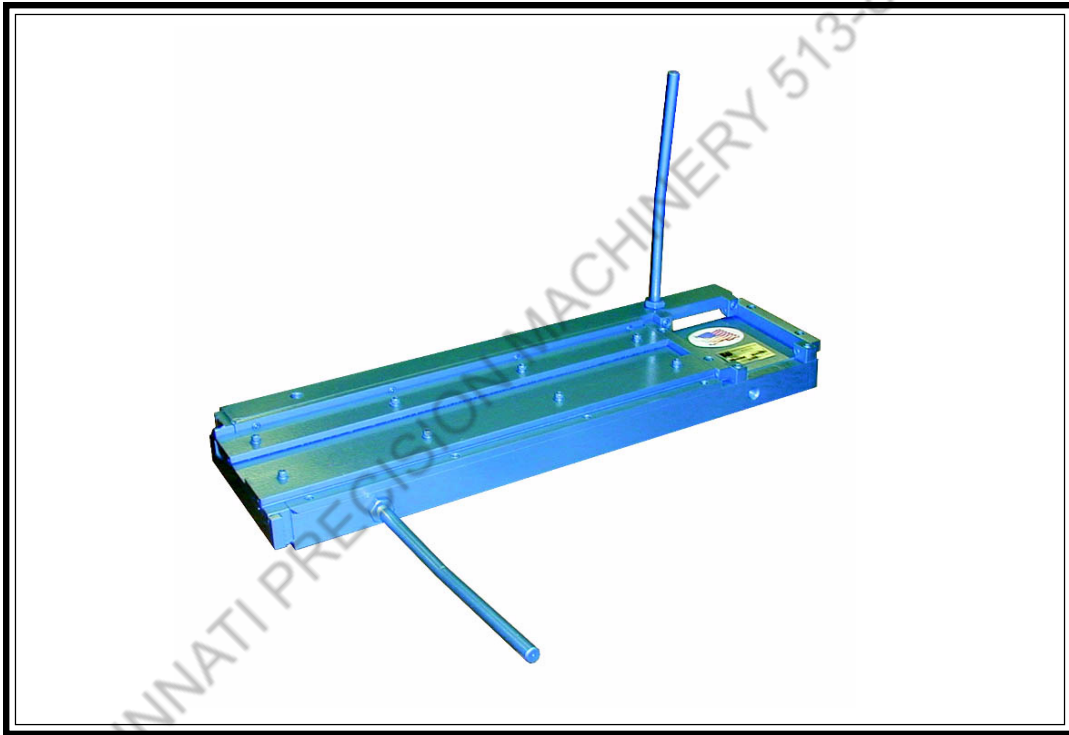


# ROPER WHITNEY CH2420A CHEEK BENDER

INSTRUCTIONS & PARTS DIAGRAM



**ROPER WHITNEY**

2833 HUFFMAN BLVD., ROCKFORD, ILLINOIS 61103-3990 \* 815/962-3011 \* FAX 815/962-2227

**Website:** [www.roperwhitney.com](http://www.roperwhitney.com) \* **Email:** [info@roperwhitney.com](mailto:info@roperwhitney.com)

**ROPER WHITNEY COMPANY**  
**SAFETY RULES**  
**CH2420A CHEEK BENDER**

1. Keep the work area well lighted, clean, neat, and orderly to avoid accidents. Do not use compressed air for cleaning debris or grit from yourself or the machine. Remove debris and grit from machine with a rake or brush - not your hands.
2. Machine to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operator's Manual as well as the warnings and instructions mounted on the machine.
3. Use hoists and cranes to lift heavy machine units, workpieces, or any other load too heavy for one person. Never use a crane, hoist, or other lifting device to lift more than its rated capacity. Be sure loads are balanced.
4. Use safety glasses and required protective tools.
5. Do not wear loose, hanging clothing or jewelry while operating or servicing the machine. Gloves, if worn, should be snug fitting so they won't be snagged by moving equipment.
6. Notify your supervisor whenever you feel there is a hazard involving the equipment or the performance of your job.
7. Report all injuries or illness, regardless of severity, to your supervisor.
8. Do not place speed above safety.
9. Never use a machine or tool for anything other than its intended purpose. Use the proper tool and equipment for the task.
10. Do not remove, paint over, alter, or deface any machine-mounted warning and instruction plates and signs.
11. Do not override the safety features of the equipment.
12. Do not operate the machine in excess of its rated capacity.
13. Beware of protruding machine elements or assemblies. Avoid any pinch-points created by the movement of the machine's components.
14. Inspect the machine before each use to ensure that it is in proper working condition. Check for cracks, chips, burrs, and other evidence of failure.
15. Report any damage to the machine to your supervisor.
16. Use only approved cleaning fluids.

## WARRANTY

All new Roper Whitney machines are sold with a one year limited warranty, on factory defective parts. The warranty is limited to the original user. Roper Whitney at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. Roper Whitney will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to Roper Whitney, at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to Roper Whitney. Removal, reinstallation or replacement parts shall be at purchasers'/user's expense. Failure due to improper use of the machine voids the warranty.

Note: Opening rolls are a consumable and not subject to warranty.

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## CH2420A CHEEK BENDER

Produces bends up to 24 inches. A two-way trunnion, that keeps the bending bar in position at the starting point, also assures perfect bends throughout the entire length. Adjustable plate can be set for bends of 3/16 inch to 5/16 inch widths. Capacity, 20 gauge. (Spacers available for lighter gauge work on request.) Shipping weight, 96 lbs.

### **Specifications:**

Capacity: 20 Ga. Mild Steel x 24

Dimensions: 32" L x 18" W x 7" H (96 lbs.)

### **Mounting Unit:**

Place Cheek Bender unit in a position on the worktable so that sufficient clearance is available for bending the maximum size section. Be sure unit is placed so that open end overhangs the table. When unit is in the most desirable work position, fasten unit to work table or bench with lag screws provided. Place handles into pivot bar holes and lock into place with Allen head set screws.

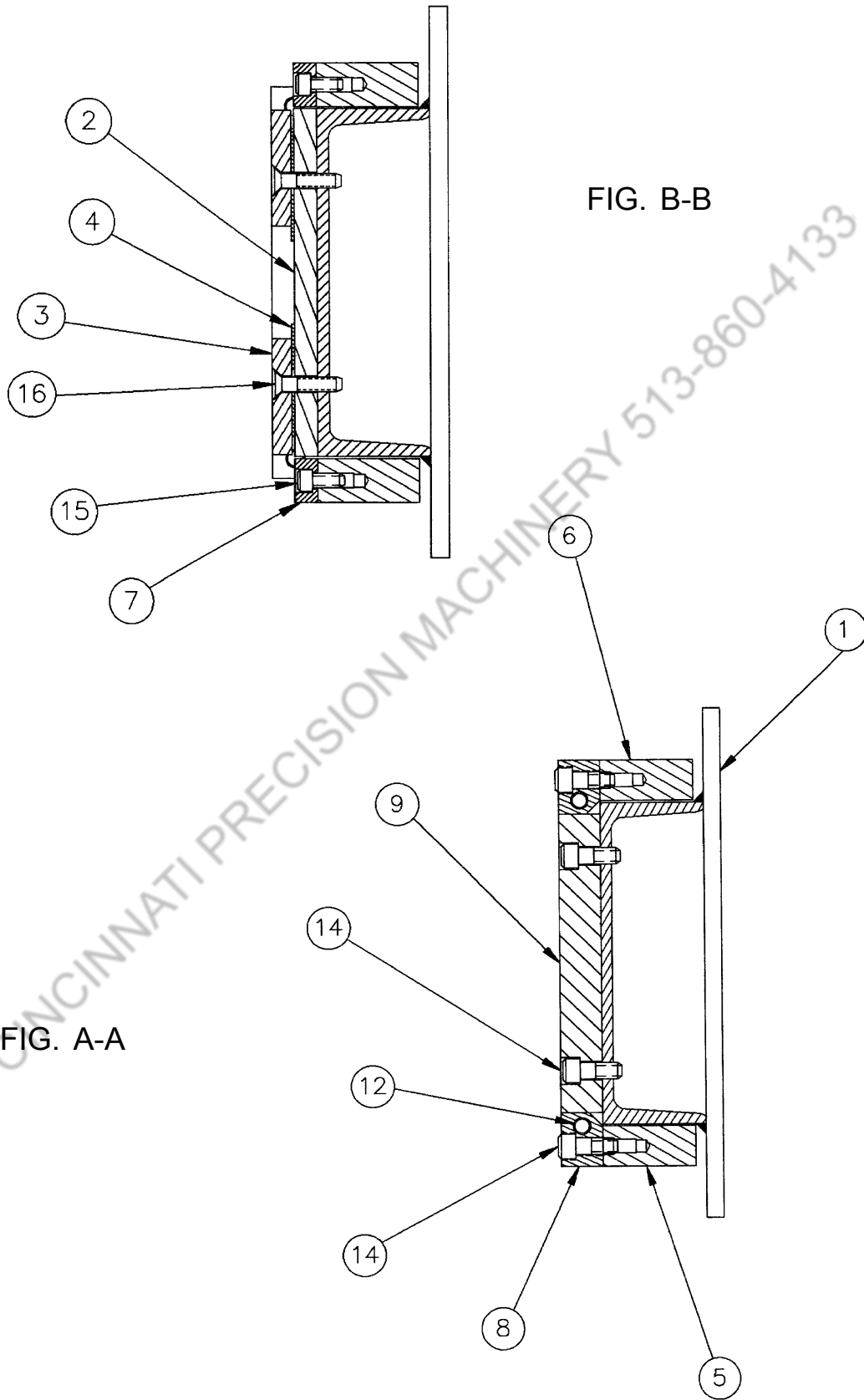
### **To Change Flange Height:**

The shims are set at the factory to run a flange of 3/16 inch. This dimension can be changed in the following manner. Remove the 4 hex head bolts on the top plate and change to desired dimension. The adjustable shim will give a range of 3/16 to 5/16 of an inch. This procedure may be done on left and right top plates, if desired.

### **For Lighter Gauge Work:**

Shims are also available, upon special request, for lighter gauge forming. When ordering shims, please give maximum gauge and range to be run. (Shims for 20 gauge are standard from the factory.)

# CH2420A CHEEK BENDER PARTS IDENTIFICATION



CH2420A CHEEK BENDER  
PARTS IDENTIFICATION

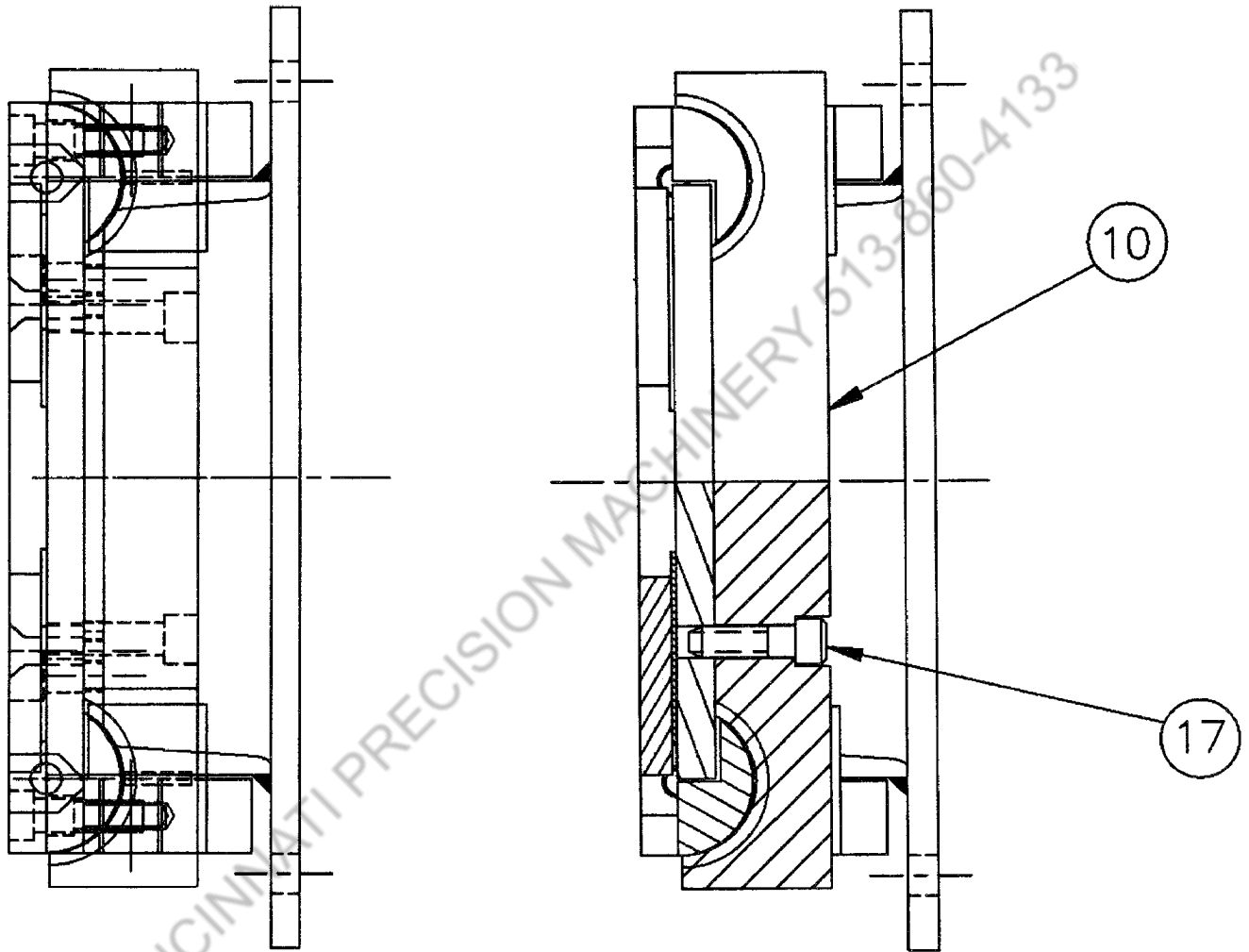
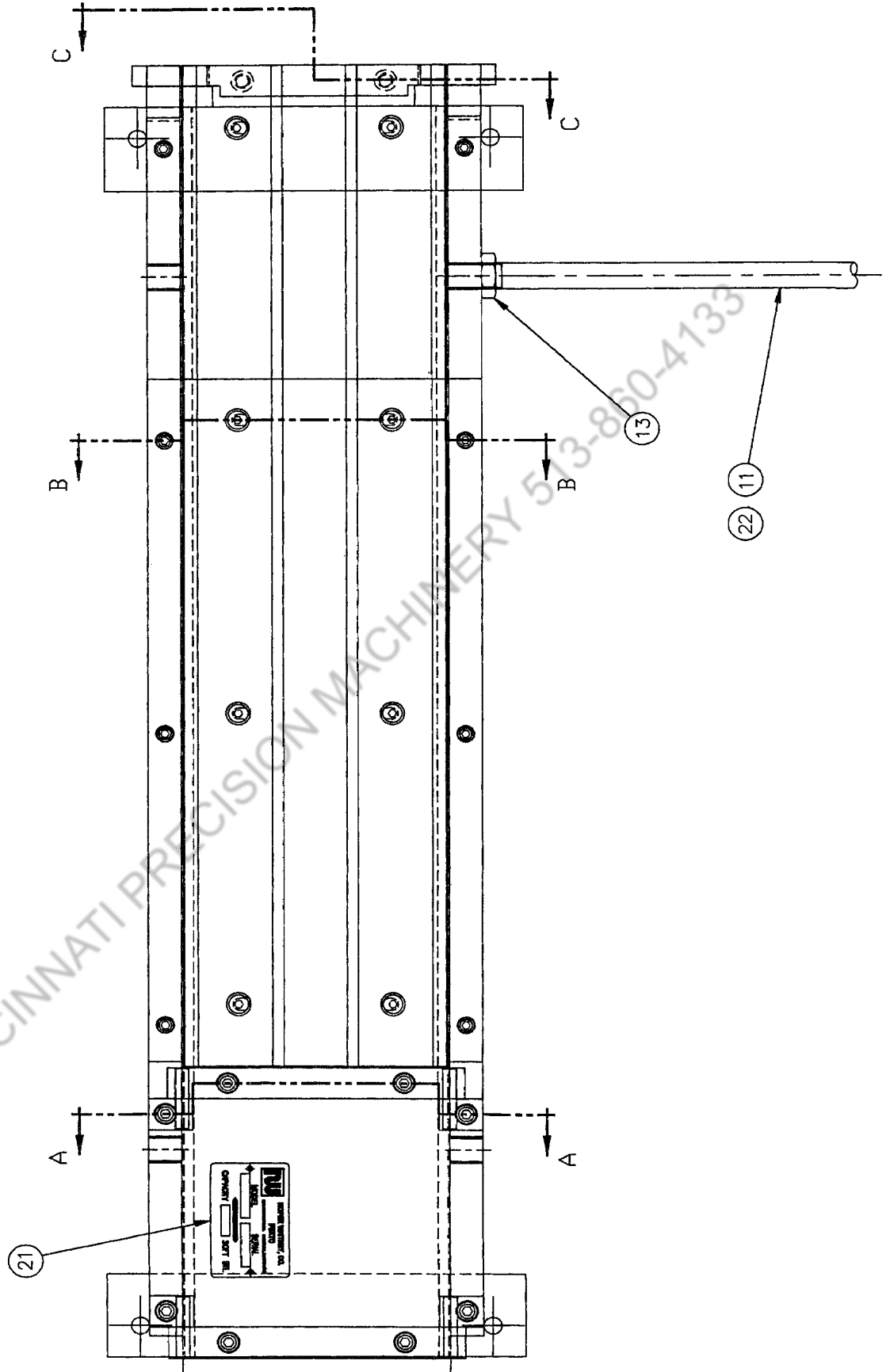


FIG. C-C

# CH2420A CHEEK BENDER PARTS IDENTIFICATION



**CH2420A CHEEK BENDER  
PARTS LIST**

<b>ITEM</b>	<b>PART NUMBER</b>	<b>PART NAME</b>	<b>QTY.</b>
1	768060035	Base	1
2	768060036	Bottom Plate	1
3	768060037	Top Plate	2
4	768720044	Shim	2
5	768030038	Pivot Bar, L. H.	1
6	768030039	Pivot Bar, R. H.	1
7	768030040	Pivot Bar Leaf	2
8	768500041	Pivot Hinge	4
9	768500042	Pivot Hinge Bar	2
10	768060048	Trunnion Plate	1
11	768060014	Handle	2
12	600053332	Dowel Pin 5/16 x 1 1/2	4
13	649023009	Hex Jam Nut 5/8-11	2
14	611012131	SHC Screw 5/16-18 x 3/4	8
15	611012086	SHC Screw 1/4-20 x 1/2	8
16	613012091	FSHC Screw 1/4-20 x 1.0	8
17	611012133	SHC Screw 5/16-18 x 1.0	2
18	600366507	Hex Key Wrench 3/16 (not shown)	1
19	600366510	Hex Key Wrench 5/16 (not shown)	1
20	768000045	Shim Adjustment Tool (not shown)	1
21	600346123	Name Plate, Model and Serial Number	1
22	668356353	Vinyl Grip	2