



MODEL CX818N
48" BOX AND PAN BRAKE
USER MANUAL



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CX818N SAFETY INSTRUCTIONS

- Do not exceed the capacities of the machines. Overloading it, can cause damage to the machine and the work-piece.
- Only use this machine for the purpose it is designed. Do not modify for a purpose not intended by the manufacturer.
- Always keep your hands away from the pinching points of machine.
- Always wear gloves, safety glasses and safety shoes when operating this machine.
- Always check your machine for any damaged punch, loose bolts or nuts and any other unsafe condition before operation.
- Always have a secure footing when using this machine.
- Always keep the knives/cutters properly adjusted and sharp.
- Always keep children away from the work area.
- Make sure all guards are in place and in working order before operation.
- Do not use and store this machine in rainy or wet locations. Always keep your work area clean and dry.
- Always read and understand the instructions given in this manual before operating your machine. Failure to do so could result in serious personal injury and damage to the machine.

WARNING!

The safety instructions given in this manual can not be complete because the environment in every shop is different. Always consider your safety first as it applies to your individual working conditions.



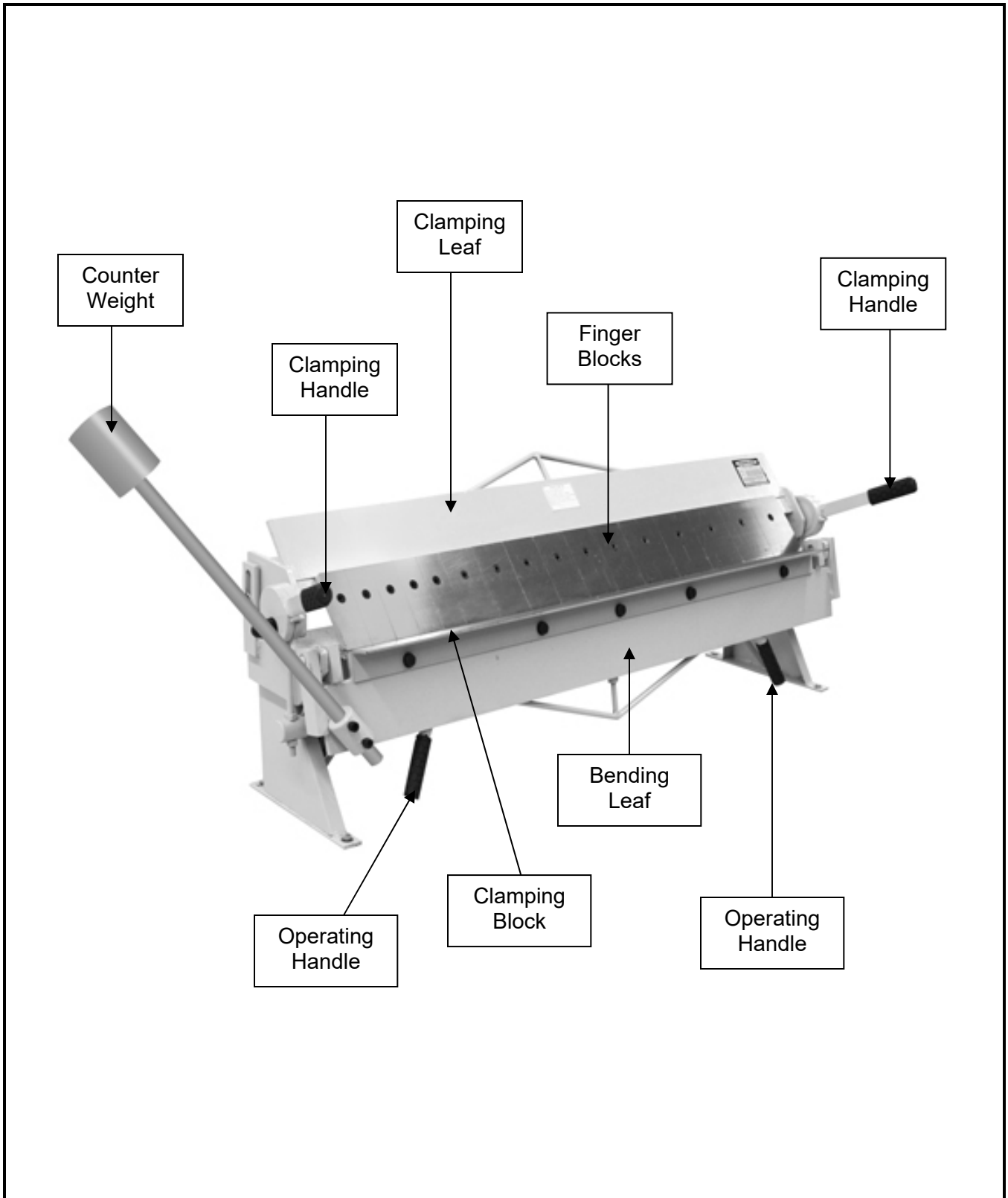
FEATURES

MODEL CX818N - 48" BOX & PAN BRAKE

As part of the growing line of Crafter CX-Series machineries, we are proud to offer the CX818N a 48" Box and Pan Brake. By following the instructions and procedures laid out in this user manual, you will receive years of excellent service and satisfaction. The CX818N is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

- ❖ Removable Fingers 16pcs (2", 3", 4" Width)
- ❖ Removeable Nose Bar 48" Wide
- ❖ Maximum Lift 1-1/2"
- ❖ Adjustable Counter Weight Yes
- ❖ Gross Weight 155 Kg
- ❖ Carton Size 17" x 26" x 62"

CX818N PHYSICAL FEATURES



UNPACKING

The CX818N is properly packaged in a carton for safe transportation. When unpacking, carefully inspect the carton and ensure that nothing has been damaged during transit.

INVENTORY

The box and pan brake comes with the following:

CONTENTS	QTY
A. Box and Pan Brake	1
B. Counterweight	1
C. Hex Wrenches.....	2
D. Wrench.....	1

While doing the inventory if you can not find any parts, check if the part is already installed on the machine.

CLEAN UP

The unpainted surfaces of the machine is coated with a waxy oil to protect them from corrosion. Remove the oil coating with a solvent cleaner before operating the machine.

MOUNTING

The CX818N features four pre-drilled holes on its base which allow mounting it to the workbench.

There are two ways to mount the box and pan brake onto the workbench; through mount and direct mount.

"Through Mount" is the strongest mounting option where the holes are drilled all the way through the workbench. Hex bolts,

washers and hex nuts are used to secure the machine to the workbench as shown in figure-1.

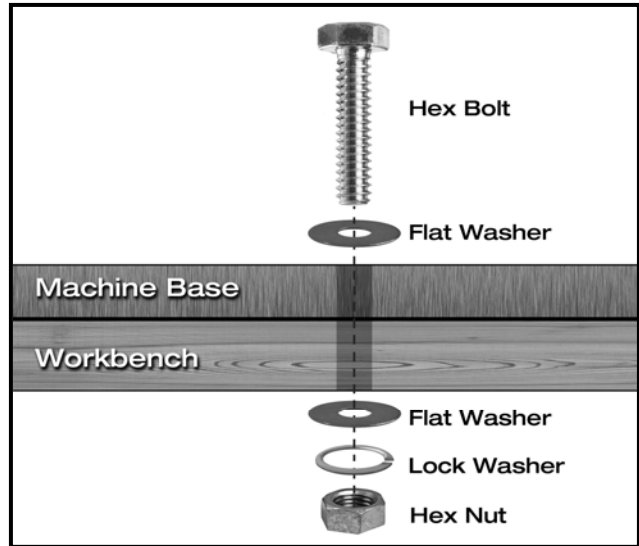


Figure-1 Through mount

"Direct Mount" is to simply secure the machine to the workbench using lag screws. See figure-2.

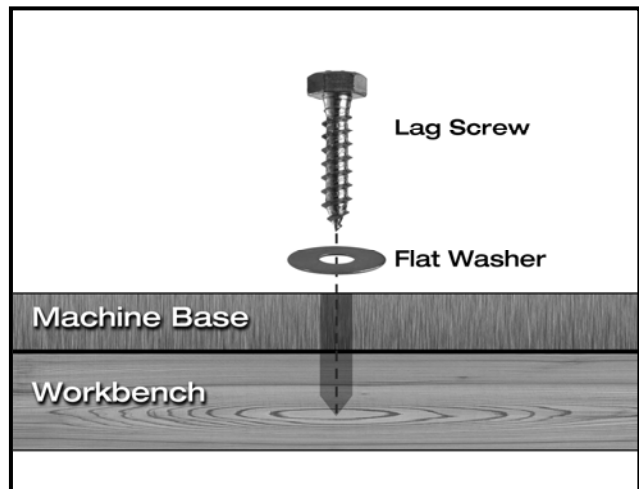


Figure-2 Direct mount

Place the box and pan brake on the workbench and use the holes on the base as a guide for drilling and securing it to the workbench.

INSTALLING THE COUNTERWEIGHT

The counterweight is attached to the left hand end of the machine and secured by tightening the cap screws. See figure-3.

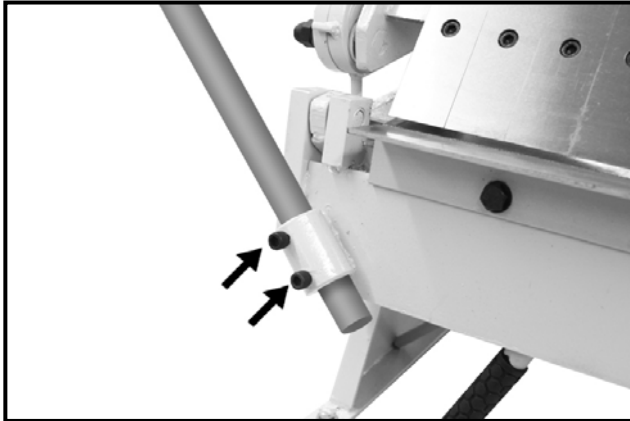


Figure-3 Removing finger blocks

CAPACITY

The CX818N is designed to fold sheet metal into pans, boxes and trays. It can bend 16 gauge miles steel.

The fingers on the box and pan brake can be put together in a variety of combinations to make bends of different sizes.

ADJUSTING SETBACK

Set back is the distance from the forward edge of the fingers to the edge of the bending leaf.

The set back on the CX818N is set to achieve either sharp or round bends depending on the sheet metal gauge. Normally the setback is adjusted at least 1.5 to 2 times the thickness of the work-piece. See figure-4.

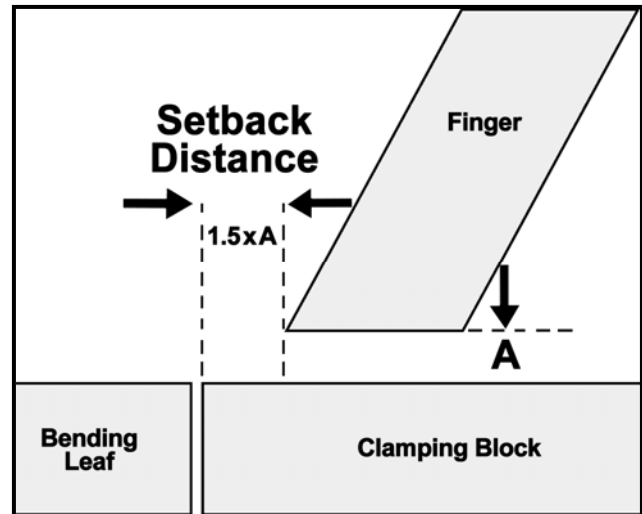


Figure-4 Setback distance

TO ADJUST THE SET BACK:

Raise the clamping leaf about an inch.

Loosen the cap screw shown in figure-5.

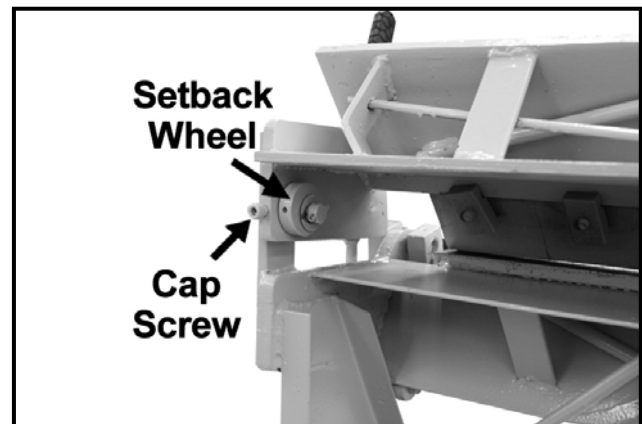


Figure-5 Cap screw and set back wheel

Rotate the setback adjusting wheels at the back of the machine. See figure-6. Turning the wheels one way will cause the clamping leaf to move forward. Turning it the other way will cause the clamping leaf to move backward. Turning the adjusting wheels a full turn will bring the clamping leaf to its original position.

In case you find it hard to turn the wheels with your hand, use a screw driver. Simply

insert the screw driver into the hole on the edge of the wheel to gain leverage. Lower the clamp leaf back over the clamping block and check the setback position.

SPACING FINGERS

The fingers can be spaced apart for clearance when making pans or boxes. This requires removing one or more of the fingers, so that you can space the others to match the width of your pan or box.

TO SPACE THE FINGERS APART:

Loosen the cap screws from each of the fingers you decide to remove.

Remove the fingers, as shown in figure-5 and set them aside.

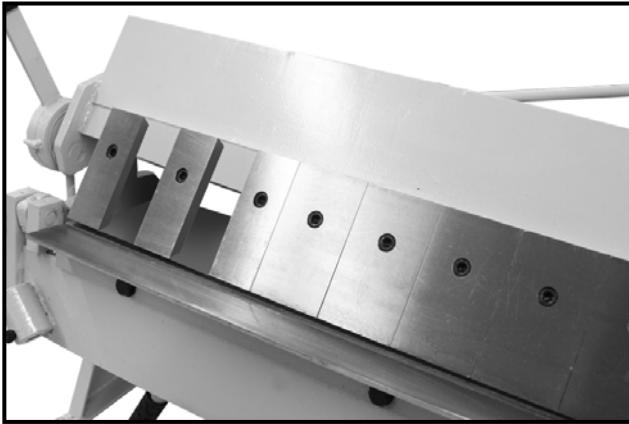


Figure-6 Spacing fingers

Align the remaining fingers and secure them by tightening the cap screws.

ALIGNING FINGERS

It is important to align the fingers properly for accurate results.

TO ALIGN A FINGER:

Lower the clamping leaf with the two clamping handles until the fingers appear to touch the clamping block as evenly as possible.

Look at the edge of each finger and determine if any of fingers are out of adjustment. See figure-7.

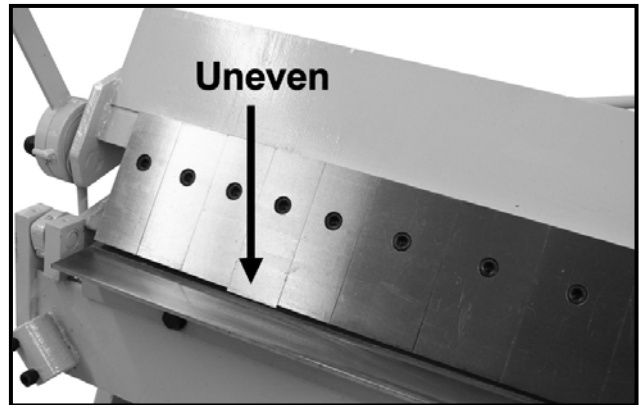


Figure-7 Uneven finger

Loosen the cap screw on the misaligned finger and adjust it so that it is aligned.

Tighten the cap screw to secure the finger in position.

CLAMPING PRESSURE ADJUSTMENT

The clamping pressure is adjusted for different work-piece thicknesses. When the clamping pressure is adjusted properly, it will have medium resistance at the clamp handles and will lock the work-piece into position easily. The pressure is adjusted by turning the clamping pressure adjustment nuts, located on both ends of the box and pan brake. See figure-8.

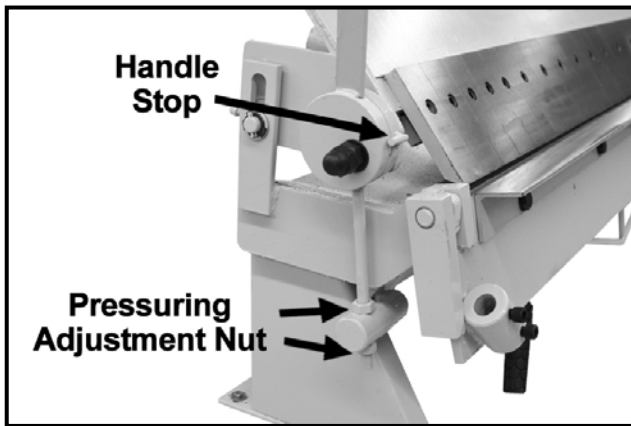


Figure-8 Clamping pressure adjustment nuts

TO ADJUST THE CLAMPING PRESSURE:

Lower the bending leaf onto the work-piece. It is good if the work-piece is the same width as the box and pan brake. If it is not, position two pieces of metal the same thickness as the work-piece on each end.

When the fingers are slightly touching the work-piece, the clamping handle on the left end of the machine should be at 2 o'clock position when viewed from that end. The clamping handle at the other end should be in the same relative position, or 10 o'clock when viewed from the end.

Loosen the upper and lower nuts shown in figure-8 and adjust both up or down until

the clamp handles at in the 2:00 and 10:00 position when the clamping leaf just touches the work-piece.

Tighten the upper nut to ensure that position is maintained.

Make sure the clamping pressure is even on both ends of the machine.

LUBRICATION

You will need to lubricate some areas on the CX818N to keep the machine in peak performance condition and prevent the unpainted cast iron surfaces from rusting.

Lubricate the clamping leaf with a few drops of oil everyday depending on usage. See figure-9 for lubrication points.

Lubricate the bending leaf hinge by applying a few drops of oil everyday depending on use.

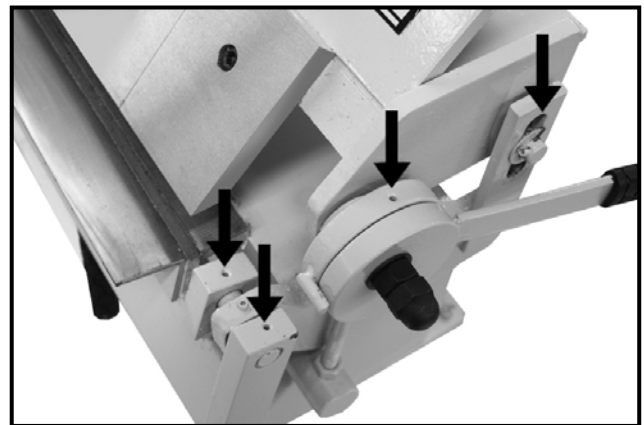
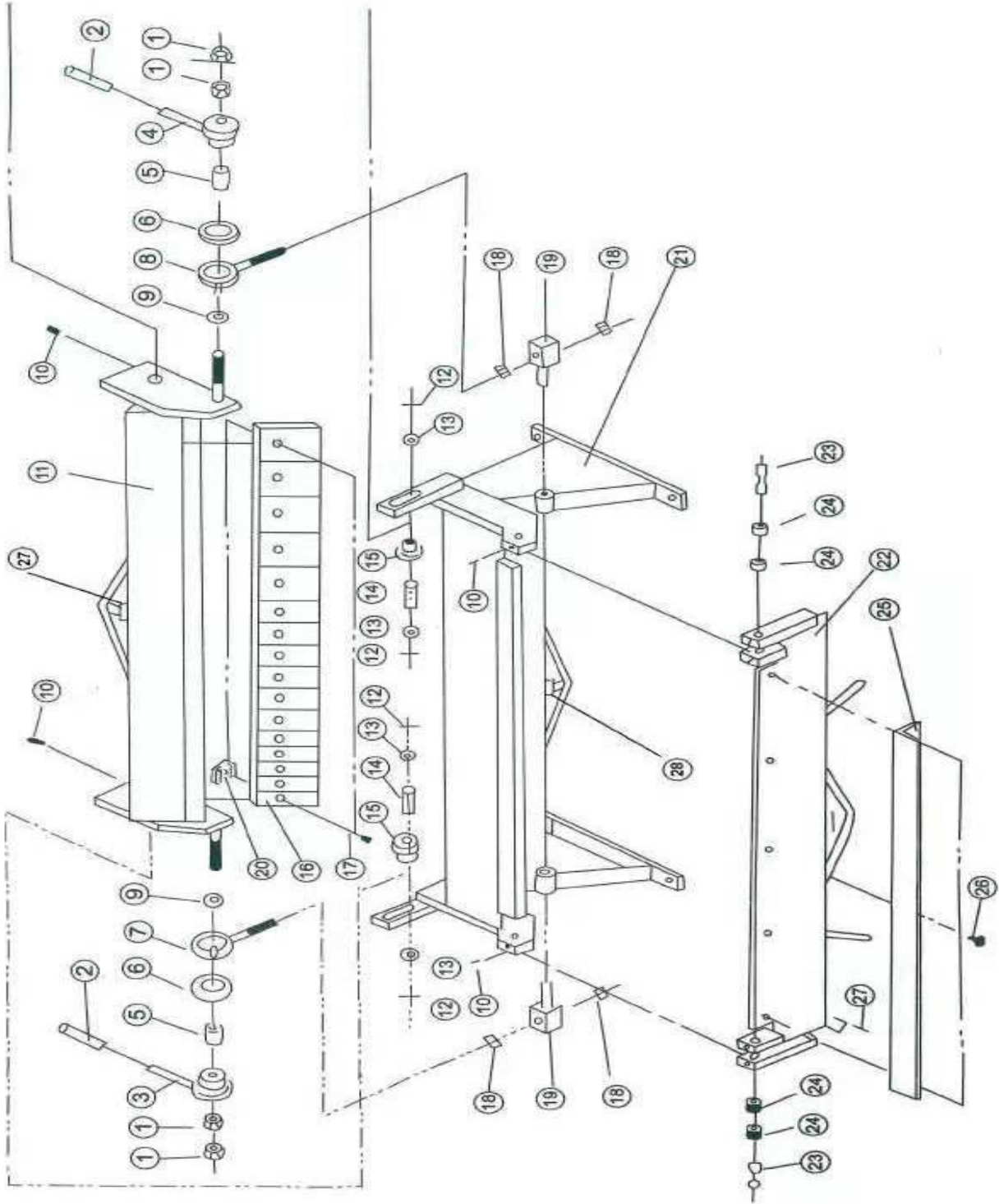


Figure-9 Oil locations

PARTS DIAGRAM CX818N



PARTS LIST

Key	Item	Description
1	PCX818N01	NUT - HEX
2	PCX818N02	HANDLE COVER
3	PCX818N03	HANDLE LEFT
4	PCX818N04	HANDLE RIGHT
5	PCX818N05	BUSHING
6	PCX818N06	SHAFT SLEEVE
7	PCX818N07	SWIVEL LEFT
8	PCX818N08	SWIVEL RIGHT
9	PCX818N09	WASHER - FLAT
10	PCX818N10	SCREW -
11	PCX818N11	BREAK SUPPORT
12	PCX818N12	SHAFT SLEEVE
13	PCX818N13	WASHER - FLAT
14	PCX818N14	PIN
15	PCX818N15	WOBBLE SHAFT
16-1	PCX818N16-1	FORMING FINGERS 2"
16-2	PCX818N16-2	FORMING FINGERS 3"
16-3	PCX818N16-3	FORMING FINGERS 4"
17	PCX818N17	SCREW - HEX SOC HD CAP
18	PCX818N18	NUT - HEX
19	PCX818N19	KNOB BLOCK
20	PCX818N20	CLAMP
21	PCX818N21	STAND
22	PCX818N22	BENDING LEAF
23	PCX818N23	SHAFT SLEEVE
24	PCX818N24	BUSHING
25	PCX818N25	ANGLE BAR
26	PCX818N26	SCREW -
27	PCX818N27	TENSION BOLT
28	PCX818N28	TENSION BOLT
29	PCX818N29	COUNTERWEIGHT BUSHING
30	PCX818N30	COUNTERWEIGHT



WARRANTY

CRAFTEX 3 YEARS LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **three 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. Return authorization may take up to 72 hours for inspection and approval.

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 labour.
- 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.