

High production MITE-E-SMITH hydraulically-operated cleat benders

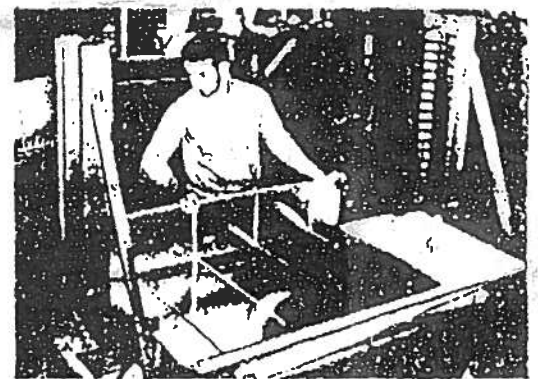
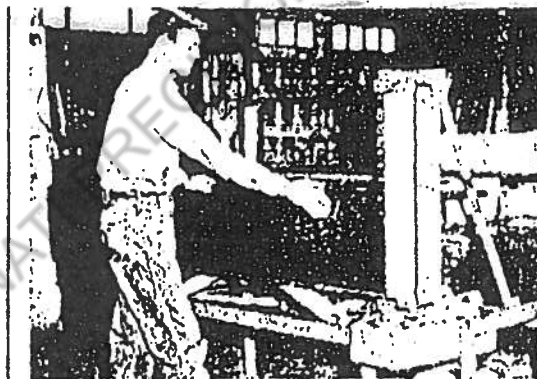


BOOST PRODUCTION WITH THIS HORIZONTAL CLEAT BENDER

Here's a ruggedly-built, reliable cleat bender that will handle ducting up to 18 gauge at widths up to 30 inches. Safety factor hydraulic power will fold and edge at full rated capacity in just 1/8 seconds. It works equally well on heavy assembled duct or small fittings.

SPECIFICATIONS

Model No.	Capacity and Description	Shipping Wt. (lbs.)
2024 VP	20 Gauge 24" Horizontal	465
1836 VP	18 Gauge 30" Horizontal	512
2036 VP	20 Gauge 36" Horizontal	562



VERTICAL CLEAT BENDERS ... ONE MAN CLEAT EDGING ON DUCTS UP TO 10 FT LONG

Mite-E-Smith hydraulically-operated vertical cleat benders are the answer to production economies in any sheet metal shop. Available in both single-end and double-end models, they allow *one man* to do a job that normally requires two.

Furthermore, these ruggedly-built, reliable benders do their job with an accuracy that quickly pays off in easier on-the-job assembly. There's no fighting a drive cleat into place; no time-consuming rework of shop operations.

Work tables on Mite-E-Smith benders are hydraulically positionable over the entire range of the machine, and *remain square* with the forming head in all positions. They'll handle duct weighing up to 500 lbs.

SPECIFICATIONS

Model	Capacity and Description	Shipping Wt. (lbs.)
2024 VP	20 Gauge 24" Vertical	804
1836 VP	18 Gauge 30" Vertical	891
2036 VP	20 Gauge 36" Vertical	970
2024 DVP	20 Gauge 24" Double End Vertical	1194
1836 DVP	18 Gauge 30" Double End Vertical	1291
2036 DVP	20 Gauge 36" Double End Vertical	1420



OPERATING INSTRUCTIONS FOR MITE-E-SMITH VERTICAL HYDRAULIC CLEAT BENDER

1. Remove the Power Cleat Bender from the shipping skid and level it by means of the six leveling jacks. (You may operate from the skid if you need portability.)
2. All machines have been tested and checked so that the bending blade is square with the table. Shipping may cause the unit to shift slightly, so check the squareness and adjust if necessary by means of the three set screws tagged at the rear of the tool. Remember, squareness is important because it automatically insures tight and parallel drive cleat edges on the end of the duct.
3. Have a certified electrician wire the line to the motor switch according to the best electrical practices. All motors are fully tested before leaving the factory. WE WILL NOT BE RESPONSIBLE FOR MOTORS IMPROPERLY CONNECTED. Each motor is tagged at the switch so that your electrician will have no difficulty. Turn on the switch and check the pump rotation. Correct the wiring if necessary before proceeding.
4. Fill the Power Pack to the middle of the oil level gauge with Mobil Vacuoline 1405 or an equivalent hydraulic oil. It has a capacity of approximately 4 1/2 gallons.
5. Turn on the motor switch so that hydraulic power is available to operate the lift table. It can be raised and lowered over the entire 30-inch length of the bender by actuating the hydraulic valve lever at the right end of the table base. Operate the lever in the direction in which you want the table to move. The table's infinite adjustment permits you to form the cleat edges on half-sections (L's) of ducts up to 30 inches. This means that one edge is bent LEG UP AND THE OTHER EDGE IS BENT LEG DOWN. This fine control is available even at the full-rated capacity of 500 lbs.
6. Next, using light pressure on the foot lever control, cycle the bending head WITHOUT MATERIAL. You will notice that the head will go through its forming cycle and automatically stop. It will stay in this position until you remove your foot from the control. The return cycle will appear to be slow, but it has been set at the factory and SHOULD NOT BE CHANGED. It will still return to its operating position before you can turn the duct or fitting around for the next bend.

(OVER)

Practice this cycle several times and then make a few bends on scrap material, following the steps indicated:

- a. Lower the table all the way to give yourself maximum clearance.
- b. Make certain that your practice sheets are at least a foot long.
- c. Supporting the material vertically with the left hand, place it on the fingers and slide it underneath the forming blade until it hits the stop.
- d. Maintain only enough pressure on the sheet to keep it against the stop during the first part of the forming operation. (When the bend has started, the material cannot be shifted, and should have NO ADDITIONAL FORCE to keep it in the machine.
- e. Remove the folded material as soon as the bend has been completed and the head has started to return. It should be clear of the machine before the head is halfway back; you will see the advantage of the slow rate of return at this time, because it virtually eliminates the possibility of jamming the machine IF you begin removing the material as directed.
- f. If you need to change the amount of crimp in the cleat edge, it can be made either tighter or looser by adjusting the screw on the valve lever as tagged on the machine. Never form beyond the capacity of the machine.

After you have practiced the above operations several times, you are ready for productive cleat edge forming.

MANUFACTURED BY
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