

OVERVIEW

When using a sheet metal break, you can expect a versatile tool for bending and shaping sheet metal with precision. The various components of the break, such as the bending leaf apron, clamping fingers, angle bar, and clamp handles, work together to securely hold and position the sheet metal. By adjusting the lock nuts and setback knob, you can accommodate different material thicknesses and set the desired bend radius. Following the step-by-step process of clamping the metal, bending it to the desired angle, and ensuring a secure hold, you can expect accurate and professional results for creating boxes and intricate bends.

PARTS

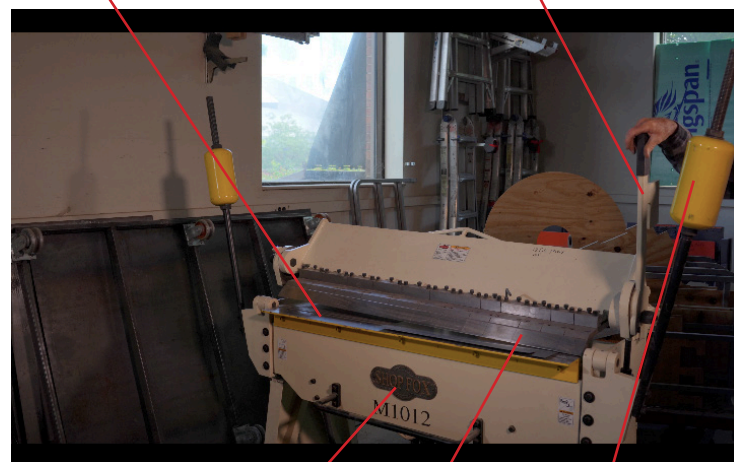
- Bending leaf apron handle
- Bending leaf apron
- Angle bar: used for supporting and bending the sheet metal
- Clamping fingers
- Clamp handles: used to raise and lower the clamping fingers
- Counterweights
- Setback knob: used for adjusting the bend radius
- Lock nuts: used to adjust the gap between the angle bar and clamping fingers to accommodate different material thicknesses



Bending leaf apron handle Bending leaf apron

Angle bar

Clamp handle



Bending leaf apron Clamping fingers Counter weight

PROCEDURE

Here are the steps to follow when using the sheet metal brake:

1. Lift and push the clamping bar handle back to raise and open up the clamping fingers and create a gap between the angle bar and clamping fingers. This gap allows you to insert your sheet metal.



2. Carefully position your sheet metal on the angle bar, ensuring it is placed beneath the clamping fingers. Be cautious not to put your fingers underneath.



3. Once your sheet metal is in the desired position, lower and pull the clamping bar handle towards you to secure the clamping fingers and firmly hold your sheet metal.



4. Verify that your sheet metal is securely clamped and not loose or shifting. If it is not secure, you need to adjust the lock nuts. By loosening or tightening the lock nuts, you can modify the clamping pressure based on the thickness or gauge of the sheet metal. Additionally, you can adjust the gap between the angle bar and clamping fingers to accommodate different thicknesses or gauges of sheet metal.

- Set the desired bend radius by adjusting the setback knob. To increase the radius for larger bends, turn the setback knob clockwise, which moves the clamping fingers backward.

5. Once the radius is set and your material is clamped, grip the bending leaf handles located below and pull upward to bend your sheet metal to the desired angle.



Bending leaf apron handle



- Lower the bending leaf back down.



- Lift the clamp bar handles at both sides and remove your sheet metal. Inspect the bend to ensure it meets your requirements.



Clamp handle

