

SAVE THIS MANUAL

You will need this manual for the safety instructions, assembly and operating instructions and parts list. Put it in a safety, dry place for future reference. Keep your invoice with this manual. Write the invoice number on the inside front cover.

SPECIFICATIONS

Characteristic	Value
Height	38"
Mild Steel Capacity	5/16" x 1-1/4" or 1/4" x 2
Right Angle Bending Capacity	3/16" x 1-1/4" or 1/4" x 1-1/4"
Center Pin Capacity	1/4" thick (use 1" die for greater)
Solid Rod Capacity	1/2" (use 3" die)
Die Sizes	1", 1-1/4", 1-1/2", 1-3/4", 2", 2-1/2", 3"

SAFETY WARNING & CAUTIONS

1. **KEEP WORK AREA CLEAN.** Cluttered areas invite injuries.
2. **KEEP CHILDREN AWAY.** All children should be kept away from the work area. Don't let them handle the tool.
3. **DO NOT OPERATE THE 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.
4. **AVOID MOVING PARTS DURING OPERATION.** Keep fingers and hands away from moving parts.
5. **USE EYE AND EAR PROTECTION.** Use an ANSI approved impact safety goggle.
6. **DRESS SAFELY.** Protective, gloves and non-skid footwear loose clothing or recommended when working with and operating the tool. Don't wear loose clothing or jewelry. They can get caught in moving parts. Also, wear a protective hair covering to prevent long hair from getting caught in the tool.
7. **DON'T OVERREACH.** Keep proper footing and balance at all times.
8. **STAY ALERT.** Watch what you are doing. Use common sense. Do not operate any tool when you are tired.

UNPACKING

If any parts are missing or broken, please call the distributor at the number on the cover of this manual.

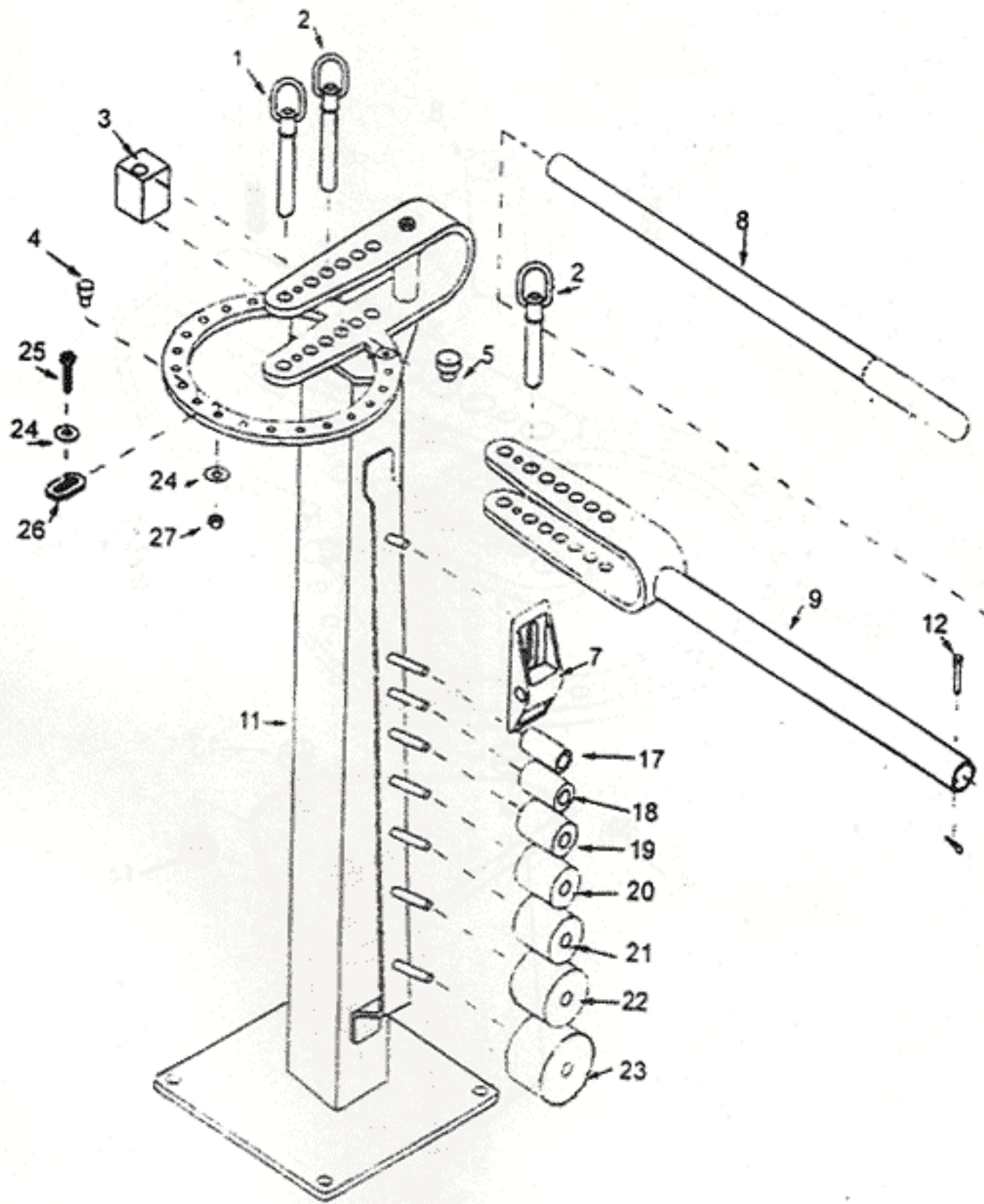
Part #	Description	Quantity
1	Long Hitch Pin	2
2	Short Hitch Pin	1
3	Square Stop Block	1
4	Stop	1
5	Support Pin	1
6	Ring Assembly Spacer	1
7	Right Angle Bending Attachment	1
8	Inner handle	1
9	Outer Handle/Die Receiver	1
10	Ring Assembly/Die Receiver	1
11	Stand	1
12	Handle Pin and Hair Clip	1
13	Mounting Spacer	3
14	3/8" Nut	4
15	3/8" x 5-1/4" Mounting Bolt	1
16	3/8" x 7/8" Mounting Bolt	2
17	1" Die	1
18	1-1/4" Die	1
19	1-1/2" Die	2
20	1-3/4" Die	1
21	2" Die	1
22	2-1/2" Die	1
23	3" Die	1
24	3/8" Washer	2
25	3/8" x 1-3/8" Mounting Bolt	1

MAINTENANCE

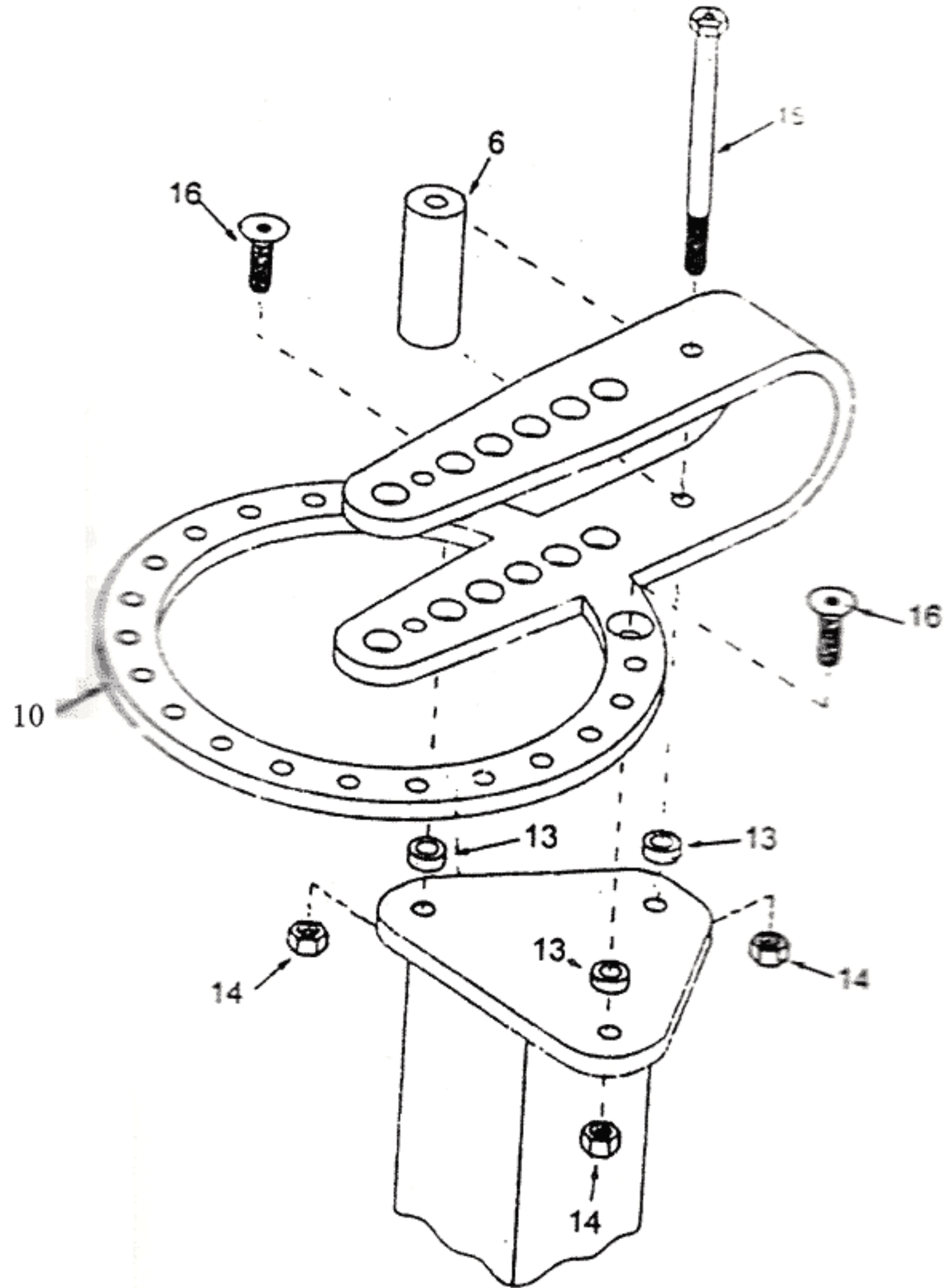
Regular lubrication will help lengthen the life of your Bending Brake. Always inspect the tool use for damaged parts. Replacement part may be purchased through distributor.

Parts Numbers, Please refer to the sheet of Page 4

Exploded View - A



Explode View - B



OVERVIEW

Your new Compact Bender is designed to make bends in flat, square or round solid metal. It may be used to create sign letters, anchor bolts, U bolts, pipe clamps, handles, and more. It is light enough to be used as a portable bender on trucks or trailers.

ASSEMBLY

- Step 1: Bolt the STAND (#11) to a stable surface.
- Step 2: Place the three mounting spacers(#13) over the three holes on the top of the STAND as shown in Figure1
- Step 3: Place the RING ASSEMBLY/DIE RECEIVER(#10) over the three MOUNTING SPACERS and secure using the two BOLTS(#16) and two NUTS(14#)
- Step 4: Place the RING ASSEMBLY SPACER(#6) between the back two holes of the RING ASSEMBLY and secure the entire assembly to the STAND using the MOUNTING BOLT(#15) and remaining NUT(#14)

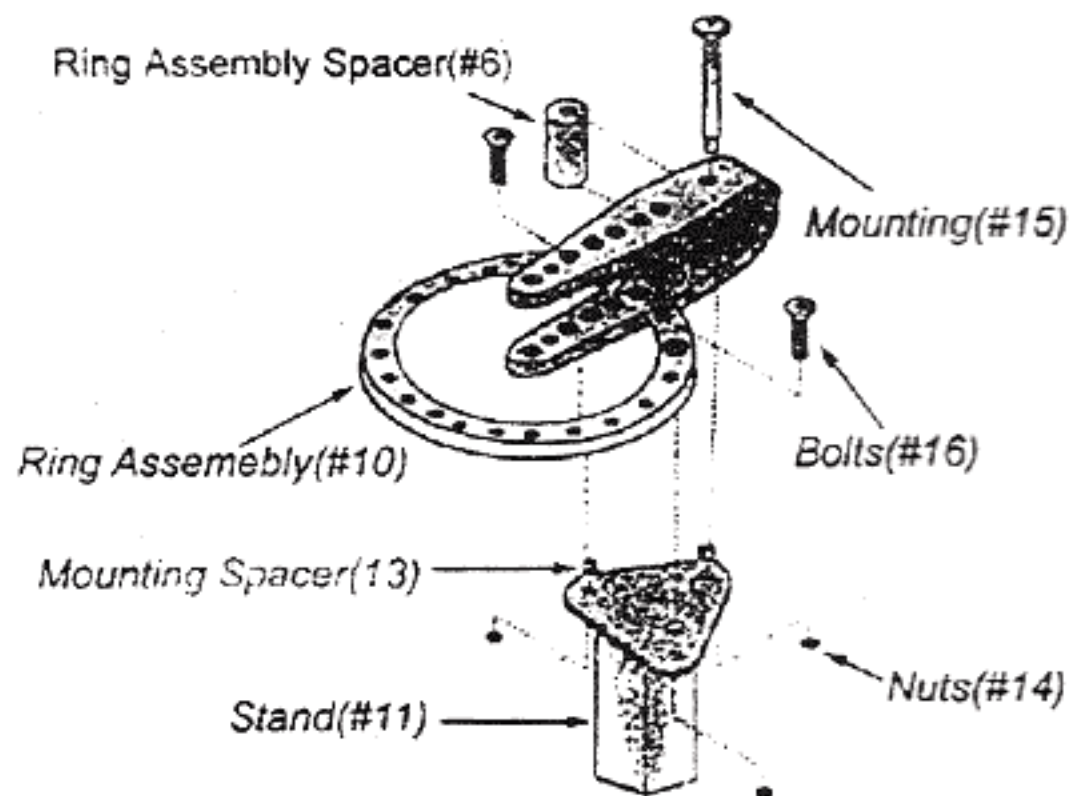


Figure 1 - Assembly

- Step 5: Place the HANDLE DIE RECEIVER(#9) between the ASSEMBLY SPACER DIE RECEIVER and secure in place using the LONG HITCH PIN(#1) as shown in Figure2

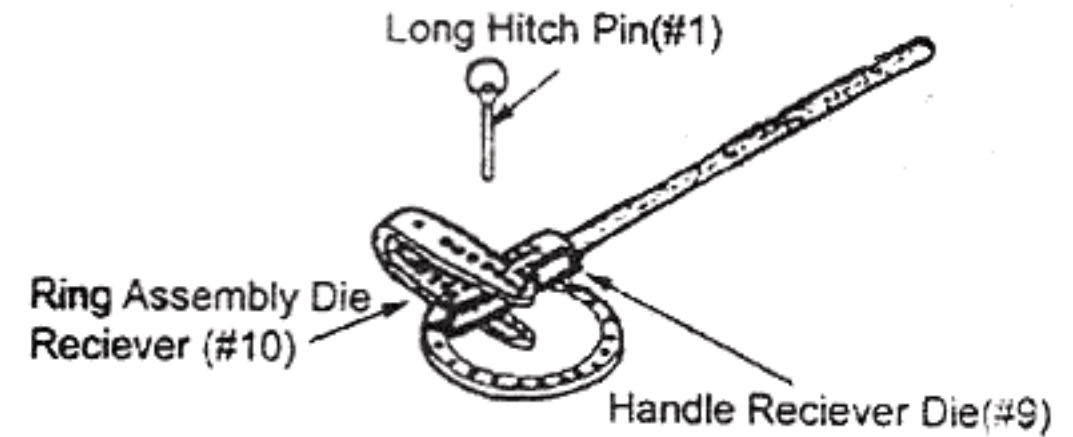


Figure 2 - Assembling Handle

OPERATION

The Stop Block

- Step 1: The Stop Block (#3) holds the workpiece in place while the selected bending DIE(#17-#23) on the HANDLE(#9) bends it around the LONG HITCH PIN(#1) or selected center DIE as shown in Figure 3. The workpiece will bend in the shape of the bending DIE around the LONG HITCH PIN (or center DIE). See Figure 3.

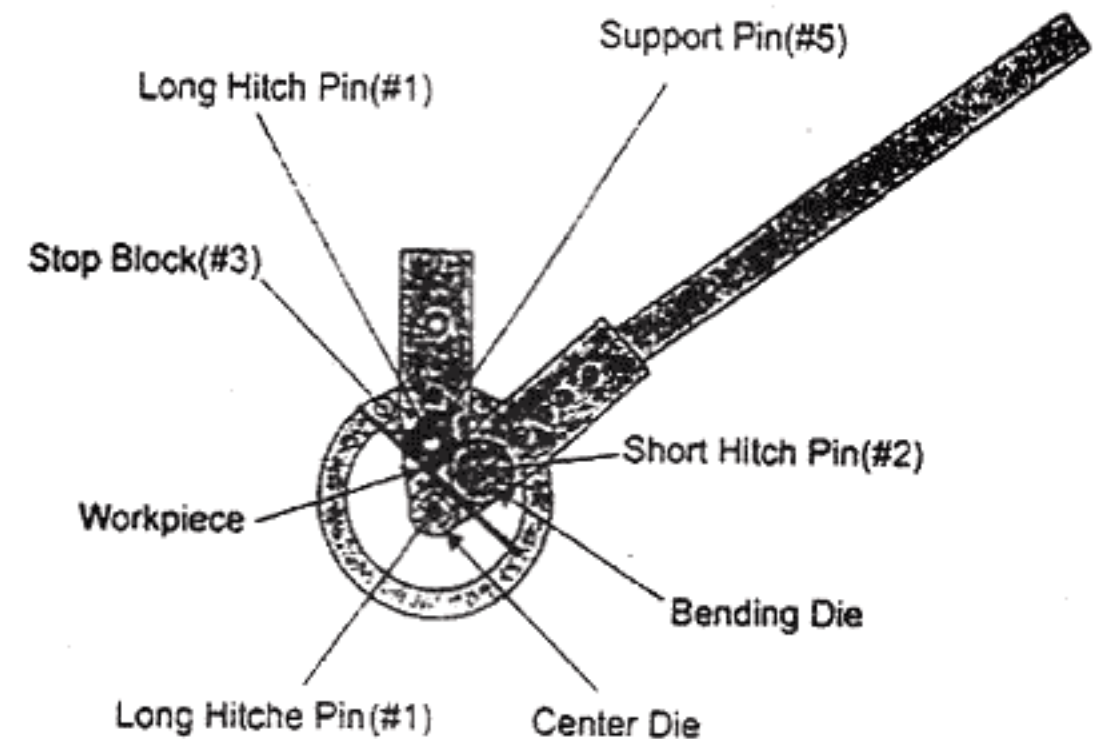


Figure 3 - Using Stop Block

Step 2: The STOP BLOCK and center DIE are secured using two LONG HITCH PINS. The bending DIE is secured one SHORT HITCH PIN(#2). The center DIE is always secured in the outer most holes of both DIE RECEIVERS.

Step 3: The SUPPORT BLOCK(#5) is used to raise the level of the STOP BLOCK so that it is even with the center DIE.

Step 4: The STOP BLOCK must be positioned in one of four ways. See Figure 4. Always position the STOP BLOCK so that it is as close as possible to the center DIE, while still allowing for the thickness of the stock.

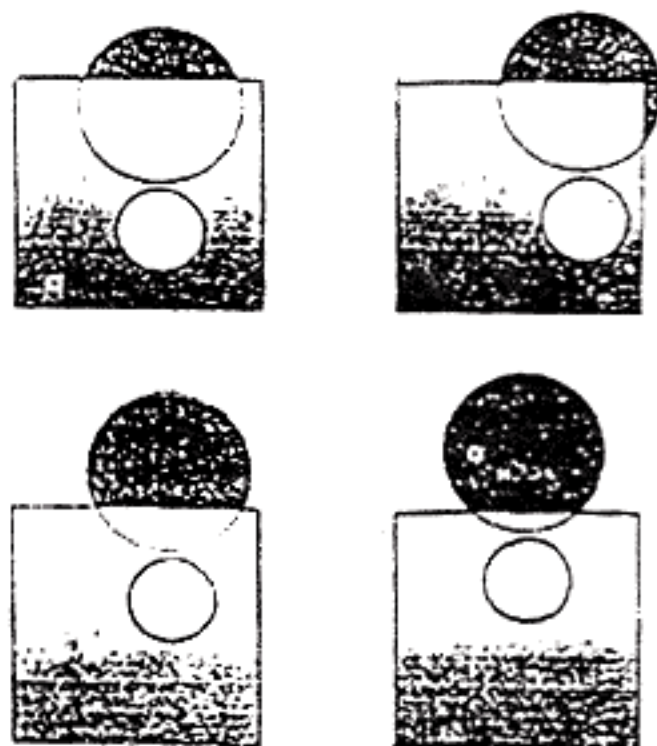


Figure 4 - Position of Stop Block.

Step 5: The stock must be positioned between the center DIE and both the bending DIE and a flat face of the STOP BLOCK.

Step 6: The STOP BLOCK & SUPPORT PIN must be moved away from the center die to accommodate thicker materials, and closer for thinner stock.

Step 7: The bending DIE is usually secured in the third hole in the of the HANDLE DIE RECEIVER, though this may depending upon the thickness of your stock.

The Right Angle Bending Attachment

Attach the RIGHT ANGLE BENDING ATTACHEMENT(#7) as shown in Figure 5.

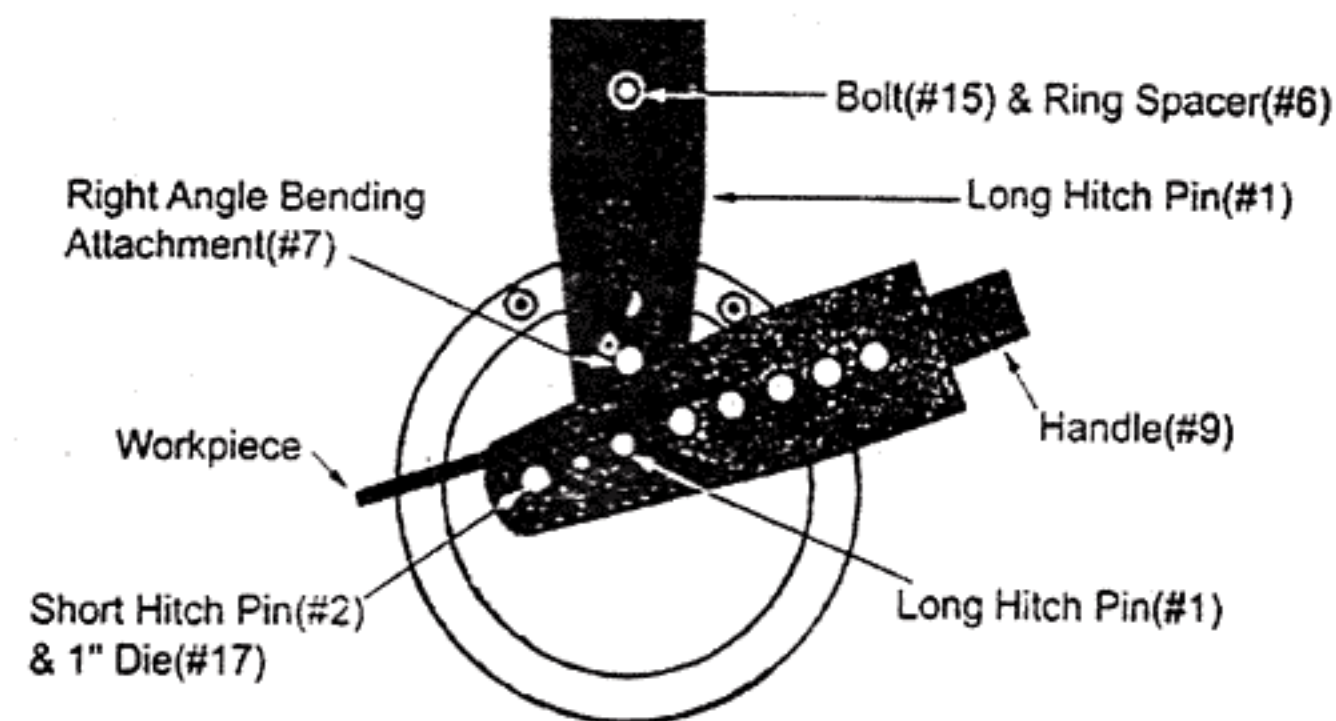


Figure 5 - Using Angle Bending

1. If the HANDLE(#9) will hit the stock due to its length, position the stock to the left of the handle.
2. HANDLE is always pulled clockwise.
3. Draw Lines with chalk on your stock at every desired interval prior to bending.
4. If you are making two or more bends, on the same piece of stock, add an additional 1/8" accommodate distance lost due to the bending.
5. Position chalk line on the edge of the RIGHT ANGLE BENDING ATTACHMENT so that only 1/2 of the line is visible.
6. Bend to the desired angle. Use a protractor for precise measurements
7. For complex operations, use cheaper stock as test material before using more expensive materials.