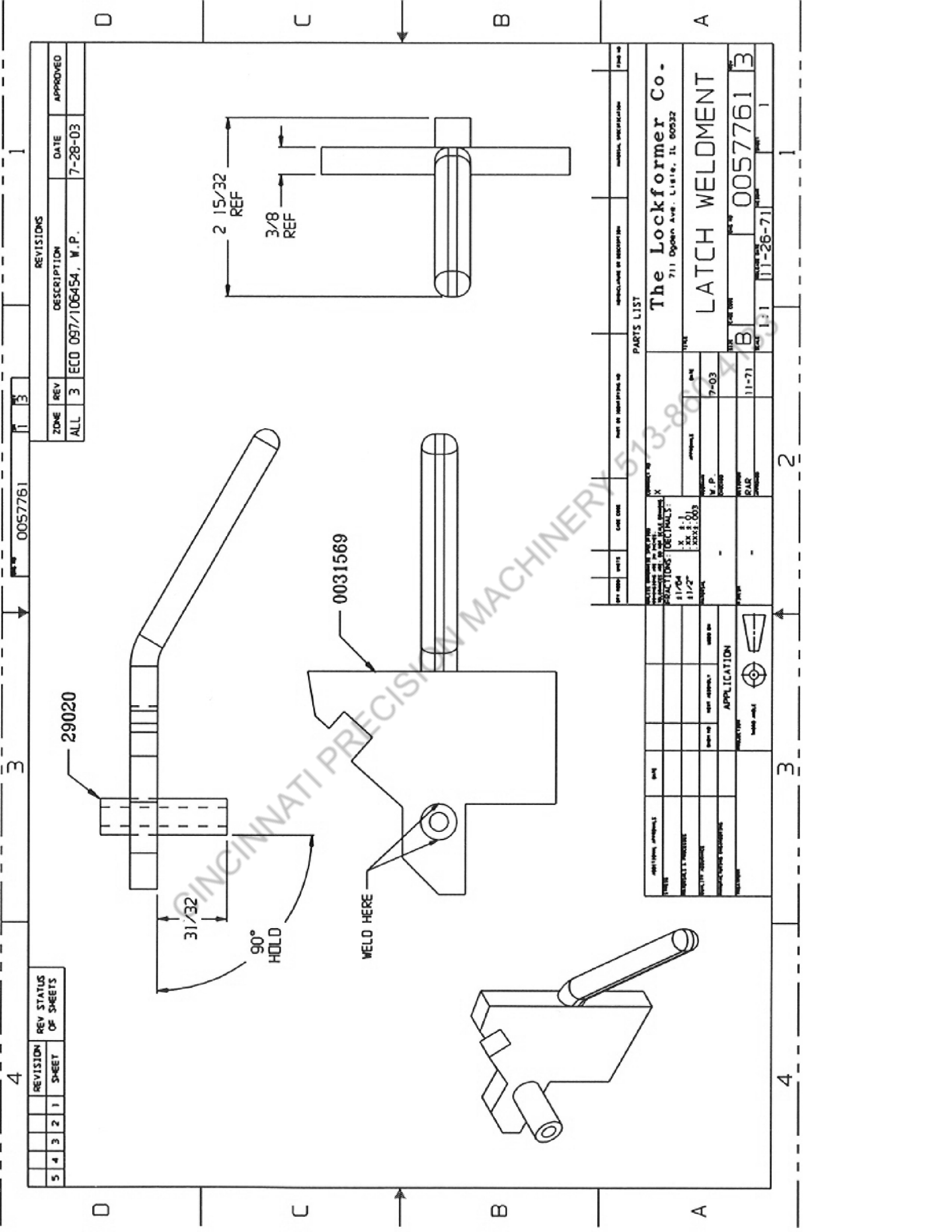
(Bed - Final Assembly)



(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.



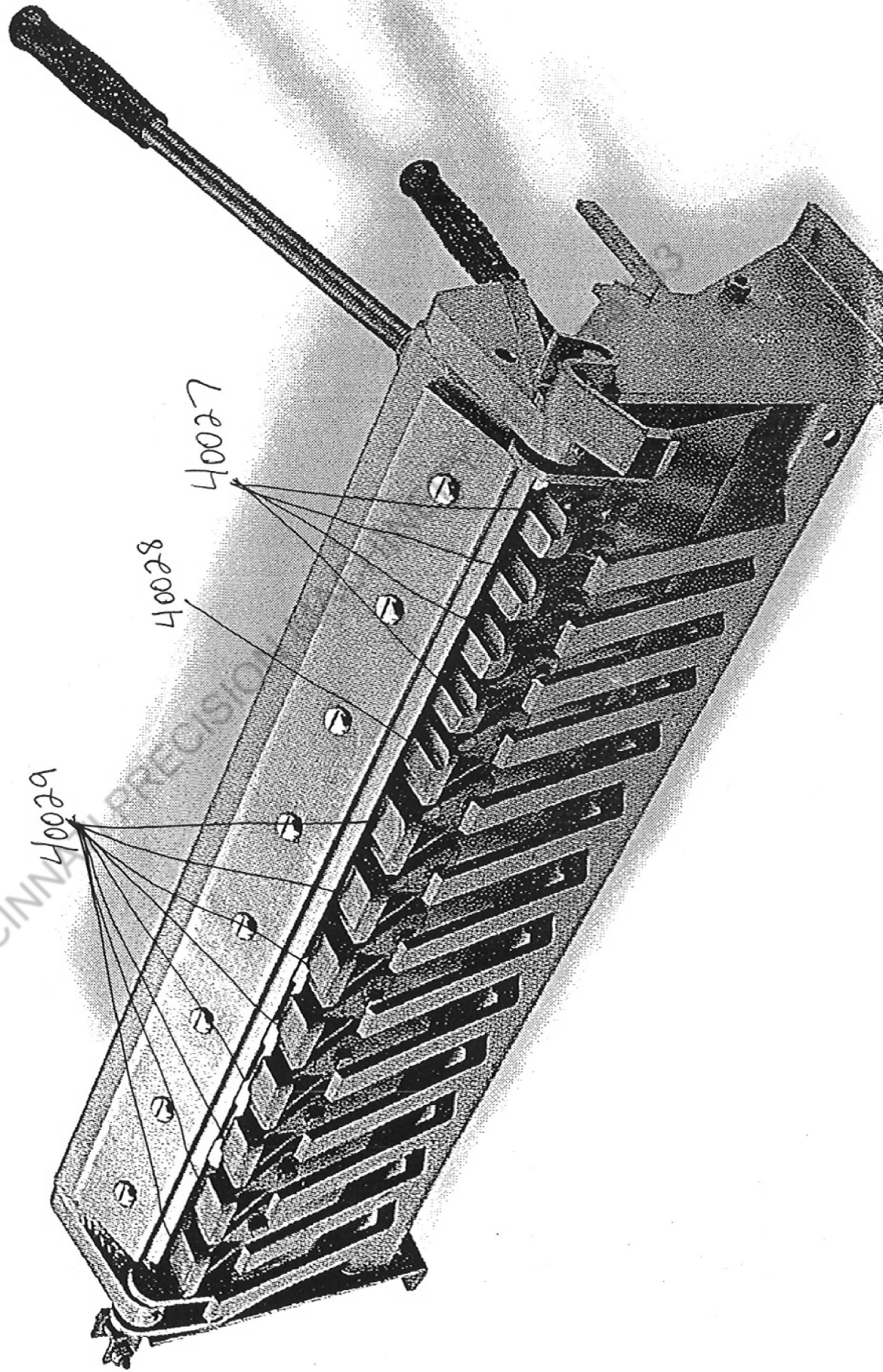
REVISION	REV	STATUS	OF SHEETS
5	4	3	2
1	1	1	1

ZONE	REV	DESCRIPTION	DATE	APPROVED
ALL	3	ECO 097/106454, W.P.	7-28-03	

PARTS LIST	
The Lockformer Co. 711 Ogden Ave. Little, IL 60532	
LATCH WELDMENT	
0057761 3	
11-26-71	

HAND CLEAT BENDER

A rugged tool designed to easily manage the laboring task of forming the drive cleat hem. Choice of lengths: 18", 24" or 30".



**1/2" HEM FOR 9 STATION AUXILIARY SHAFT MACHINES
CAPACITY 20 - 24 GAUGE GALVANIZE**

INSERT DRAWING

INSTRUCTIONS

1. Remove cover and side plate.
2. Mount roll in position on auxiliary shaft, rotate roll insert key, place 3/8" "C" washer in position and lock in place with 3/8" 16 HHCS.
3. Replace side plate.

ENTRANCE GAUGE SETTING

Place a straight edge along outside face of rolls extending over the entrance table. At a point closest to rolls (Y) measure 1 23/32" from the straight edge to gauge bar. At a point furthest to the rolls (X) measure 1 3/4". Lock gauge bar in place.

EXIT STRAIGHTENER

Run piece through the last station about 1 foot and place exit straightener against edge of hem.

STUD NUT ADJUSTMENTS

The 3/8" diameter studs that pass through the machine plates have nuts on top of them. These nuts should be set as required to produce the most satisfactory shape.

SUGGESTED SETTING

Set stud nuts snug, then loosen stud nut 1/2 turn at front of machine. If piece part is tightly formed, loosen stud nut at exit end. If loosely formed, tighten stud nut at exit end

After a satisfactory setting is obtained in all planes, lock entrance bars, exit straightener, etc. firmly into position for production operation and replace cover.

NEW TRIGGER ASSEMBLY

