



Before Operating Your Tools,  
Please Read This Instruction Carefully



## Mini Sheet Metal Cutter

ITEM NO.61- 251-124  
MODEL NO . #T3024

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## Specifications

Bending Capacity:	18Gauge Mild Steel
Max. Bending Width:	24"(Unlimited Throat) 27"(2-1/2"Throat)
Overall Length:	30-7/8"
Tool Weight:	53-3/4 lbs.

### WARNING:

When using electric tools, machines or equipment, basic safety precautions should always be followed to reduce the risk of fire, electric shock, an personal injury.

## IMPORTANT SAFETY PRECAUTIONS

READ ALL INSTRUCTIONS BEFORE USING THIS TOOL

- 1. KEEP WORK AREA CLEAN.**  
Cluttered areas invite injuries.
- 2. CONSIDER WORK AREA CONDITIONS.**  
Don't expose to rain. Keep work area well lit.
- 3. KEEP CHILDREN AWAY.**  
All children should be kept away from the work area. Don't let them handle machines.
- 4. STORE IDLE EQUIPMENT.**  
When not in use, tools should be locked up in a dry location to inhibit rust. If possible, also store in an area out of reach of children.
- 5. DON'T FORCE THE MACHINE OR TOOL.**  
It will do the job better and more safely at the rate for which it was intended.
- 6. USE THE RIGHT TOOL.**  
Don't force a small tool or attachment to do the work of a larger industrial tool. Don't use a tool for a purpose for which it was not intended.
- 7. DRESS PROPERLY.**  
Don't wear loose clothing or jewelry. They can be caught in moving parts. Wear protective hair covering to contain long hair. Preventing it from getting caught in machinery.
- 8. USE EYE AND EAR PROTECTION.**  
Use a full face mask if the work you're doing produces metal filings, dust or wood chips. Goggles are acceptable in other situations.
- 9. DON'T OVERREACH.**  
Keep proper footing and balance at all times. Do not reach over or across machines which are running.
- 10. MAINTAIN TOOLS WITH CARE.**  
Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Keep handles dry, clean, and free from oil and grease.
- 11. REMOVE ADJUSTING KEYS AND WRENCHES.**  
Make it a habit to check that keys and other tools are removed from machine and its surfaces before using.
- 12. STAY ALERT.**  
Watch what you are doing, use common sense. Don't operate any tool when you are tired.
- 13. CHECK DAMAGED PARTS.**  
Before using any tool, any part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and other conditions that may affect its operation. Any part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.

#### 14. REPLACEMENT PARTS AND ACCESSORIES

When servicing, use only identical replacement parts. Only use accessories intended for use with this tool.

#### 15. DO NOT OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.

Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate machine.

#### 16. NEVER STAND ON TOOL.

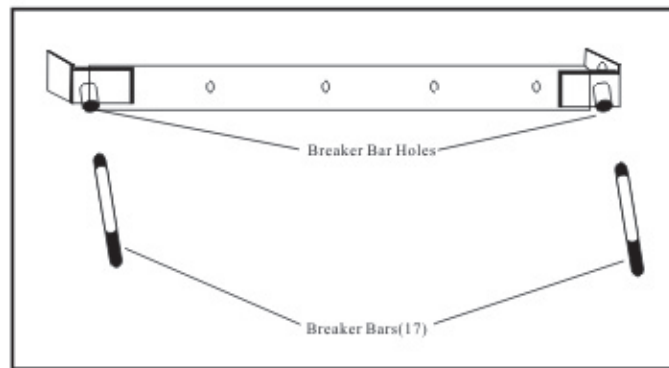
If tool is tipped over or if blades or cutters are accidentally contacted, serious injury could result.

#### 17. KEEP HANDS AND FINGERS CLEAR OF THE BENDING AREA AT ALL TIMES.

Make sure to work at a moderate pace, paying close attention to where your body is when operating the machine.

### ASSEMBLY

Your new Sheet Metal Bender comes almost completely assembled. All that needs to be done is to screw the two Bending Levers (17) into the holes in the Breaker Bar (18). Refer to the Diagram below for detail.



### OPERATION

#### !WARNING!

Do not operate the Sheet Metal Bender unless it has been either securely clamped in place or mounted on a bench.

#### ● ANGLE BENDING:

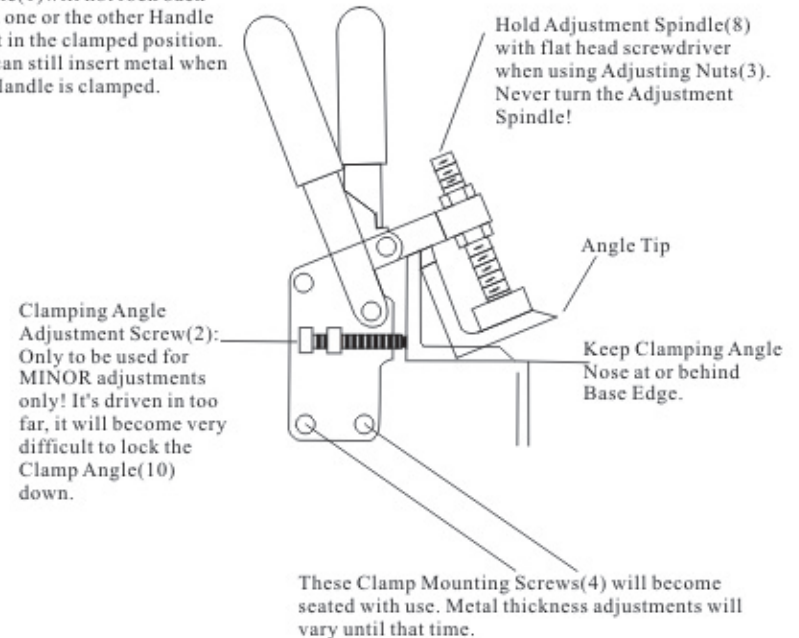
**Note: See Diagram below for details!**

1. Open the Clamps (1) and place your metal underneath the Clamping Angle (10). The metal will be bent at the tip of the Angle. This means that if you want your bend to be 1" away from the edge of the material, that amount should extend out from the Angle's tip.

#### Notes:

- a. Place thicker materials to wards one clamp as opposed to centering them!
  - b. When inserting metal, you typically only need to open one clamp!
2. Pull Clamp's levers forward until you feel them snap into place. If they do, proceed with step 4, otherwise, go to step 3.
  3. To adjust the Clamps to allow them to snap into place, first release the Clamp if still in closed position. **Hold the Adjustment Spindle (8) with a flat-head driver. Screw the Adjusting Nuts (3) (but not the spindle) clockwise to adjust for thicker metals, counter-clockwise for thinner.**
  4. When material is properly clamped, lift the Bending Levers (17) to form the angle you desire. Use a protractor or other measuring tool to ensure accuracy.

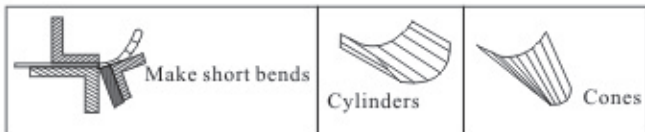
Note that the Clamping Handle (1) will not rock back when one or the other Handle is left in the clamped position. You can still insert metal when one Handle is clamped.



#### ● RADIUS BENDING:

Note: See Figures (below) for detail.

1. Radius bending is done by making a series of small, closely spaced angles.
2. If you cannot get bends close enough together for your needs, remove the Front Breaker Angle (18). This will allow very tight tolerances, but will decrease the Bend Capacity.
3. For cones, simply move one side of your stock out further than the other every time you bend.



### ● PAN FORMING: //

**Notes:** a. Keep lip under 1

b. Use material lighter than 20 gauge

c. Do not engage in long production runs

1. Pre-measure and cut your material before bending. Notch corners according to the desired finish height (see figure 1, below).
  2. Insert, clamp and bend one side according to the Angle Bending Instructions (above).
  3. Rotate material counterclockwise. Allow your completed side to extend just beyond the clamping angle, clearing it (see figure 2, below). Form side.
  4. Repeat step 3 for third side.
  5. Rotate to final side, and insert with one finished side clearing the clamping angle.
- (NOTE: Your formed sides will be on the outside of the Bender.)
- Before bending, tap one corner nearer to the middle of the machine (see figure 3, below). This will allow the material to clear the clamping angle when raised. Form side.
6. Using a low quality gauge block or a piece of wood, tap material back into place.

Figure 1  
Notch  
Material

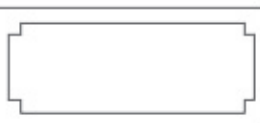


Figure 2  
Allow completed  
side to extend.



Figure 3  
Tap the corner.

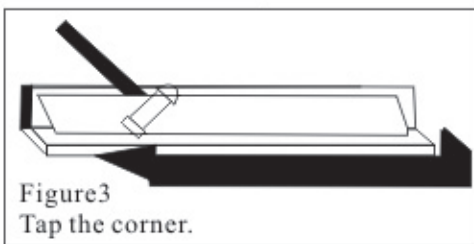
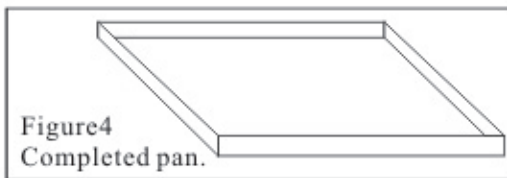
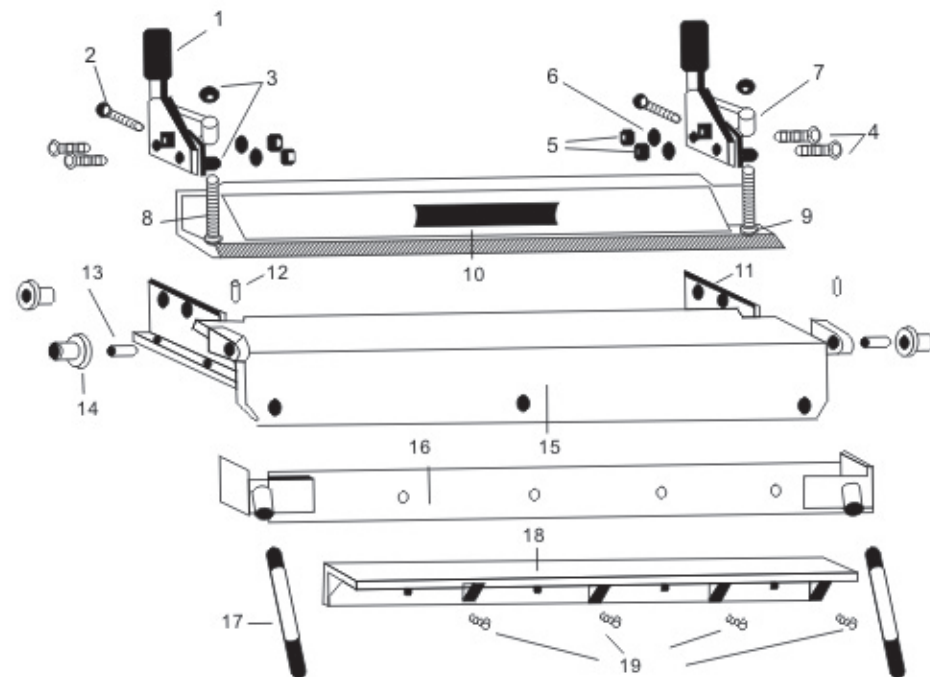


Figure 4  
Completed pan.



### ◆ PARTS DRAWING & LIST



#	Description	Qty.	#	Description	Qty.
1	Clamp	2	11	Clamp Mounting	
2	Clamping Angle Adjusting Screw	2	12	Roll Pin	2
3	Clamp Adjusting Nut	4	13	Pivolt Pin	2
4	Clamp Mounting Screws	4	14	Flange Bearing	2
5	Clamp Mounting Nuts	4	15	Base	1
6	Clamp Mounting Lock Washers	4	16	Breaker Bar	1
7	Collar	2	17	Bending Lever	2
8	Adjustment Spindle	2	18	Breaker Angle	1
9	Swivel Pad	2	19	Breaker Angle Screws	4
10	Clamping Angel	1			