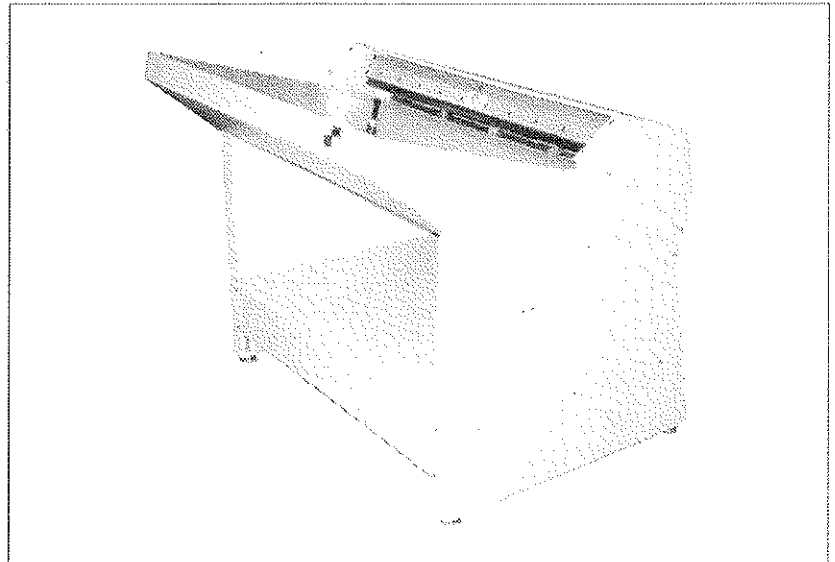


NELA Ternes PolyForm 107 (42-Inch) Polyester Plate Bender

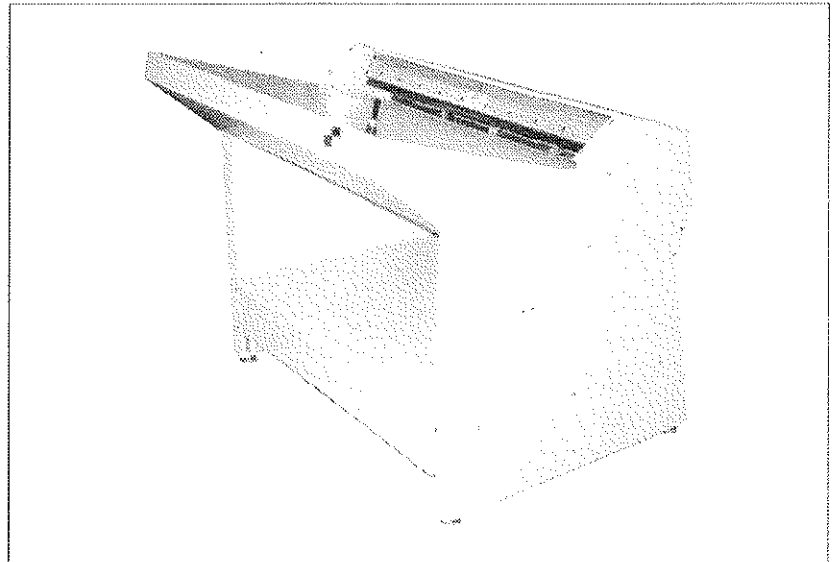


Installation/Operation Manual

Ternes Part Number: 5644-01



NELA Ternes PolyForm 107 (42-Inch) Polyester Plate Bender



Installation/Operation Manual

Ternes Part Number: 5644-01





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1 — Introduction

Congratulations on the purchase of your new NELA Ternes PolyForm 107 (42-Inch) Plate Bender. There is no product on the market that is so easy to use and yet so dependable.

The PolyForm 107 Plate Bender is designed and manufactured with the most advanced technology and the highest quality materials available. The result is a bender that is accurate and reliable for years to come, with minimal maintenance.

Before You Start. Please read Sections 1 through 3 to become familiar with the controls, indicators, and basic capabilities of the bender. A thorough review of the safety information will help you avoid residual operator hazards and will ensure that the bender will not be damaged.

How to Use This Manual. This manual is organized to guide you through the entire process of uncrating, site preparation, installing, and operating of the PolyForm 107 Plate Bender. When the machine is up and running, this manual will then serve as a reference guide for performing maintenance and providing you with basic troubleshooting information. Other pertinent information includes adjustment procedures, parts data, and diagrams.

If after reading this manual you still have questions, please contact the Customer Service Department of NELA Ternes Register System at:

NELA Ternes Register Group
4851 White Bear Parkway
White Bear Township, MN



U.S./Canada Toll-Free: 1-888-407-4808
Worldwide: 1-651-407-4800
FAX: 1-651-407-4801
Web Site: <http://www.nelaternes.com>
E-Mail: info@nelaternes.com



2 — Safety

The Ternes PolyForm 107 Plate Bender is designed with your safety in mind. Specific areas of the machine are designed to minimize personal injury during operation. Additionally, highly visible labels are placed in those areas of the bender where potential hazards exist. Although these preventative steps have been taken, there are always residual risks which exist during the uncrating, installation, operation, and maintenance of the equipment.

Before proceeding, Ternes recommends that you read the following **WARNINGS** to protect yourself from possible injury. Also read the following **CAUTIONS** to prevent damage to the equipment and ensure its optimal performance.

Warning

- ▶ When uncrating, **do not move or lift the bender without the use of a pallet jack or forklift** to prevent the possibility of personal injury.
- ▶ **Do not operate the bender with the top cover removed. WARNING: Pinch points or crushing hazards are present which can cause severe injury.**
- ▶ **Do not remove any covers and do not service the bender until you perform the following:**
 - **Shut Off the air power by using the pneumatic lockout/tagout. WARNING: Failure to do so may expose you to hazardous fluids and potentially hazardous flying debris.**

NOTE: The U.S. Department of Labor, the Occupational Safety and Health Administration (OSHA) has issued a standard detailing safety requirements for the control of hazardous energy. The standard defines the criteria for establishing an effective program for locking out or tagging out energy isolating devices. For specific information, refer to OSHA 29 CFR Standard 1910.147.
 - **Disconnect the bender from the electrical power source. WARNING: Failure to do so may expose you to potentially hazardous electrical power.**
- ▶ **WARNING: Keep hands away from all moving parts to avoid personal injury.** Even with no air to the system, pinch points can still be dangerous.
- ▶ **WARNING: Keep hands away from the anvil surface when electrical power switch is On.** The Surface temperatures can be hot enough to burn the skin.
- ▶ When making adjustments to plate stops, **disconnect bender from electrical power source and set lockout/tagout valve in the “closed” position.**

(continued)





2 — Safety (cont.)

Caution

- ▶ ***Do not operate the bender without the regulator functioning properly within the pneumatic circuit and set to a maximum of 100 psi***, as an overpressure condition can occur that exceeds rated components.
- ▶ ***Do not bend more than one piece of material at a time***. Bending multiple pieces will result in loss of accuracy and can damage the upper anvil and lower clamp.
- ▶ ***Before you consider any lubrication of the bender, please read the following:***
The bender should *not* (under normal operating conditions) require lubrication of any moving parts in the pneumatic system.



3 — Features

Description of Use

The Ternes PolyForm 107 Plate Bender is a pneumatically-operated plate bender designed to bend the polyester plate material commonly used in commercial webfed and sheetfed print shops. Electricity is used *only* to provide power to the heat element during bending.

Three sets of plate stops (two movable, one fixed) are provided for making any of three different plate bend lengths. Depending on how you set these stops in any given operational sequence, you can configure the machine to make either single or double tuck-over bend at either the lead or tail edges of the plate. Or, you can make any combination of these two.

By simply moving the crimp/tuck joystick, you can pneumatically control the movement of the anvils to tuck or bend the plate. A built-in stops-position switch allows you access to either of two sets of movable stops and one set of fixed stops. The three sets of stops are factory-set to varying bend lengths, but can be readjusted to suite the press needs at the site.

The PolyForm 107 Plate Bender is capable of bending a maximum plate thickness of 0.3 mm (0.012 inch), in a full 42-inch (1067-mm) width. Other features include a self-standing floor stand for overall stability during operation, minimal cycle time without any warm-up, and an angled-design for faster/more accurate plate positioning.

The paragraphs on the following page describe the bender controls, indicators, and safety features.





3 — Features (cont.)

Controls and Indicators

The PolyForm 107 Plate Bender consists of the following controls and indicators to provide you optimum ease of operation (Figure 1):

On/Off Switch — This rocker switch powers On or Off the heat element.

Heat Element Status Light — Illuminates when heat element is On. It stays *on* during the warm-up period, and extinguishes when optimum temperature is achieved.

Fuse(s) — Protects circuit from heat element overload. Replaceable.

Tuck/Crimp Joystick — Forward movement away from operator (labeled **1**) initiates a tuck. Backward movement towards operator (labeled **2**) initiates a bend.

First-Position Plate Stops — Movable, adjustable, and pneumatically controlled. With the stops-position switch in the first position (*leftmost* on dial), you can engage the first-position stops when a single (or short) bend is required.

Second-Position Plate Stops — Fixed, adjustable, not pneumatically controlled. With the stops-position switch in the second position (*middle* on dial), you can engage the second-position stops when a second (or long) bend is required.

Third-Position Plate Stops — Movable, adjustable, and pneumatically controlled. With the stops-position switch in the third position (*rightmost* on dial), you can retract any movable stops so that the third-position (or fixed stops) can be used when a third bend is required (generally at the opposite end of plate).

Stops-Position Switch — Numbered 1–3, this dial switch allows you to pneumatically move stops into position for any of three bend lengths. Set the dial to the #1 position (*left*) to use the two first-position stops for a single bend. Set the dial to the #2 position (*center*) to engage the second-position stops a second bend. Set the dial to the #3 position (*rightmost*) to engage the third first-position stops for a third optional bend.

Hold-Downs — Activated *only* when the first-position stops are selected and used to secure the plate firmly in place while making a single short bend, or critical first bend of a double tuck-over bend.

Pneumatic Lockout/Tagout — Allows you to shut Off in-house air supply to the pneumatic circuit. This is required when inspecting or servicing the bender.

Air-Line Coupling — You can quickly disconnect the bender from the in-house air supply should you have to move the bender or use an alternate air supply.

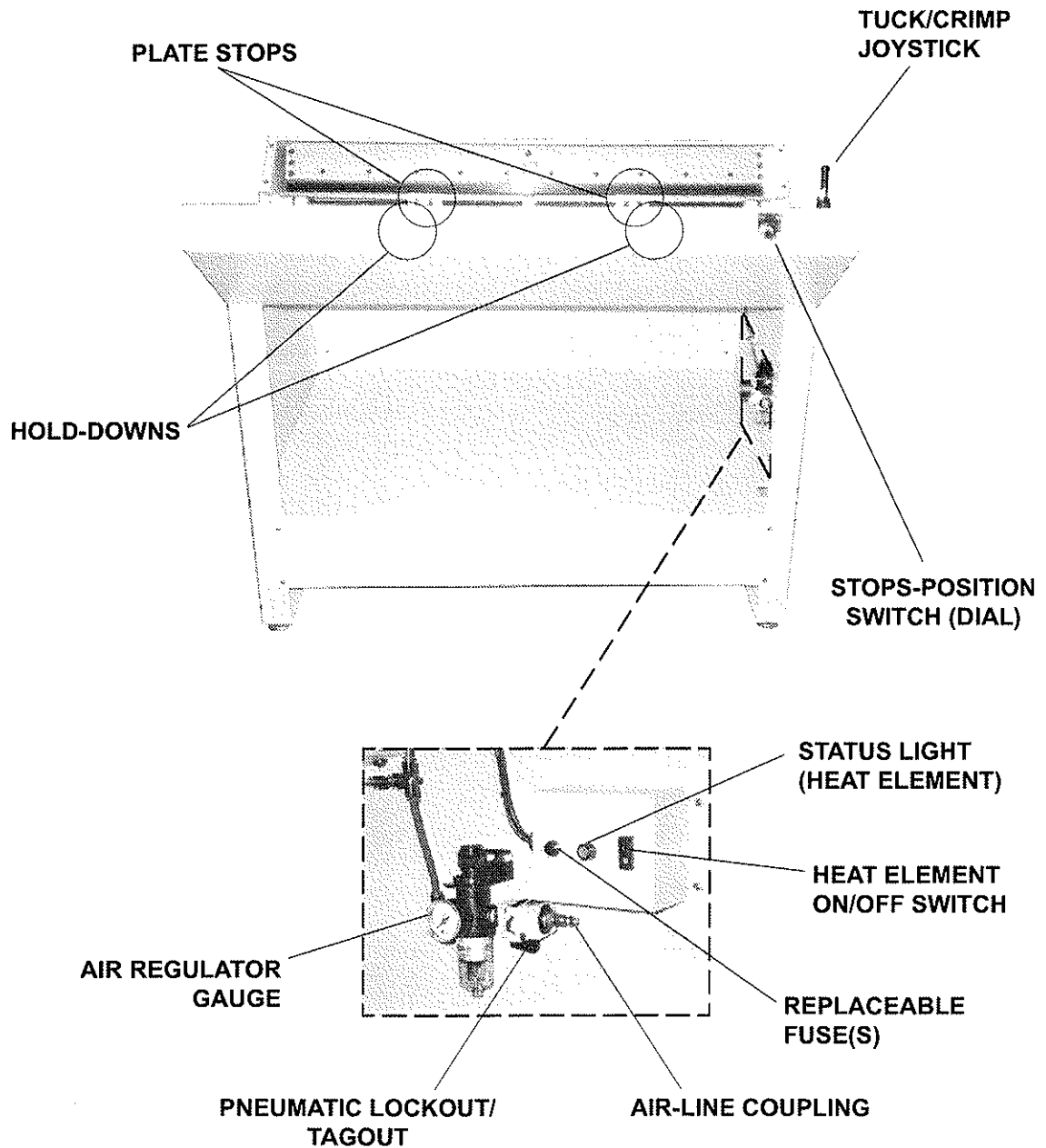
Air Regulator/Gauge — Maintains constant minimum operating pressure in the pneumatic circuit. Built-in gauge displays current pressure (in units of “psi”).





3 — Features (cont.)

Figure 1. Controls and Indicators



3 — Features (cont.)

Safety Features

The Ternes PolyForm 107 Plate Bender is designed to minimize personal injury to the operator. It complies with European CE safety regulations and is therefore certified.

The main safety features include:

- Protective shrouding around moving parts to prevent operator from direct hand contact with crimping/bending anvils.
- Pneumatic lockout/tagout to prevent any accidental movement of parts by the air-powered circuit while inspecting or servicing the bender.
- Air-line quick-disconnect to remove all active air from the system during maintenance.

Safety Labels. Ternes has made every effort to protect the operator from any residual risks associated with the use of the bender. Notice that safety labels are prominently displayed directly adjacent to those areas of the machine where the potential for injury exists. The sample labels shown below are used to warn the operator of the dangers associated with the tuck bar and crimping slot.

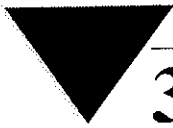




3 — Features (cont.)

Technical Data

Electrical requirements:	110 VAC, 60 HZ, single phase supply 220 VAC, 50 Hz, single phase supply
Power consumption:	1000 watts (110 VAC) 700 watts (220 VAC)
Air supply:	85 – 100 psi (6.2 – 6.9 bar)
Plate width:	Maximum: 42 inches (1067 mm)
Plate length:	Minimum: 6 inches (381 mm) Maximum: None
Length of single bend:	Minimum: 0.157 inches (4 mm) Maximum: 1.770 inches (45 mm)
Registration method:	Edge of material
Plate stops:	First-position: Movable, adjustable for length Second-position: Fixed, adjustable for length Third-position: Movable, adjustable for length
Factory presets:	First-position preset for 0.118 inches (3 mm) Second-position preset for 0.157 inches (4 mm) Third-position preset for 0.5 inches (12.7 mm)
Stops spacing:	First-position: 15.236 inches (387 mm), center-to-center Second-position: 17.736 inches (450.5 mm), center-to-center Third-position: 20.236 inches (514 mm), center-to-center
Weight:	~ 250 pounds (113.4 kg)
Physical dimensions: (see Figure 2)	Width — 44.40 inches (1228 mm) Length — 43.11 inches (1095 mm) Height — 43.11 inches (1095 mm)

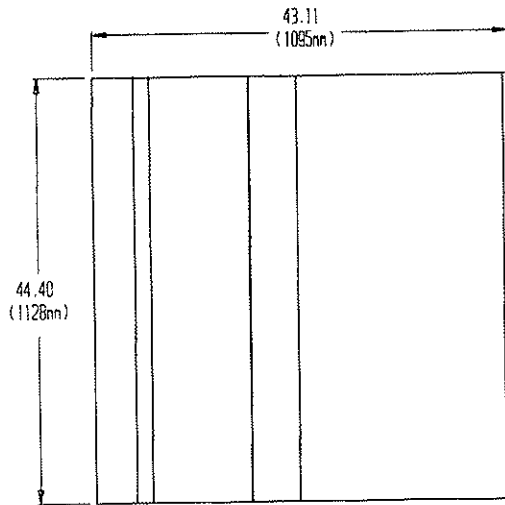


3 — Features (cont.)

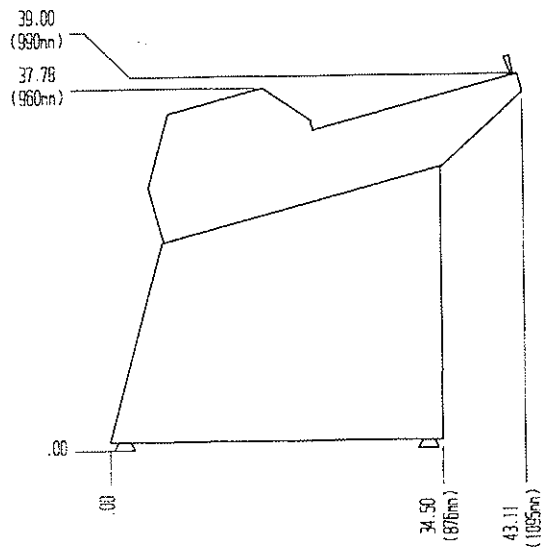
Figure 2. Dimensional Diagrams

NOTE: Measurements are shown as *inches* and *millimeters*.

TOP



SIDE





4 — Unpacking and Setup

Tools

All fasteners in this machine are metric. You will need a metric tool set, including a metric Allen wrench set, to perform certain adjustment procedures or to remove any panels. Specifically, you should have available the following Allen wrench sizes: 3 mm, 4 mm, and 8 mm.

Unpacking/Site Considerations

The Ternes PolyForm 107 Plate Bender is shipped in a sturdy crate to ensure that no damage occurs to the unit. It arrives completely assembled on a self-standing floor stand. No further assembly or adjustments are necessary.

CAUTION: Use care when unpacking to avoid any surface damage to the floor stand, work surface, or operator controls.

To help you make your unpacking easy and safe, read the following before removing the bender from the shipping crate:

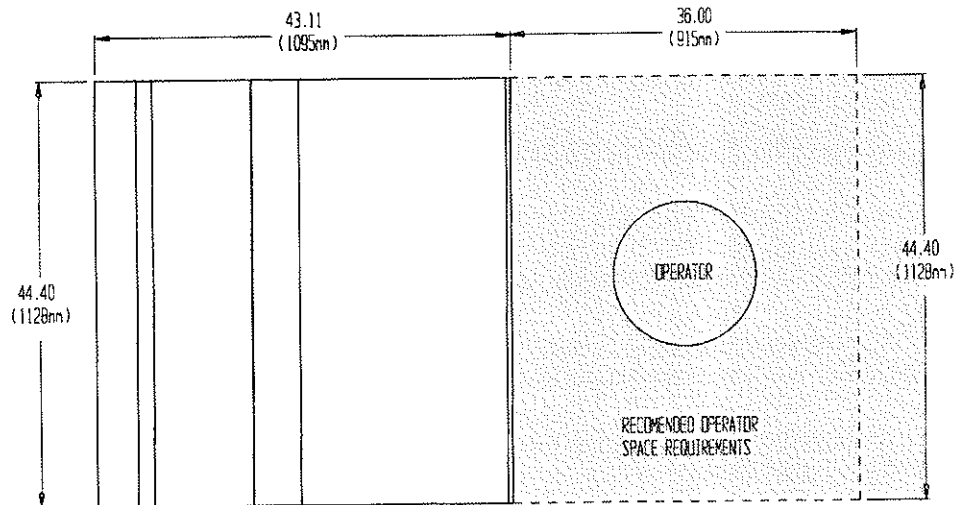
- The bender weighs approximately 250 pounds (113.4 kg). Plan to have a pallet jack or forklift available to assist in the receiving, unpacking, and moving to the site.

WARNING: Use safe moving practices to avoid injury.

- Carefully handle crating materials to avoid any possible damage to the floor stand, work surface, or operator controls.
- When moving the bender, always grip the bender by the solid metal floor stand. Avoid gripping the machine near the controls.
- Make sure the floor at the site is level and that you have allowed ample working space for operation and maintenance. Front operating clearance should be a minimum of 36 inches (915 mm) from the front of the machine (Figure 3).
- Make sure the site chosen has an air supply which can provide pressure in the range of 85 – 100 psi.
- Make sure the site has a power source that is grounded, fused, within reach of the 6-foot (1.83-m) power cord provided. A dedicated 15-ampere circuit is required for 110-VAC machines (10-ampere circuit for 220-VAC machines).

4 — Unpacking and Setup (cont.)

Figure 3. Site Footprint



Setup

After the bender is removed from the shipping crate and moved to the site, perform the following procedure:

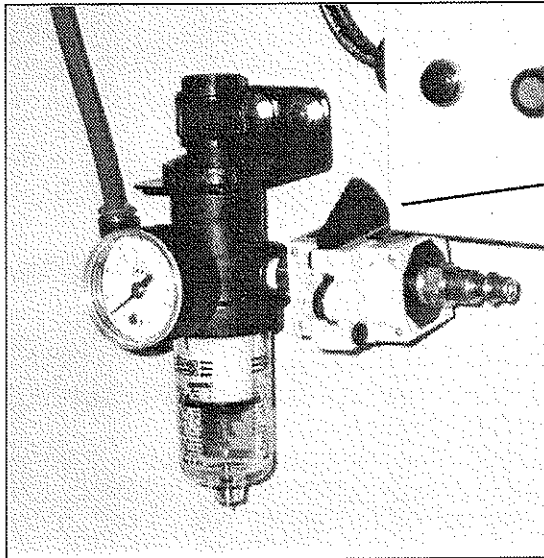
Procedure:

- 1 Check for stability of the bender on the floor. Adjust leveling feet if necessary.
- 2 Locate the pneumatic lockout/tagout valve near the compressor/air circuit coupling (Figure 4A) and make sure it is in the operational (open) position.
NOTE: Whenever you are inspecting or servicing the bender, always have the lockout/tagout valve in the "closed" position to ensure that no compressed air can move parts and cause personal injury.
- 3 Locate the in-house air supply hose and coupling. For convenience, feed air supply hose through access hole in base plate, and connect to fitting on lockout/tagout. If necessary, use the provided adapter to connect to in-house air.
- 4 Locate the 6-foot (1.83-m) AC power cord provided. For convenience, feed through the access hole in base plate and plug into the designated power source. The outlet at the site should be grounded and fused.
- 5 Proceed with bending a plate. *To select the plate stops prior to operation, see "Selecting the Plate Stops" on page 18 for more information.*

4 — Unpacking and Setup (cont.)

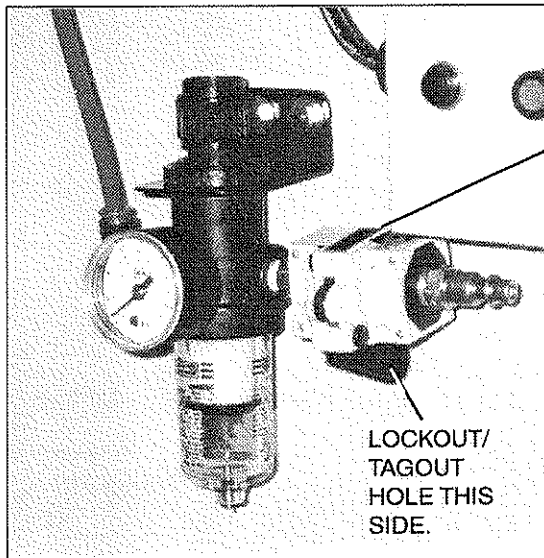
Figure 4. Pneumatic Lockout/Tagout

A



OPEN: OPERATIONAL POSITION SHOWN.

B



CLOSED: SERVICE POSITION SHOWN.

NOTE: In the “closed” position, no air is present in the circuit. You can verify “closed” if a padlock hole is visible. Prior to removing locks/tags after service, make sure:

- All safety covers are in place.
- Workers are positioned safely for startup.
- Controls are positioned correctly for startup and unit is operating properly.

4 — Unpacking and Setup (cont.)

Selecting the Plate Stops

Check that the correct plate stops are selected for your particular bending requirements.

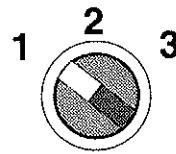
The plate stops are activated by rotating the stops-position switch located on the front of the bender. Move the switch several times and observe the movement of the first-position plate stops to either the forward or reverse position. See figure 5.

Whether you select the first-position or second-position plate stops depends on the following bending requirements:

- **If you are making a single bend**, set the switch to the forward or normal position (*leftmost* on dial) to set the two first-position plate stops.
- **If you are making a double bend**, set the switch to the reverse position (*rightmost* on dial) to retract the first-position stops, thereby engaging the two second-position plate stops.
- **If you are making a third bend (such as opposite end of plate)**, set the switch to the reverse position (*rightmost* on dial) to retract the first-position stops, thereby engaging the two second-position plate stops.

NOTE: Refer to the procedure on page x for detailed information on adjusting the stop positions.

Figure 5. Selecting the Plate Stops



- 1 = First-position stops move to forward position.
- 2 = Second-position stops (fixed) are in forward position; first-position and third-position stops are retracted.
- 3 = Third-position stops move to forward position.

5 — Operation

General

The Ternes PolyForm 107 Plate Bender allows you to configure your plate bending sequence in several ways. Using the first- and second-position stops, you can make a *single-bend double-bend* on either the lead or tail edges of the plate (or, any combination of these two) Using the third-position stops, you have the option of another bend length (such as a single-bend at the opposite end of the plate).

The procedures for making single bends, double bends, and optional third bends are covered in the following paragraphs.

Single (or Shortest) Bend

To make a single bend:

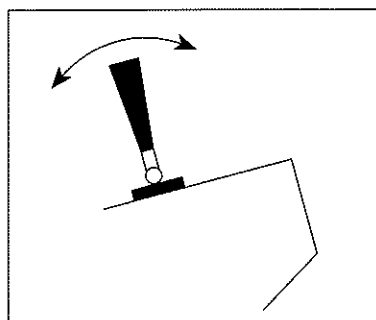
Procedure:

- 1 With the stops-position switch set to "1" position, lay the plate to be bent emulsion side down on the bender work surface, allowing gravity to pull the plate edge against the first-position stops and *under the hold-downs*.
- 2 To tuck the plate, push the tuck/crimp joystick forward (labeled 1) until it stops (Figure 6). This pushes the material into the crimping slot. The rear edge of the material will raise up slightly off of the work surface as the material goes into the slot.
- 3 To crimp, pull the tuck/crimp joystick back in the opposite direction (labeled 2). This causes the tuck bar to retreat and starts the bending cycle which lasts until you release the joystick.

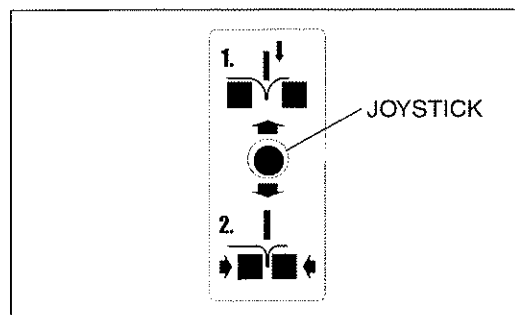
NOTE: To ensure an optimal bend, hold the joystick in the crimp position 3 to 4 seconds.

- 4 Remove the plate.
- 5 Repeat steps 1–4 for the opposite edge of the plate if necessary.

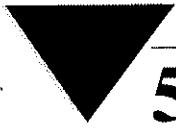
Figure 6. Operating Tuck/Crimp Joystick



SIDE VIEW



TOP VIEW



5 — Operation (cont.)

Double Bend

To make a double bend:

Procedure:

- 1** With the stops-position switch set to "1" position, lay the plate to be bent emulsion side down on the bender work surface, allowing gravity to pull the plate edge against the first-position stops and *under the hold-downs*.
- 2** To tuck the plate, push the tuck/crimp joystick forward (labeled **1**) until it stops (Figure 6). This pushes the material into the crimping slot. The rear edge of the material will raise up slightly off of the work surface as the material goes into the slot.
- 3** To crimp, pull the tuck/crimp joystick back in the opposite direction (labeled **2**). This causes the tuck bar to retreat and starts the bending cycle which lasts until you release the joystick.

NOTE: To ensure an optimal bend, hold the joystick in the crimp position 3 to 4 seconds.

- 4** Remove the plate.
- 5** Rotate the stops lever to select the lower stops.
- 6** Move the stops-position switch clockwise to the "2" (*center* position) to engage second-position stops. Notice that the hold-downs are *not* used during this bend.
- 7** Repeat steps 2–4.
- 8** Repeat steps 1–7 for the opposite edge of the plate if necessary.

NOTE: In order for a double bend to be performed successfully, the first bend must be shorter than the second bend so that the plate can tuck properly into the crimping slot before a second bend is attempted.



5 — Operation (cont.)

Third Optional (or Longest) Bend

To make an optional third (or longest) bend:

Procedure:

- 1** With the stops-position switch set to “**3**” position, lay the plate to be bent emulsion side down on the bender work surface, allowing gravity to pull the plate edge against the first-position stops.
- 2** To tuck the plate, push the tuck/crimp joystick forward (labeled **1**) until it stops (refer back to Figure 6). This pushes the material into the crimping slot. The rear edge of the material will raise up slightly off of the work surface as the material goes into the slot.
- 3** To crimp, pull the tuck/crimp joystick back in the opposite direction (labeled **2**). This causes the tuck bar to retreat and starts the bending cycle which lasts until you release the joystick.

NOTE: To ensure an optimal bend, hold the joystick in the crimp position 3 to 4 seconds.
- 4** Remove the plate.



6 — Adjustments

Plate Stop Adjustments

Although the first-position (movable), second-position (fixed), and third-position (movable) plate stops are factory preset, there may be plate sizes that require manual adjustment of the plate stops.

The *first-position* stops are generally used for making the initial (or shortest) bend. Each movable plate stop can be moved closer to the edge of the bending anvil (compared to the second-position stops) to provide the shortest possible bend length.

The *second-position* stops are generally used for making the second (or longer) bend.

The *third-position* stops are generally used for making a third single (or longest) bend, at the opposite end of the plate.

NOTE: In general, when adjusting stops to create a double bend, the thickness of the material should be considered. You should adjust the stops so that *the first bend is at least 0.05 inches (1.3 mm) shorter than the second bend*. This allows the first bend to fit inside the second bend.

Some procedures may involve working on or near parts which can create pinch points. Please read the following before proceeding adjusting the plate stops.

NOTE: Before disconnecting pneumatic power, move the tuck/crimp joystick to the crimp position.

WARNING:

- **Disconnect bender from electrical power source.**
- **Disconnect bender from pneumatic power source.**
- **Set lockout/tagout valve in the “closed” position to prevent compressed air from accidentally moving the air cylinders. These parts create pinch points which can be dangerous.**

Before proceeding with plate stop adjustments, make sure you have access to 8-mm and 3-mm Allen wrenches.

6 — Adjustments (cont.)

To access and adjust a set of plate stops (See Figure 7):

Procedure:

- 1 Remove the top cover (two 8-mm Allen screws each side).
- 2 Loosen the locking set-screw for the first stop to adjust using a 3-mm Allen wrench.
- 3 Rotate the adjustment dial either clockwise (to shorten) or counter-clockwise (to lengthen) the bend. *One complete rotation of the stop equals 0.050 inches (1.27 mm) of stop movement.*

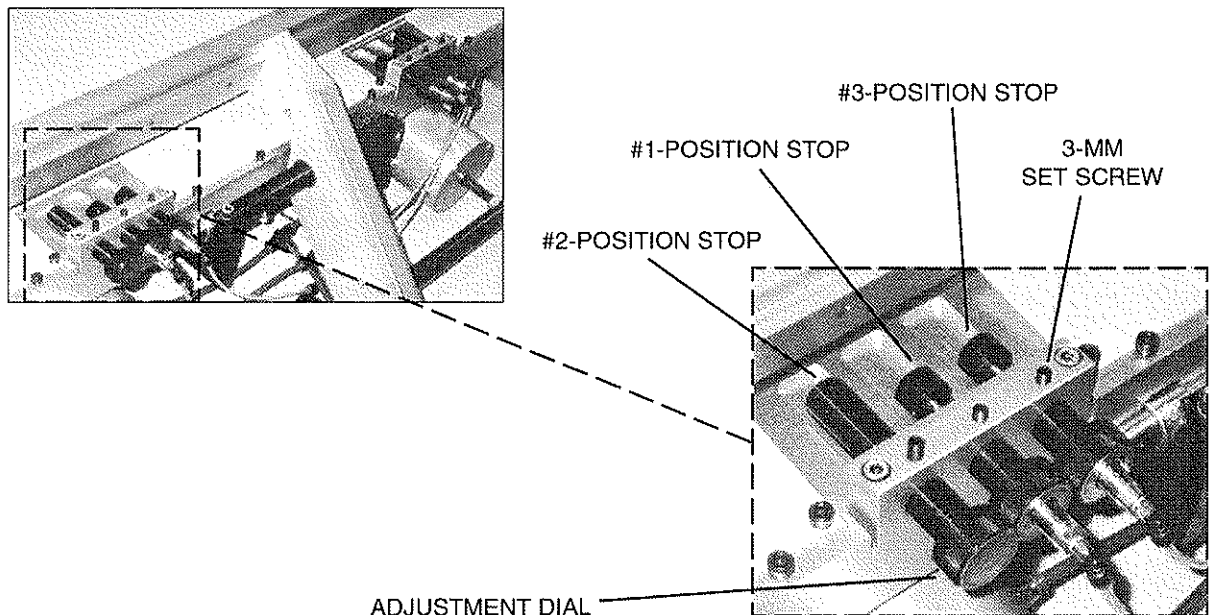
NOTE: For a movable stop, allow the pneumatic line to rotate on the air fitting barb.

- 4 When you have the stop in the desired position, gently snug-up the stop locking set-screw (3-mm Allen wrench).

CAUTION: Over-tightening may damage the stop threads.

- 5 Repeat steps 2–4 for the second and third stop as required.
- 6 Replace top cover. Set lockout/tagout to “open” position.

Figure 7. Location of Stop Adjustments





7 — Maintenance

The Ternes PolyForm 107 Plate Bender is constructed for lifetime use. Refer to the following maintenance information to clarify any questions you may have about specific parts.

- **Tuck/crimp joystick, stops-position switch:** Each bender is constructed to allow movement of these controls time after time, without the need for periodic lubrication.
- **Tuck bar and crimping slot:** Occasionally the tuck bar and crimping slot should be cleaned to ensure consistent plate bending (see procedure below). No lubrication is necessary.

WARNING:

- **Disconnect bender from electrical power source.**
- **Disconnect bender from pneumatic power source.**
- **Set lockout/tagout valve in the “closed” position to prevent compressed air from accidentally moving the air cylinders. These parts create pinch points which can be dangerous.**

To clean the tuck bar and crimping slot:

Procedure:

- 1** Confirm that the tuck bar is in the *up* position.
- 2** With a clean cloth, moistened with mild solvent, wipe off the tuck blade and crimping slot to remove excess plate developer, dirt, and other foreign material.
- 3** If possible, blow slot out with compressed air.
- 4** Make sure all foreign objects are clear of the bending area.
- 5** Reconnect pneumatic power and move lockout/tagout valve to the “open” position to resume operation.

8 — Troubleshooting

Problem:

Bender does not have electrical power.

Solution:

- a. Verify power cord connection at the AC power source.
 - b. Inspect in-line fuse. Replace if necessary.
 - c. Check breaker or fuse at AC power source.
-

Problem:

- a. Check that coupling between the in-house air supply and the air regulator is properly connected.

Solution:

- b. Locate the pneumatic lockout/tagout valve near the compressor/air circuit coupling and make sure it is in the operational (open) position.
 - c. Check air regulator pressure gauge to make sure there is sufficient air pressure in the pneumatic system.
 - d. Inspect for breaks and/or loose connections in the pneumatic circuit.
-

Problem:

Inconsistent bend angles.

Solution:

- a. Check that the in-house air supply is charging the pneumatic system to the required pressure (90 psi minimum).
 - b. Disconnect air line hose from the in-house air supply. Set lockout/tagout valve in the closed position. Inspect for breaks and/or loose connections in the pneumatic circuit.
 - c. Make sure joystick is held in crimp position for the optimum 3 to 4 seconds when making a bend.
-

Problem:

Inconsistent bend lengths.

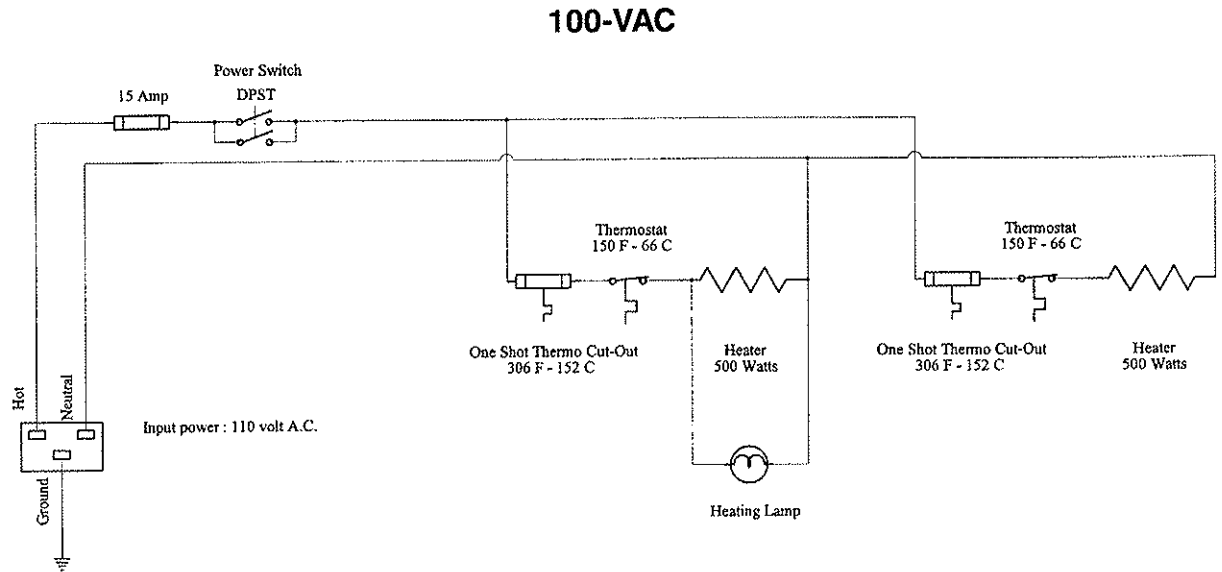
Solution:

- a. Verify that plate is secured against stops during bend.
- b. Inspect for breaks/or loose connections in the pneumatic circuit.
- c. Inspect crimp slot for debris. Blow out with compressed air if necessary.

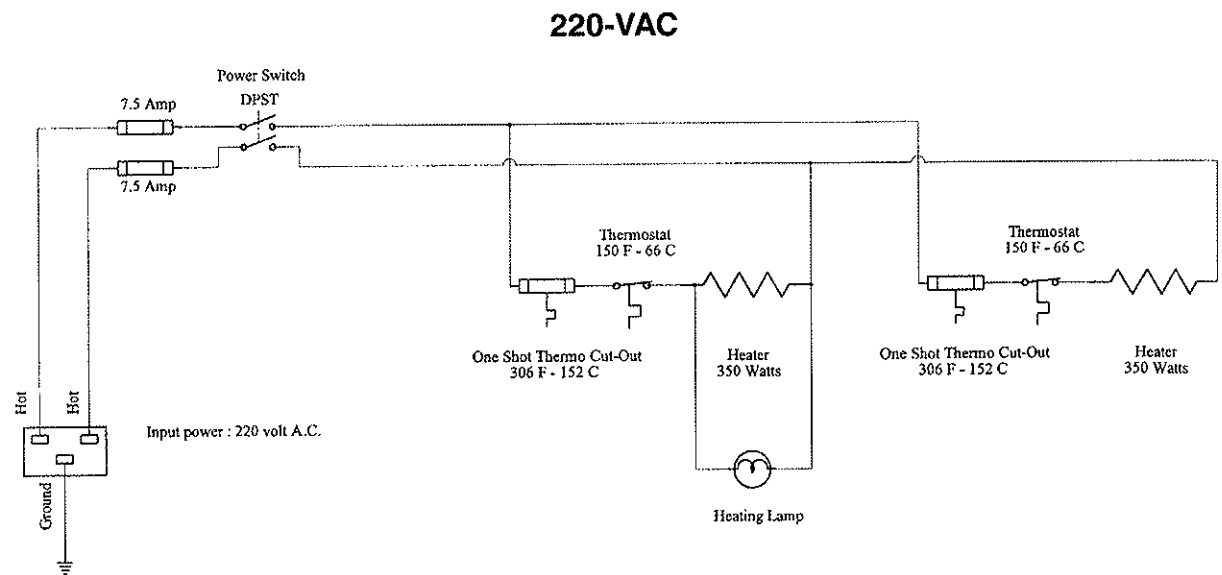


9 — Miscellaneous Diagrams

Figure 8. Electrical Diagrams



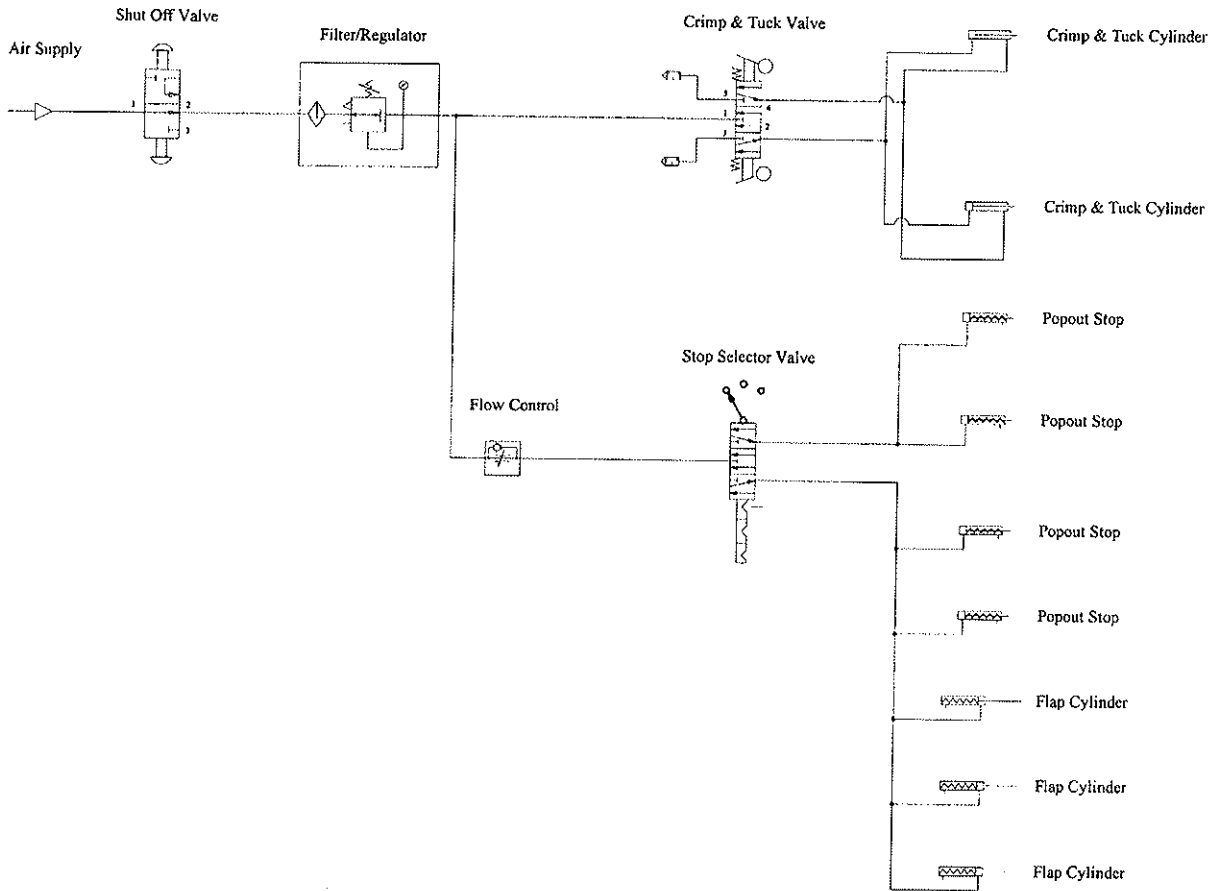
Note : Heating lamp goes out when unit is at operating temperature.



Note : Heating lamp goes out when unit is at operating temperature.

9 — Miscellaneous Diagrams (cont.)

Figure 9. Pneumatic Diagrams



Limited Warranty

NELA Ternes PolyForm 107 Plate Bender

Every NELA Ternes PolyForm 107 Plate Bender is warranted to be in good working order for the original purchaser for 1 (one) full year. The warranty covers all defects in workmanship and materials. This warranty only covers repairs or adjustments performed in our factory. Benders returned for warranty repair must be shipped to NELA Ternes "freight paid" and will be returned "freight collect".

Every effort has been made in the design of this bender to perform with limited maintenance. Reasonable care must be taken by the operator to periodically check for any wear which may be deemed excessive and affect the performance of the NELA Ternes PolyForm 107 Plate Bender.

This warranty does not cover damages, defects, malfunctions, or equipment failures caused by:

1. Failure to follow NELA Ternes' installation, operation, or maintenance instructions and guidelines.
2. Unauthorized adjustment, modification or alteration of the equipment.
3. Replacement of factory parts with parts other than original NELA Ternes Register Group replacement parts.
4. Abuse, misuse, or the negligent acts of persons not under the reasonable control of NELA Ternes.
5. Acts of God, and/or the actions of third parties.

The warranty period shall begin on the date the equipment is shipped to the customer. NELA Ternes will, at its option, repair or replace without charge any parts which fails to operate as warranted during the warranty period. All work performed under this warranty shall be performed by NELA Ternes or its agents. Parts removed during warranty maintenance become the property of NELA Ternes. NELA Ternes' obligation to repair or replace, as set forth above, shall be the customer's exclusive remedy.

NELA Ternes Register Group shall make all warranty repairs in a timely fashion. NELA Ternes Register Group will not be responsible for any losses incurred by the purchaser due to time delays or inconveniences during factory service or service performed on the purchaser's site. In no event, shall NELA Ternes be liable to the customer or to any other company or entity for any incidental, special, reliance, consequential, or any other indirect loss or damage (including lost profits or revenues) arising out of this agreement.

Except as specifically set forth above, NELA Ternes makes no warranties, expressed or implied, and specifically disclaims any warranty of merchantability or fitness for a particular purpose. Purchaser shall be solely responsible for determining the adequacy of the equipment for any and all uses to which the purchaser shall apply and use the equipment, and the application of the equipment by purchaser shall not be subject to any implied warranty of fitness for that purpose.

This warranty is effective for all PolyForm 107 Plate Bender shipped after July 1, 2000.

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