



CT153

12" Box and Pan Brake

User Manual



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

Width:	12"
Thickness:	20 Gauges
Fingers:	5
Brake Angle:	0 to 135 Degrees
Weight:	20 kgs

UNPACKING

CT153 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 comes fully assembled, so before you begin you need to mount your machine.

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 when operating the machine, there should be enough space to accommodate the material. The box and pan brake should be mounted on the bench in such a way that when looking at it, the handle of the machine should be on the right and there should be enough space for it to move.

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 the box and pan brake base holes to the work surface holes. Take the nuts, washers, and bolts and mount the machine to the work bench.

ADJUSTMENTS

Fingers

The box and pan brake has got 5 fingers. To adjust these fingers you need to loosen the cap-screws on the fingers first. Then push the fingers up into the hold down assembly tightly and tighten the screws back.

When tightening the cap-screws, make sure the fingers are held square to the hold down and parallel to the apron and then tighten the cap-screws. Failure to do so may cause problems while operating the machine or poor result.



- A. Hold Down Assembly
- B. Hold Down Stop
- C. Fingers
- D. Finger Knife edge
- E. Apron Face
- F. Apron

Metal Thickness

To adjust the machine for the metal thickness, loosen the screws at the back of the hold down assembly on both sides. Now you should move the hold down assembly by rotating the eccentric at the back of the hold down assembly which will make the fingers move away from the apron edge.

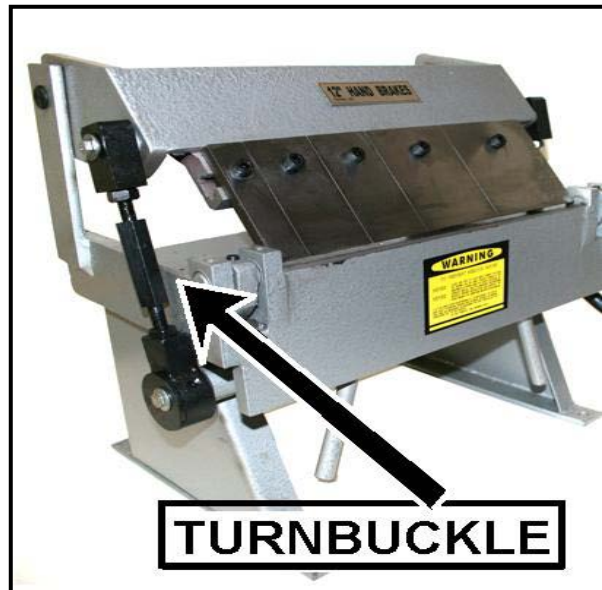


Figure-2

The distance between the fingers edge and the apron edge must be 1 1/2 times or more thick than the material thickness. It should not be less than 1 1/2 or it will cause damage to the finger knife edge.

Turn the hex nuts located on the turnbuckle on both sides of the machine. Use the turnbuckle to adjust the hold down assembly for metal thickness. The holding pressure should be strong enough to hold the material and make sure the material does not move while bending. But it should not be so tight to make it hard to rotate the hold down assembly handle. Now, tighten the hex nuts on both sides of machine. See Figure-2.

OPERATIONS

Bending Metal

To bend metal, open the hold down assembly by lifting up the hold down handle. Put the work metal sheet between the fingers and the apron edge. Align the fingers to bend the metal sheet and move the hold down handle to hold the work-piece. Do not force the hold down handle. The pressure should be tight enough to just hold the work piece and do not let the work piece to move while bending it.

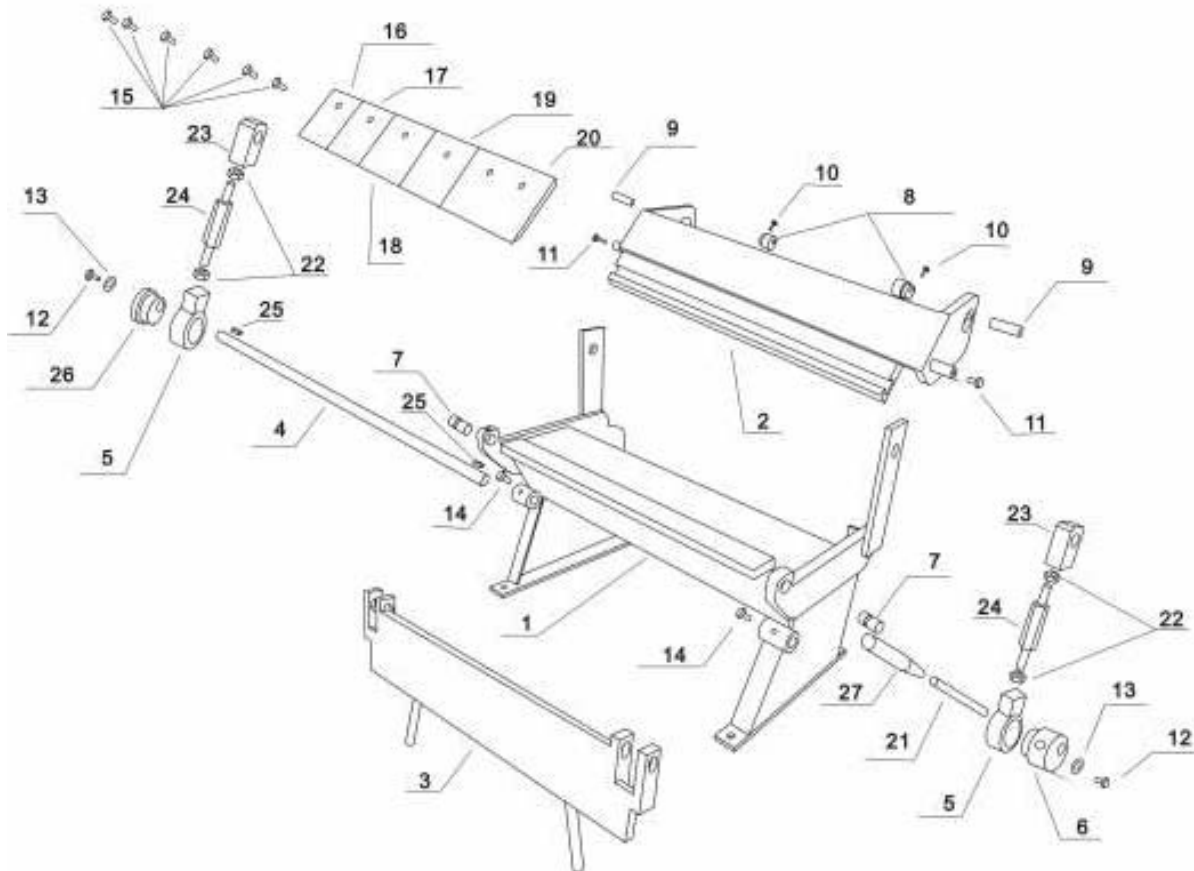
Now, bend the metal by lifting up the apron handle with both hands. Once your work piece reaches to your desired angle, lift up the hold down handle to open the hold down assembly and then remove the bent work-piece.

To bend only certain portions of your work-piece, simply loosen the bolts that hold the fingers and remove or add fingers as desired.

LUBRICATION

1. Apply a small amount of the oil or grease to the sliding areas.
2. To keep the fingers free from rust, keep a light coat of oil on them.

CT153-12" BOX & PAN BRAKE PARTS LIST



1. BODY	10.M8X15 BLOT	19.3'' BLADE
2. BLADE BODY	11.M6X10 BLOT	20.4'' BLADE
3. BENDING LEAF	12.M6X10 BLOT	21.HANDLE
4. TRANSMISSION SHAFT	13.76 WASHER	22.M8 SCREW
5. RING	14.M6X10 BLOT	23.HANDLE COVER
6. RIGHT ECCENTRIC	15.M8X30 BLOT	24.PULL BLOT
7. HINGE SHAFT	16.1'' BLADE	25.4MM FLAT WASHER
8. ECCENTRIC	17.2'' BLADE	26.ECCENTRIC
9. ECCENTRIC SHAFT	18.2'' BLADE	27.PLASTIC HANDLE



WARRANTY

CRAFTEX 2 YEAR LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **two years** for parts and 90 days for labour (unless specified otherwise), to the original purchaser from the date of purchase but does not apply to malfunctions arising directly or indirectly from misuse, abuse, improper installation or assembly, negligence, accidents, repairs or alterations or lack of maintenance.

Proof of purchase is necessary.

All warranty claims are subject to inspection of such products or part thereof and Craftex reserves the right to inspect any returned item before a refund or replacement may be issued.

This warranty shall not apply to consumable products such as blades, bits, belts, cutters, chisels, punches etceteras.

Craftex shall in no event be liable for injuries, accidental or otherwise, death to persons or damage to property or for incidental contingent, special or consequential damages arising from the use of our products.

RETURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a Craftex product, you must visit the appropriate Busy Bee Tools showroom or call 1-800-461-BUSY. Craftex is a brand of equipment that is exclusive to Busy Bee Tools.

For replacement parts directly from Busy Bee Tools, for this machine, please call 1-800-461-BUSY (2879), and have your credit card and part number handy.

- All returned merchandise will be subject to a minimum charge of 15% for re-stocking and handling with the following qualifications.
- Returns must be pre-authorized by us in writing.
- We do not accept *collect* shipments.
- Items returned for warranty purposes must be insured and shipped pre-paid to the nearest warehouse
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an un-used condition and shipped in their original packaging a letter explaining your reason for the return. Incurred shipping and handling charges are not refundable.
- Busy Bee will repair or replace the item at our discretion and subject to our inspection.
- Repaired or replaced items will be returned to you pre-paid by our choice of carriers.
- Busy Bee reserves the right to refuse reimbursement or repairs or replacement if a third party without our prior authorization has carried out repairs to the item.
- Repairs made by Busy Bee are warranted for 30 days on parts and labor.
- Any unforeseen repair charges will be reported to you for acceptance prior to making the repairs.
- The Busy Bee Parts & Service Departments are fully equipped to do repairs on all products purchased from us with the exception of some products that require the return to their authorized repair depots. A Busy Bee representative will provide you with the necessary information to have this done.

For faster service it is advisable to contact the nearest Busy Bee location for parts availability prior to bringing your product in for repairs.