



Sheet Metal Pan & Box Brake



**Before Operating Your Tools,
Please Read This Instruction Carefully**



**ITEM NO.61- 251-127
MODEL NO . #SPBB1**

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Receiving and Unpacking

On receiving your machine, please examine if the outer packing is in good condition, then remove the cover to inspect whether there is any damage or loss caused during the transportation. If any is found, please immediately notify the transportation and your supplier. Some parts and accessories are knocked down and in bulk packing to save transportation space, please check those parts and accessories in extra care. List for parts and accessories in bulb pack as below:

Parts in bulk packing: Wrenches, Plastic handle covers(spare), Counterweight.

Top Half Adjustment

See the page4

Jaw Alignment

Before bending, please check if jaws of **Fingers(D)** forma straight bending edge, if not, please do not following process:

Loosen **Fingers Bolts(B)** in all fingers, with **Angle Bar(E)** mounted, bring the **Bending Half(F)** 90 degree up to straighten **Fingers(D)** in line, then tighten **Fingers Bolts(B)**.

Removable Fingers

The **Fingers(D)** are interchangeable easily, and there are three sizes of fingers, 2", 3" & 4", operator can combine any two or more pieces of fingers to brake certain length of steel sheet. Anyway, a full length of **Fingers(D)** can be used to become a standard hand brake.

Counter Balance

Counterweight can be raised or lowered to properly counterbalance the **Bending Half(F)**.

Bowed Bending Half Adjustment

If **Bending Half(F)** becomes bowed in center after quite a use, tighten both **Tension Bolts(H)** until center part is in a straight line with both ends.

Benefits and Applications

The Box and Pan Brake has all the outstanding functions of the hand brake. Besides, its removable, sectioned fingers provide additional depth and clearance for wide uses. The machine can form a box or pan with four sides and a bottom from one sheet of metal. The Box and Pan Brake is mostly used in the manufacture of electric switch box, panel board cabinets. Other extensive applications are in forming cases, buckets, carry boxes and all kinds of boxes and pans.

Caution

It is strictly forbidden to bend metal sheet thicker than the rated capacity, even in shorter length.

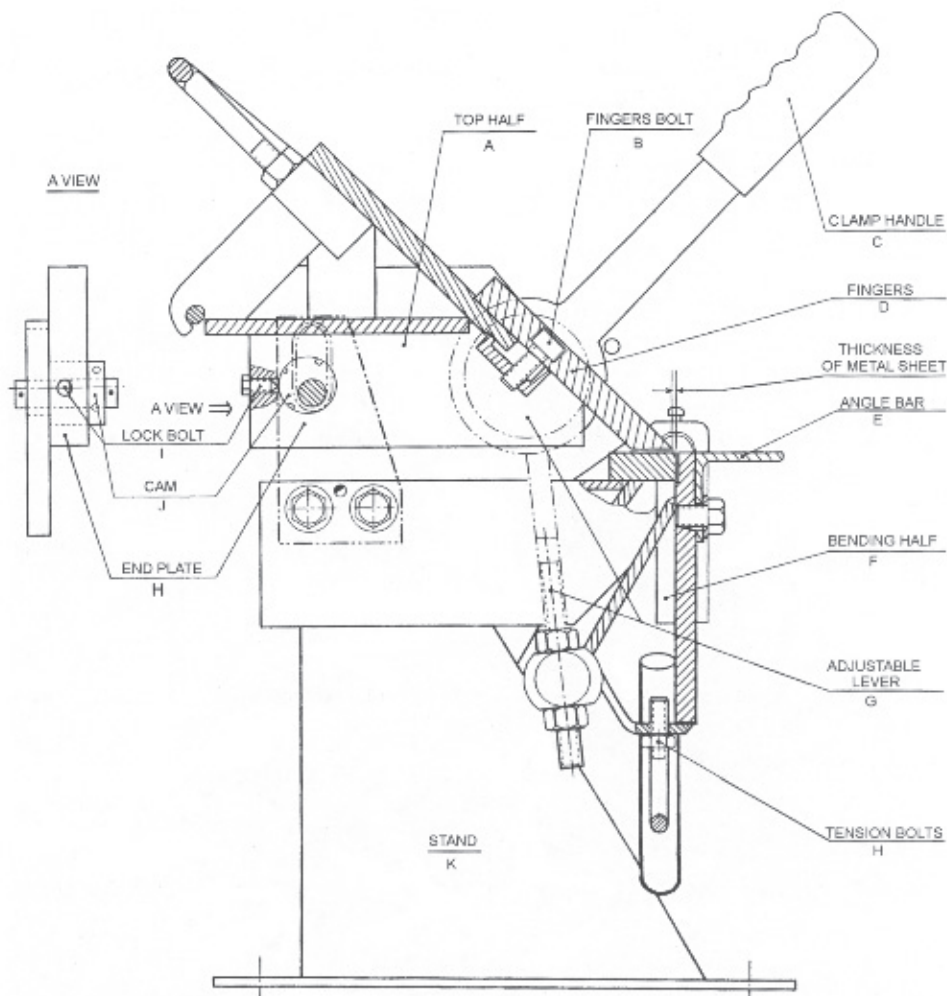
Never use pipe extensions on **Clamp handle(C)** for leverage.

Never bend against seams. It can be done only when **Adjustable Lever(G)** are adjusted to clamp the full multiple thickness of seam. Simultaneously the **Top Half (A)** is set back for clearance of the same multiple thickness.

Be aware to have **Angle Bar(E)** mounted to **Bending Half(F)** when making capacity bends.

Lubrication

Lubricate occasionally your machine with SAE-30 oil on all moving parts and into holes will insure smooth trouble free operation in long time use



◆ Top Half Adjustment

If customers need to adjust the Top Half(A) to adapt to different thickness of metal sheet, kindly please operate the machine as following steps:

1. Unclamp the **Clamp Handle(C)**
2. Loosen **Lock Bolts(I)** on end of the End Plats(H), be sure to make this step each side for **lock Bolt(I)** and **Cam(J)**
3. Turn the **Cam(J)** to move the **Top Half(A)** forward or backward in order to make bend according to different thickness of material.
4. Then clamp the **Clamp Handle(C)** to check if the edge of **Fingers(D)** is in straight line and has same clearance with the edge of the Stand in whole Flat, If not, adjust the **Cam(J)** to right position. Be attention that the clearance between edge of Fingers and edge of stand Flat is the thickness of sheet metal at least.

5. Tighten the **Lock Nut(I)** and then can bend the metal.

6. The **Adjustable Lever(G)** is used to raise or fall the **Top Half(A)** to adapt to different thickness of metal sheet.

◆ Capacity

The capacity of the brake is determined by the bending edge thickness provided by the **Bending Half(F)** and **Fingers(D)**. The operator can adjust the **Adjustable Lever(G)** and **Cam(J)** as showed behind to adapt to different thickness.

The maximum bending thickness for **130-4816** is **16 gage for mild steel**, and the maximum bending thickness for **130-4822** is **22 gage for mild steel**.

On capacity work, the reinforcing **Angle Bar(E)** must be in the normal or top position.

Capacity of brake will be reduced by 4 gages if without the **Angle Bar(E)**.

◆ Parts List

PART#	DESCRIPTION
1	NUT
2	HANDLE COVER
3	HANDLE LEFT
4	HADLE RIGHT
5	BUSH
6	SHAFT SLEEVE
7	SWIVEL FLFT
8	SWIVEL RIGHT
9	WASHER
10	SCREW
11	BREAK SUPPORT
12	PIN
13	WASHER
14	SHAFT
15	WOBBE SHAFT
16-1	FORMING FINGERS 2"
16-2	FORMING FINGERS 3"
16-3	FORMING FINGERS 4"
17	SCREW
18	NUT
19	KNUB BLOCK
20	SLAMP
21	STAND
22	BENDING LEAF

PART#	DESCRIPTION
23	SHAFT
24	BUSH
25	ANGLE BAR
26	SCREW
27	SCREW(FOR 130-4816 ONLY)
28	COUNTER WEIGHT (FOR 130-4816 ONLY)

PARTS DRAWING

