

Installation Instructions for 81510

Metal Brake with Stand

36" Maximum Width, 22 Gauge Maximum

Save This Manual Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number on the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

UNPACKING

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-800-845-4545 as soon as possible.

Read this material before using this product. Failure to do so can result in serious injury. **SAVE THIS MANUAL.**

SPECIFICATIONS

Bending Capacity (Gauge x Width)	Up to 12 Gauge Sheet Metal at 18" Up to 16 Gauge Sheet Metal at 36" Up to 16 Gauge Mild Steel at 18" Up to 20 Gauge Mild Steel at 36" Up to 22 Gauge Stainless Steel
Bend Angles	0 to 120°
Max. Box Depth	3"
Max. Beam Lift	7/8"

IMPORTANT SAFETY INFORMATION

1. Do not exceed the maximum bending capacities of 18" wide stock (for 12 gauge steel) or 36" wide stock (for 16 gauge steel.)
2. Wear ANSI-approved safety goggles and heavy-duty work gloves during assembly.
3. Keep fingers clear of Press Plate (14) and Press Plate Assembly (17) during use.
4. Assemble only according to these instructions. Improper assembly can create hazards.
5. Place only on a flat, stable surface able to support weight of Metal Brake, item being bent, and the bending force.
6. Verify that installation surface has no hidden utility lines before drilling the holes.
7. Keep assembly and work area clean and well lit.
8. Keep bystanders out of the area during assembly and use.
9. Do not assemble when tired or when under the influence of drugs, alcohol or medication.
10. This product is not a toy. Do not allow children to play with or near this item.
11. Use as intended only.
12. Inspect before every use; do not use if parts are loose or damaged.
13. Maintain product labels and nameplates. These carry important safety information. If unreadable or missing, contact JEGS 1-800-345-4545 for a replacement.



1-800-345-4545 jegs.com

ASSEMBLY AND INSTALLTION INSTRUCTIONS

Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this document including all text under subheadings therein before set up or use of this product.

WARNING! The weight of the Brake and Stand requires that two people assist in the assembly.

1. Place the Metal Brake (back side) on the floor with the mounting feet facing forward.
2. Place the Left Brake Stand (20) mounting pad against the left mounting foot of the Brake.
3. Assemble with Bolt (12), Washer (11), and Nut (10) as shown in Figure 1. Securely tighten.
4. Mount the Right Brake Stand (19) as described in Step 2.
5. Using two people carefully lift the Brake and Stand it upright.
6. Place the Brake and Stand in the location where it will be mounted to the floor, then mark through the 1/2 inch holes in the Left and Right Brake Stands (20 and 19).

CAUTION! Before drilling the mounting holes, verify that you will not be drilling through any utility lines or water pipes.

7. Drill four mounting holes into the floor and secure the Brake with four bolts*, lock washers, and nuts (not supplied).

*We recommend using expansion anchor bolts for concrete floors. For wooden floors, use lag bolts.

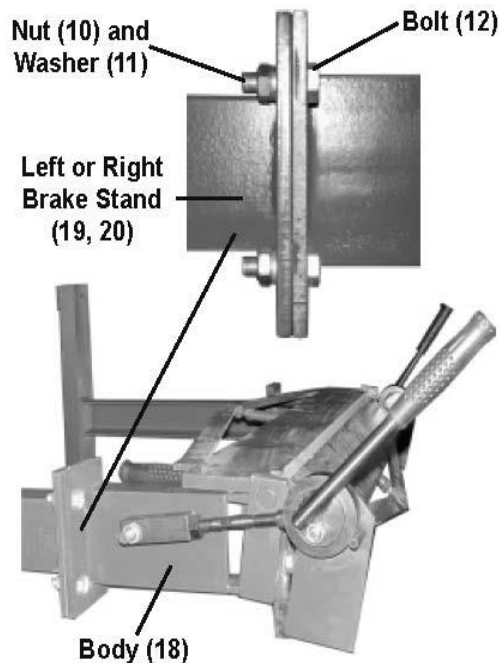


Figure 1

MAINTENANCE

1. Periodically lubricate all moving parts and surface with a light oil.
2. Cover the Metal Brake when not in use.

OPERATION

NOTICE: TO PREVENT DAMAGE: Do not bend stock which is thicker than 12 gauge sheet metal. Damage could occur to the brake. If not sure of the stock thickness, try bending a small piece of scrap stock. If it does not easily bend, either the stock is too thick, or the Bending Brake needs adjustment.

1. Pull the upper Eccentric Handles (2) all the way down before opening the Press Plate Assembly (17).

2. Scribe a line with pencil at point where stock is bent.

3. Slide sheet metal to be bent in between the Body (18) and under the Press Plate Assembly (17). Align the scribed bending line with inner lip of the Body. See Figure 2.

4. Lift both Upper Eccentric Handles into the locked position. See Figure 2. This will cause the Press Plate Assembly to clamp down on the stock. If the Handle does not come down all the way and lock, the stock is greater than 12 gauge or the Brake needs to be adjusted to allow for thicker stock. **If so, refer to the Adjustments section.**

CAUTION! Keep spectators clear of the work area during use.

5. Using both hands, lift up on the Body using its Lower Handles until the desired angle is reached on the stock. Once bend is complete, return Lower Handles to their down position.

6. Lift the upper Eccentric Handles all the way up and remove the sheet metal.

CAUTION! During bending, keep both hands on the Lower Handles (1).

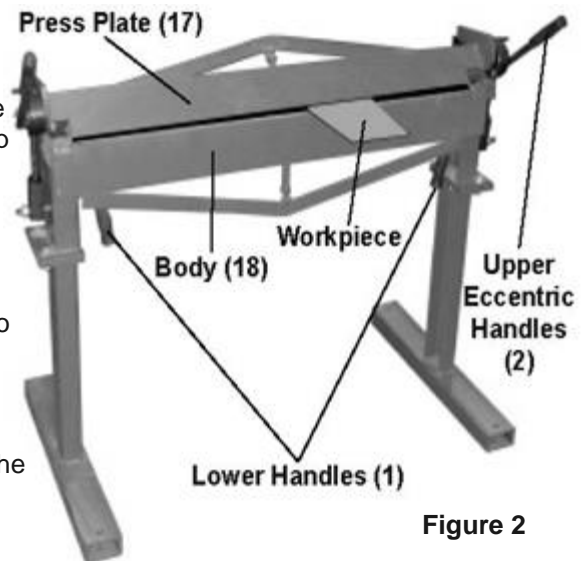


Figure 2

ADJUSTMENTS

It may be necessary to adjust the position of the Press Plate Assembly to accommodate a thicker or thinner piece of sheet metal, or to align it to the Body.

Adjusting for Thickness of Sheet Metal

1. Lift both Upper Eccentric Handles all the way up.

2. Loosen Nuts (7 and 5) to enable Bolt (6) to move up or down. See Figure 3.

3. Using an open end wrench, turn Bolt clockwise to lower the Press Plate Assembly, or counterclockwise to raise it up (to accommodate larger stock). Count the number of turns.

4. Adjust the Bolts with equal number of turns. The Press Plate Assembly (17) must be flush with the Body (18) when closed. If one side is not flush, readjust the side.

5. On the opposite side of the Brake, repeat steps 1 through 4.

Adjust Bolt (6) with the same number of turns. The Press Plate Assembly (17) must be flush with the Body (18) when closed. If one side is not flush, readjust that side.

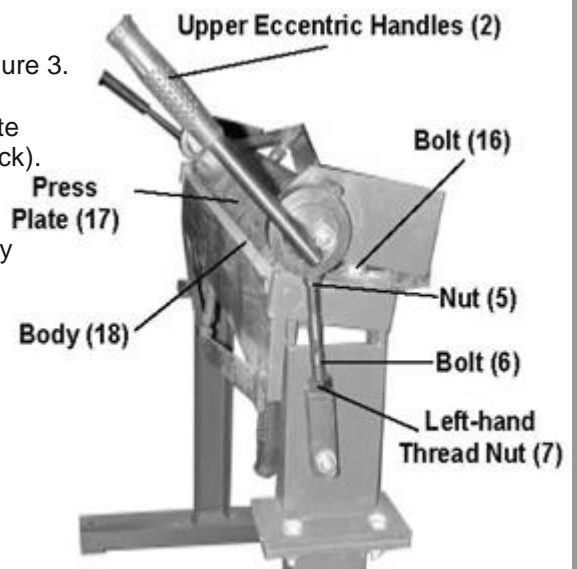


Figure 3

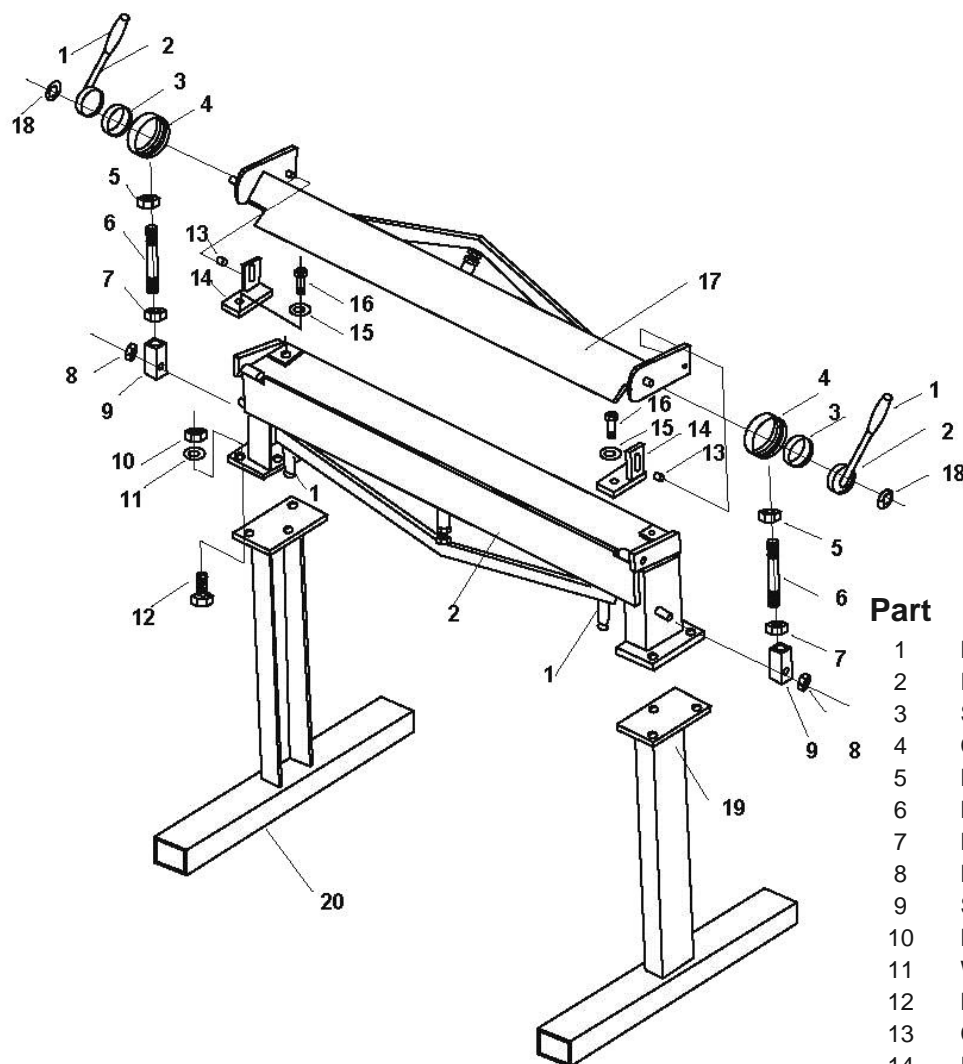
Align the Press Plate In or Out

1. Lift both Upper Eccentric Handles all the way up.
2. Loosen Bolts (16) on each side of the Brake.
3. Nudge each side of the Press Plate in or out.

Note: This adjustment will determine the roundness of the bend. The farther back the Press Plate Assembly, the rounder the bend. A typical setting should be between 1/16 to 1/8 inch behind the inner edge of the Body. The thickness of the sheet metal may also require an adjustment here.

4. Check that the Press Plate Assembly is parallel to the inner edge of the Body.
5. Retighten both Bolts.

PARTS LIST AND DIAGRAM



Part	Description	Qty
1	Handle	4
2	Eccentric Handle	2
3	Slide Bearing	2
4	Cover	2
5	Nut (M14 x 1.5)	2
6	Bolt	2
7	Left-hand Thread Nut (M14 x 1.5)	4
8	Lock Nut (M12)	4
9	Square Steel Holder	2
10	Nut (M10)	6
11	Washer (M10)	6
12	Bolt (M10 x 30mm)	6
13	Copper Cover	2
14	Press Plate Bracket	2
15	Washer	2
16	Bolt (M12 x 40)	2
17	Press Plate Assembly	1
18	Body	1
19	Right Brake Stand	1
20	Left Brake Stand	1