

Metal Brake with Stand

MB-36 (36")

MB-40 (40")



Operating Manual

I. SAFETY WARNING & CAUTIONS



WARNING : When using machine tools, machines, or equipment, basic safety precautions should always be followed to reduce the risk of fire and personal injury. **READ ALL INSTRUCTIONS BEFORE USING THIS TOOL!**

1. **KEEP WORK AREA CLEAN.** Cluttered work benches and dark work areas may cause accidents or injury.
2. **OBSERVE WORK AREA CONDITIONS.** Do not use machines or powered tools in damp, wet, or poorly lit locations. Don't expose to rain. Keep work area well lit.
3. **KEEP CHILDREN AWAY.** Children must never be allowed in the work area. Do not let them handle machines, tools, or extension cords.
4. **STORE IDLE EQUIPMENT.** When not in use, tools must be locked up in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
5. **DO NOT FORCE THE TOOLS.** It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool's capacities.
6. **USE THE RIGHT TOOL FOR THE JOB.** Do not attempt to force a small tool or attachment to do the work of a large industrial tool. Do not use a tool for a purpose for which it was not intended.
7. **DRESS PROPERLY.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
8. **USE EYE AND EAR PROTECTION.** Always wear ANSI approved chemical splash goggles when working with chemicals. Always wear ANSI approved impact safety goggles at other times. Wear a full-face shield if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, and chemical dusts and mists.
9. **DO NOT OVERREACH.** Keep proper footing and balance at all times. Do not reach over or across running machines.
10. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. The handles must be kept clean, dry, and free from oil and grease at all times.
11. **STAY ALERT.** Watch what you are doing; use common sense. Do not operate any tool when you are tired.
12. **CHECK DAMAGED PARTS.** Before using any tool, any part that appears damaged should be carefully checked to determine that it would operate properly and perform its intended function. Check for alignment and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the tool if any switch does not turn on and off properly.
13. **REPLACEMENT PARTS AND ACCESSORIES.** When servicing, use only identical replacement

parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from the distributor.

14. **DO NOT OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.** Read warning labels on prescriptions to determine if your judgment of reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.
15. **SAFETY GLASSES AND EAR PROTECTION must be worn during operation**

Note: The warning and instructions contained in this instruction manual cannot cover all possible conditions and situations that may occur when using this product. It must be understood that common sense and caution are factors, which cannot be built into this product. These factors must be supplied by the person whom operating this piece of equipment.

II. GENERAL FEATURES & SPECIFICATIONS

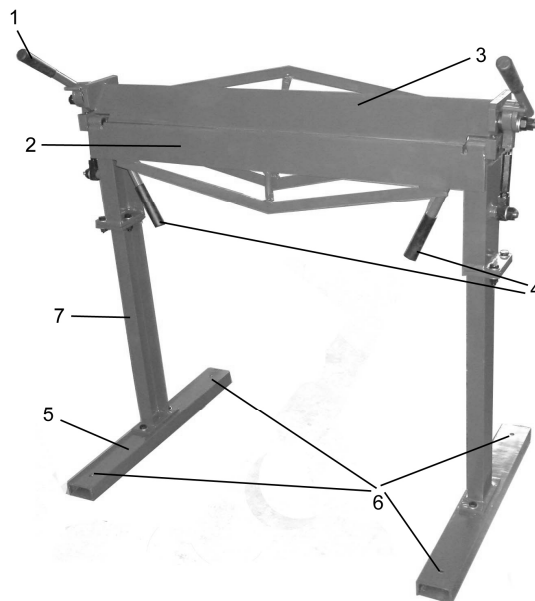
Feature & Specifications:

- 36 (40) Inch Metal Brake
- Includes Stand
- Bends Mild Steel As Thick As 12 Gauge
- Bends Stainless Steel As Thick As 16 Gauge
- Bending Angle Range 0-120°
- Easily Bolts To Workbench

III. PACKAGE CONTENTS

COMPONENTS:

1. Upper Handles
2. Body
3. Press Plate Assembly
4. Lower Handles
5. Mounting Foot
6. Mounting Holes
7. Stand



The Metal Brake is shipped in one ply-wooden case, include the metal brake and the stand. Please review contents before assembly

IV. ASSEMBLY



:The Brake is VERY heavy and requires that two people assist with assembly and installation.

1. Put the brake on the floor and position the mounting feet facing forward.
2. Put the left brake stand mounting pad facing against the left mounting foot. Assemble with the bolt, washer and nut and tighten securely.
3. Put the right brake stand mounting pad facing against the right mounting foot. Assemble with the bolt, washer and nut and tighten securely.
4. With the help of two people, lift the Brake and Stand upright.
5. Put the Brake and Stand where it will be mounted to the floor and mark through the holes on the left and right side.

WARNING: Make sure that you will not be drilling through electrical conduit or water pipes, before drilling the mounting holes.

6. Drill holes to the floor. Secure the brake with bolts, lock washers, & nuts (not included).

V. OPERATION



: Do not bend stock that is thicker than 12 gauge. You will damage the rake. Measure the thickness before use. During bending, keep both hands on the lower handles.

1. Lift up the Handles to open the Press Plate Assembly. Insert sheet metal that you want to bend over the Body and under the upper Press Plate Assembly. Slide sheet metal and align the bend marks on the metal to the inner lip of the Body.
2. Press down on both Handles to the locked position. This will cause the upper Press Plate Assembly to clamp down on the stock. If the Handle does not come down all the way and lock, either the stock is greater than 12 gauge, or the Brake needs to be adjusted to allow for a thicker stock.
3. 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 down position.
4. Lift the upper Eccentric Handles all the way up and remove the sheet metal.

VI. MAKING ADJUSTMENTS

You may need to adjust the position of the Press Plate Assembly to allow for thicker or thinner pieces of sheet metal, or to align it to the Body.

Adjust for Thickness of Sheet Metal

Lift the upper handles all the way up and loosen nuts to allow the bolt to move up or down. Using an open end wrench, turn the bolt clockwise and move the Press Plate Assembly down, or counterclockwise to move it up (for large stock).

Determine the number of turns, then tighten the nuts to secure the bolt. Repeat on opposite side.

Adjust bolt with the same number of turns. Press Plate Assembly must be flush with the body when closed. If one side is not flush, readjust that side.

Align the Press Plate Assembly In or Out

Lift both upper Handles. Loosen the bolts on each side. Nudge each side of the press plate assembly in or out. This 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.

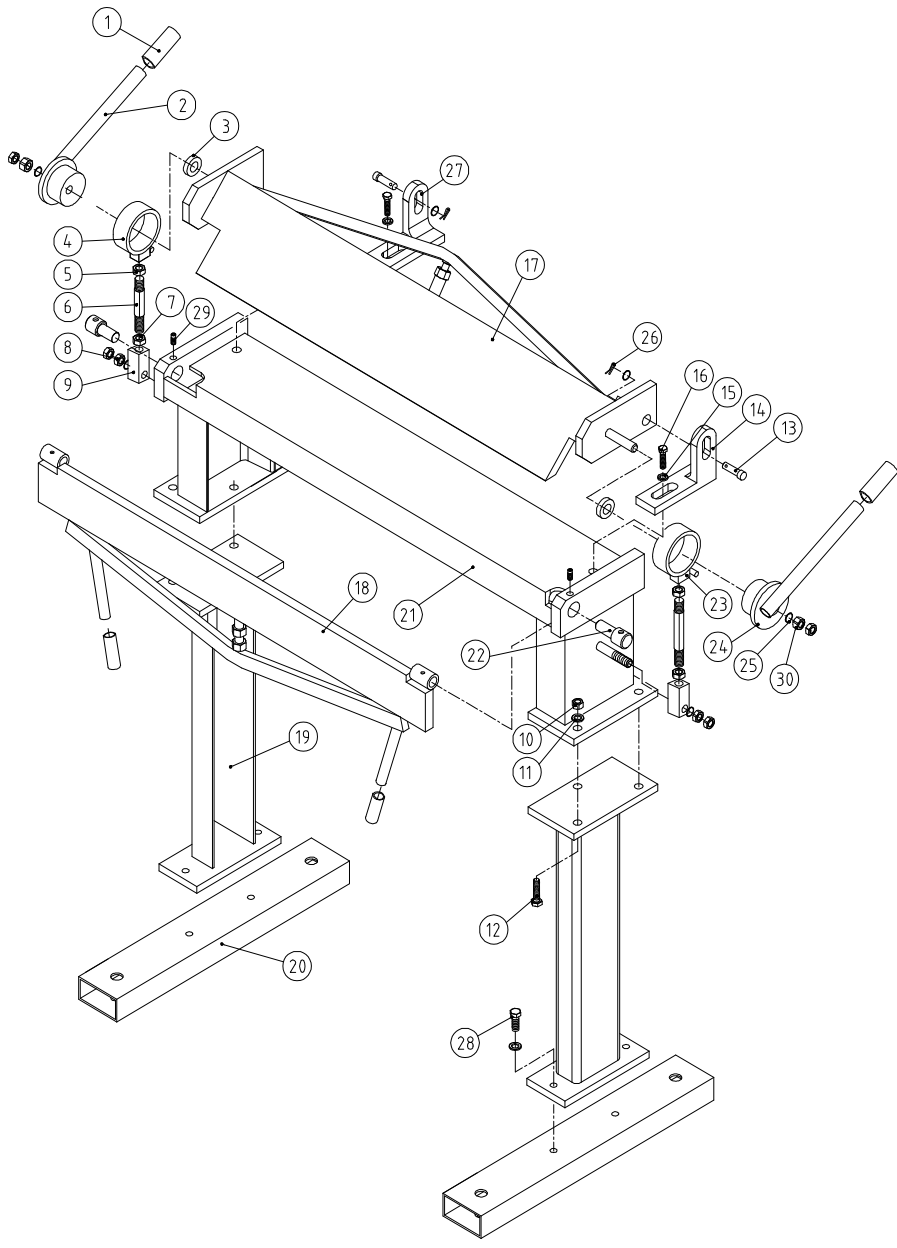
VII. MAINTENANCE and SERVICE

 **WARNING** : Always use caution when moving or handling the metal brake.

- 1. Lubricate all moving parts periodically. Use a light oil.**
- 2. Tool service must be performed only by qualified repair personnel.** Service or maintenance by unqualified personnel could result in a risk of injury.
- 3. When servicing a tool, use only identical replacement parts and follow instructions in the manual.** Use of unauthorized parts or failure to follow Maintenance Instructions may create a risk of shock or injury
- 4. SAVE THESE INSTRUCTIONS FOR FUTURE REFERENCE.**

This manual contains important information regarding safety, operation, maintenance and storage of this product. Before use, read carefully and understand all warnings, cautions, instructions and labels. Failure to do so could result in serious personal injury, property damage or even death.

VIII. PARTS DRAWING



IX. PARTS LIST

Part No.	Description	Qty	Part No.	Description	Qty
1	Handle cover	4	16	Bolt M16x35	2
2	Left crank handle	1	17	Upper press plate	1
3	Washer	2	18	Bending leaf	1
4	Left eccentric bushing	1	19	Leg for stand	2
5	Nut M10	2	20	Level plate for stand	2
6	Connecting shaft	2	21	Frame	1
7	Nut M10-turn left	2	22	Turning shaft	2
8	Lock nut M16	6	23	Right eccentric bushing	1
9	Square steel holder	2	24	Right crank handle	1
10	Lock nut M12	6	25	Washer 16	2
11	Washer 12	10	26	Pin $\Phi 3$	2
12	Bolt M12x35	6	27	Left bracket plate	1
13	Shaft	2	28	Bolt M12x25	4
14	Right bracket plate	1	29	Bolt M12x12	2
15	Washer 16	4	30	Nut M16	2

Note: This manual is only for your reference. Owing to continuous improvement of the machines, Changes may be made at any time without obligation on notice.