



# CT152

## 12" Metal Sheet Machine 3 in 1 Shear / Brake / Roll



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# **Important Safety Precautions**

**Pleas read all the instructions before using this tool.**

- 1) Always keep your work area clean. Cluttered areas invite injuries.
- 2) Do not use tools in damp, wet or poorly lit locations. Do not expose to rain.
- 3) Children should be kept away from the work area.
- 4) When not in use, tool should be kept in a dry place to inhibit rust.
- 5) Do not force the tool. It will do the job better and more safely at the rate for which it was intended.
- 6) Do not wear loose clothing or jewelry.
- 7) Wear ANSI approved impact goggles and protective gloves.
- 8) Use clamp or vise to hold the work piece if possible. It is safer than using your hands.
- 9) Keep tools sharp and clean for better and safer performance
- 10) Keep proper footing and balance at all times.
- 11) Serious injury could occur if the tool is tipped over.
- 12) Never operate the machine unless all the guards are functioning properly.
- 13) Get help when lifting tools and materials that are too heavy for you to do yourself.
- 14) When appropriate and whenever possible, use a fork truck or a hoist.

## SPECIFICATIONS

Capacity: 22 Gauges, 12" width

Rollers: 1-1/2"

Die Set Sizes: 4", 3", 2"(x2), 1"

Wire Forming Grooves: 3/32", 1/8", 5/32", 3/16", 7/32" & 1/4"

Weight: 120 lbs

## SAVE THIS MANUAL

You will need this manual for the safety instructions, assembly instructions, operating procedures, parts list, and diagram. Write your invoice number on the inside front cover. Put both your manual and invoice in a safe, dry place for future reference.

## UNPACKING

CT152 is carefully packed in a box and completely assembled. The unpainted surfaces of the machine are coated with rust prevention waxy oil and you will want to remove this after unpacking the machine.

The machine is fully assembled, so before you begin you will need to mount your machine.

**NOTE:** The handle is shipped mounted to the right side of the machine. If you wish to move the handle to the left side of the machine proceed with the following instructions.

Remove one of the handles. Loosen the handle adjustment knobs to take the handle arm out. Remove the arm out from the right side and take it to the left side of the machine. Attach the handle arm and tighten the adjustment knobs and attach the handle.

## **Mounting the machine**

To mount the machine to a workbench, you need 4 bolts, 4 washers and 4 nuts for the four holes located on the base of the machine.

Take the machine and put it on a work surface where you want to mount it. Make sure there is enough space at the back of the machine, so that while operating the machine, there should be enough space to accommodate the material. It should be mounted in such a way that there should be enough space for the handle of the machine to be moved.

Now, mark the holes on the work bench and remove the machine. Take a drill and drill the holes on the work surface. Place the machine on the work surface and align base holes to the work surface holes. Take the nuts, washers, and bolts and mount the machine to the work bench.

# **OPERATIONS**

## **Shearing**

To adjust the position of back measurement assembly to your desired position loosen the knobs and move the assembly forward and backward using hand wheel. Once the assembly reaches to your desired position, tighten the knobs. If you desire a 90 degree angle, attach the guide to the left side of the work surface with the help of two hex key screws. Now, rotate the handle assembly to raise the upper cutting die all the way up and slide the metal sheet between the braking die and the work surface. Now, crank down the handle to shear the metal sheet.

## **Pressing**

Slide plate brackets of the press plate assembly into the receiver holes of the upper cutting die. Note that the press plate should be facing down. Place the work piece so that it is centered under the press plate. Use the handle assembly to press the work piece.

## **Braking**

For precision braking from 2"-10" (lengthwise), first attach the back measurement assembly to the receiver holes in the back of the crossbeam. To adjust the position of back measurement assembly to your desired position loosen the knobs and move the assembly forward and backward using hand wheel. Once the assembly reaches to your desired position, tighten the knobs. Raise the cross beam to the highest position with the help of the handle. Now, insert the metal sheet between the upper and lower braking dies and apply enough amount of force to rotate the handle and bend the sheet.

If you want to bend only some parts of the metal sheet, remove the bolts holding the upper braking dies. You can add or remove dies as you need. To achieve your desired result, cut between the portion of the material that you want to bend and the portion that you want to remain straight.

## **Rolling**

Remove the cover that is provided on the roller and loosen the rear roll bar by loosening the adjustment knobs. Now, insert the edge of the metal sheet between the upper and lower roll bars and then tighten the roll bar gap adjustment keys until the roll bars are barely snug against the metal sheet. Advance the adjustment knobs and tighten the roll. The tighter the roll, the more the knobs must be advanced. Move the handle assembly and the material will feed itself through the rollers as you rotate the handle.

## **Wire Rolling**

- 1) Use the proper groove in the upper roll bar depending upon the gauge of the wire being rolled.
- 2) Follow the procedures as listed above in "Rolling"

# **ADJUSTMENTS**

## **Shear Bow**

During operation, the shear frame may come out of alignment causing uneven cuts. To correct this problem, tighten or loosen the bolt attached to the shear frame adjustment bar as necessary. When you tighten the bolts, the ends of the shear will bow out while loosening them, the ends of the shear will bow in.

## **Shear Alignment**

First lower the shear assembly all the way and see if the two shears are even with each other. If the lower shear is not aligned with the upper shear then you need to adjust the work surface. Loosen the bolts that secure the work surface to the frames and tighten or loosen either of the adjustment screws on the front, underside of the work surface as necessary to make the two shears meet properly.

## **Upper Braking Dies**

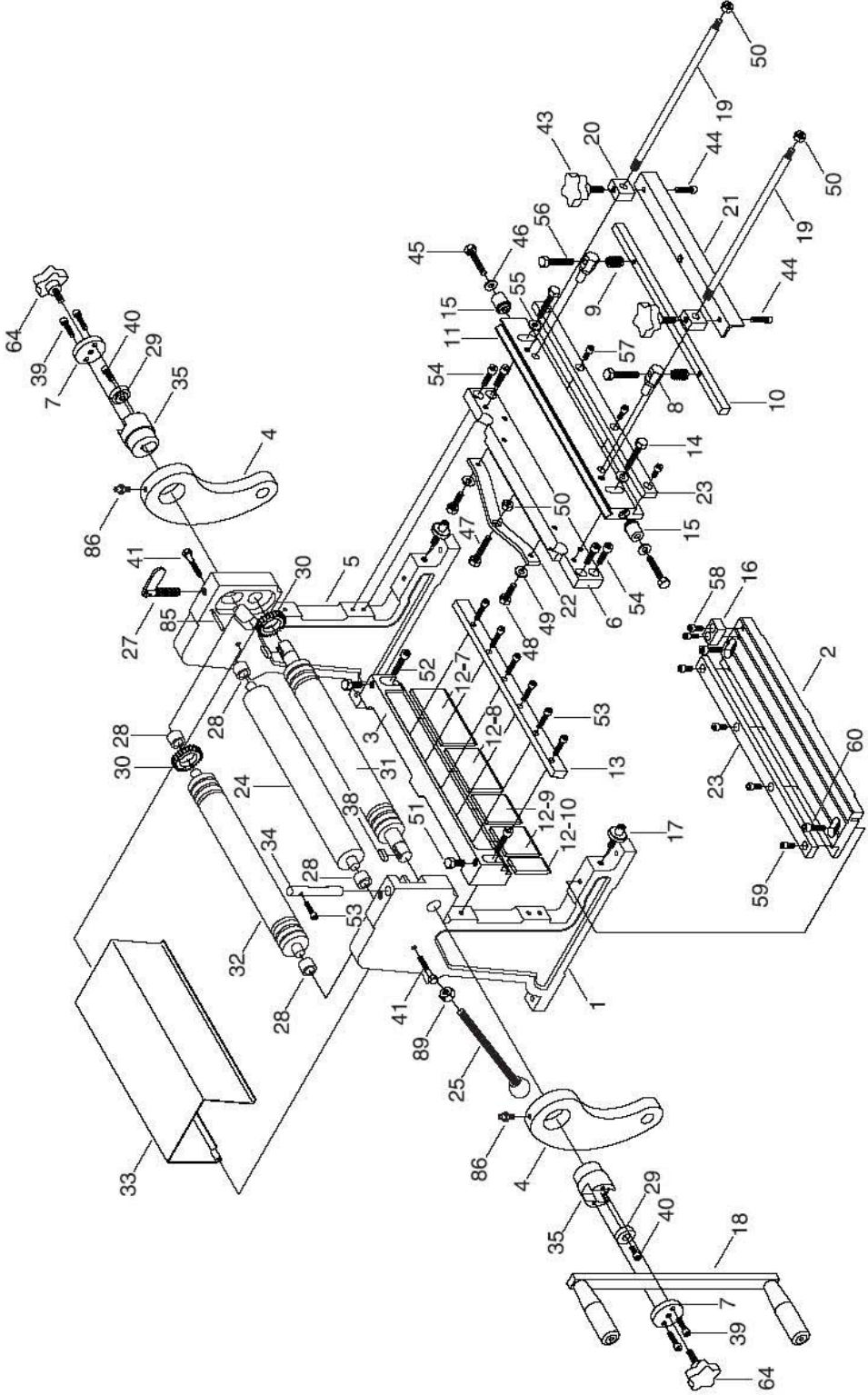
The upper dies may become uneven .The best way to correct this problem is to cut a gauge from hard wood .Make sure the gauge is even all of the way across its length. Raise the crossbeam all the way and place the hardwood gauge underneath the dies. Loosen the bolts that hold the upper braking die bracket in place and allow the dies to drop so that they contact the block and tighten the bolts securing the upper braking dies

# **LUBRICATION**

- 1) Grease the cranking arms as necessary using a grease gun on the provided grease fittings.
- 2) Grease the sliding areas as necessary.

# CT152-12" Metal Sheet Machine

## PARTS BREAKDOWN





# CT152-12” Metal Sheet Machine

## PARTS LIST

REF	PART #	DESCRIPTION
1	P6089001	LEFT WALL
2	P6089002	WORK BENCH
3	P6089003	CROSSBEAM
4	P6089004	CRANK ARM
5	P6089005	RIGHT WALL
6	P6089006	REAR FRAME
7	P6089007	COVER
8	P6089008	PRESS PLATE BRACKET
9	P6089009	SPRING
10	P6089010	PRESSING PLATE
11	P6089011	MOVING CUTTER PLATE
12-7	P6089012-7	UPPER BREAKING DIE 4"
12-8	P6089012-8	UPPER BREAKING DIE 3"
12-9	P6089012-9	UPPER BREAKING DIE 2"
12-10	P6089012-10	UPPER BREAKING DIE 1"
13	P6089013	DIE CLAMPING PLATE
14	PB15M	HEX BOLT M8-1.25 X 40
15	P6089015	ARM ROLLING WHEEL
16	P6089016	POSITIONER
17	P6089017	ADJUSTABLE BOLT
18	P6089018	HANDLE ARM
19	P6089019	THREADED ROD
20	P6089020	POSITIONING PIECE
21	P6089021	POSITIONING PLATE
22	P6089022	SUPPORTING PLATE
23	P6089023	CUTTER
24	P6089024	BACK PRESSING ROLL
25	P6089025	LOCK SCREW
27	P6089027	ADJUSTABLE BOLT
28	P6089028	BUSHING
29	P6089029	PRESS COVER
30	P6089030	GEAR

REF	PART #	DESCRIPTION
31	P6089031	LOWER PRESSING ROLL
32	P6089032	UPPER PRESSING ROLL
33	P6089033	PROTECTING COVER
34	P6089034	ROTATION SHAFT
35	P6089035	ECCENTRIC SHAFT
38	PK07M	KEY 6 X 6 X 20
39	PSB01M	CAP SCREW M6-1.0 X 16
40	P6089040	CAP SCREW M6-1.0 X 8
41	P6089041	HEX BOLT M6-1.0 X 44
43	P6089043	KNOB
44	P6089044	CAP SCREW M6-1.0 X 8
45	PB15M	HEX BOLT M8-1.25 X 40
46	PW01M	FLAT WASHER 8MM
47	PB15M	HEX BOLT M8-1.25 X 40
48	PB19M	HEX BOLT M8-1.25 X 24
49	PW01M	FLAT WASHER 8MM
50	PN03M	HEX NUT M8-1.25
51	P6089051	HEX BOLT M10-1.5 X 16
52	PSB13M	CAP SCREW M8-1.25 X 30
53	P6089053	CAP SCREW M6-1.0 X 24
54	PSB11M	CAP SCREW M8-1.25 X 16
55	PW01M	FLAT WASHER 8MM
56	P6089056	HEX BOLT M6-1.0 X 45
57	PSB04M	CAP SCREW M6-1.0 X 10
58	PSB04M	CAP SCREW M6-1.0 X 10
59	PSB04M	CAP SCREW M6-1.0 X 10
60	PSB14M	CAP SCREW M8-1.25 X 20
64	P6089064	HANDLE ADJUST KNOB
85	P6089085	PIN
86	P6089086	GREASE FITTING 5/16"X3/16"
89	PN02M	HEX NUT 10MM