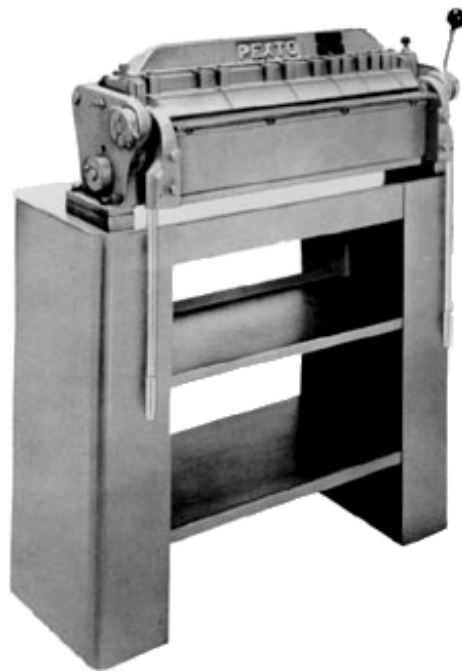


PEXTO

PX-24 & PX-36

BOX AND PAN BRAKE

OPERATING INSTRUCTIONS
AND
PARTS IDENTIFICATION



ROPER WHITNEY OF ROCKFORD, INC.

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WARNING:

Machine is dangerously tippy and unstable and will cause bodily injury if it is not bolted down. Before operating, Box and Pan Brake must be bolted to work bench. If floor stand is used, Box and Pan Brake must be bolted to stand and stand must be bolted to floor.

OPERATING INSTRUCTIONS

Mount Brake so that Frame (4) is approximately flush with the edge of bench and bolt or lag in place.

Make certain all Fingers are straight in line and Clamping Screws (10) tightened securely.

Bending clearance should be equal to twice the thickness of material to be bent for heavy gauge sheets and proportionately less for lighter gauge sheets depending on sharpness of bend desired.

To set bending clearance, loosen Lock Screws (21A), rotate Side Plate Cam Pins (21) to move Fingers toward or away from Folding Blade as required. Tighten Lock Screws (21A) securely.

To set for duplicate bends, loosen Lock Screw in Stop Collar (5). Insert material and bend to desired angle. Hold the Folding Blade in position at the completed bend and rotate Stop Collar (5) until Stop Pin (6) rests on Pin in Frame. Tighten Lock Screw securely.

Reverse bends 1/4" apart can be made by reversing Folding Blade (29).

To adjust clamping, insert sheet under Fingers, loosen Lock Nuts (3) and adjust knurled Screw (2) until sheet is clamped tightly.

Brake Collar (40) provides adjustable braking or locking, to prevent Upper Bar from dropping accidentally. To prevent unauthorized use of the machine, tighten Locking Screw securely.

Align Folding Blade with Bed Blade by loosening Blade Bolts and adjusting Set Screws as required.

To gauge bends from 0 to 7" use Finger Gauge with prongs (38) in forward position. (See Fig. 1) For bends over 7", Finger Gauge may be swung back as shown in dotted lines Fig. 1 and Back Gauge (37) (solid face) is used to gauge up to 24".

Brake is rated for 1 inch minimum flange on capacity material and can be used for capacity bending only with Reinforcing Angle (32) in place.

CAUTION: DO NOT BEND HEAVIER MATERIAL THAN RATED CAPACITY, EVEN IN SHORT LENGTHS.

Occasional oiling of all moving parts will insure smooth, trouble-free operation.

Radius Fingers can be furnished in radii up to 1 inch in all standard finger widths. (Specify desired radius when ordering) See Fig. 2.

Extension Fingers for forming boxes with inside flanges both R.H. and L.H., as well as 9" open end finger, are available as extras.

PX-24 & PX-36 PARTS IDENTIFICATION CHART

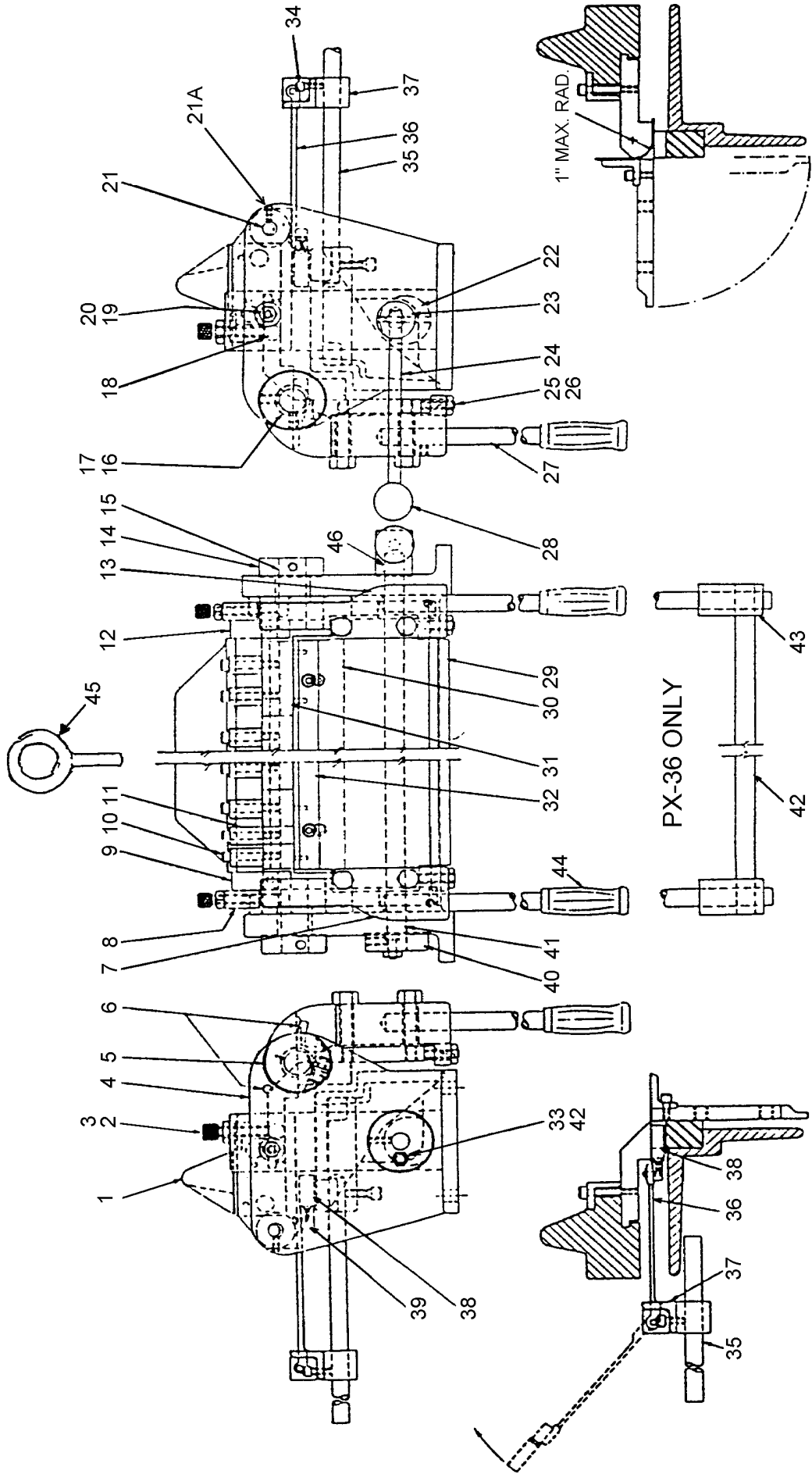


FIG. 1

FIG. 2

PX-24 & PX-36 PARTS IDENTIFICATION LIST

ITEM NO.	PART NO. PX-24	PART NO. PX-36	PART NAME
1	756030139	756030168	Upper Bar
2	756650164	756650164	Adjusting Screw
3	649023006	649023006	Locknut
4	756140522	756140514	Frame
5	756260154	756260154	Stop Collar
6	600063487	600063487	Stop Pin
7	756010148	756010175	L.H. Folding Bar Holder
8	756180152	756180180	Eccentric Strap
9	756060140	756060169	L.H. Upper Bar Side Plate
10	611012141	611012141	Finger Clamp Screws
11	756010056	756010056	Finger Clamp
12	756060141	756060170	R.H. Upper Bar Side Plate
13	756010147	756010176	R.H. Folding Bar Holder
14	756260162	756260162	Collar
15	756160158	756160187	Hinge Pin
16	656235009	656235016	Needle Bearing, Outer Race
17	656235010	656235011	Needle Bearing, Inner Race
18	600053359	600053366	Eccentric Strap Pin
19	756650163	756650190	Eccentric Guide Screw
20	649023005	649023005	Eccentric Guide Nut
21	756160157	756160184	Eccentric Pin
21A	621012133	621012133	Lock Screw
22	756210149	756210177	Eccentric
23	756030165	756030182	Handle Socket
24	756030155	756030155	Clamping Handle
25	621012133	621012133	Blade Adjusting Screw
26	649023004	649023004	Lock Nut
27	756030161	756030189	Folding Bar Handle
28	600356310	600356310	Control Ball
29	756120142	756120171	Folding Blade
30	756120150	756120178	Frame Blade
31	756360057	756360057	Fingers .750 Wide
	756360058	756360058	Fingers 1.000 Wide
	756360059	756360059	Fingers 1.250 Wide
	756360060	756360060	Fingers 1.500 Wide
	756360061	756360061	Fingers 3.000 Wide
	756360062	756360062	Fingers 4.500 Wide
	756360063	756360063	Fingers 6.000 Wide
32	756120143	756120172	Reinforcing Blade
33	740570151	740570151	Friction Shoe
34	600010467	600010467	Brass Plug

PX-24 & PX-36 PARTS IDENTIFICATION LIST

ITEM NO.	PART NO. PX-24	PART NO. PX-36	PART NAME
35	756030159	756030159	Back Gauge Rod
36	756030167	756030167	Back Gauge Extension Arm
37	756420160	756420188	Back Gauge
38	756130145	756130145	Gauge Prongs
39	756030144	756030173	Gauge Bar
40	756260153	756260181	Brake Collar
41	756680151	756680179	Eccentric Shaft
42		756030192	Handle Bar
43		756010191	Handle Socket Holder
44	656356301		Hand Grip
45		680000019	Eye Bolt
46	600123909	600123909	Woodruff Key