Sheet Metal Brake

Purpose
The sheet metal brake is a device for bending. This tool is great for bending a piece of metal into a box sheet metal.

Safety
- Keep hands clear of the clamping bar and magnetic pieces during clamping.
- Keep hands clear of the rotating joint during bending.
- Stand on the side of the machine to avoid getting hit with the bending apron as it comes up to bend.
- DO NOT run the magnetic brake without material between the clamping bar and the electromagnetic work-bench.

Startup and Running Procedure
1. Make sure the machine is plugged in.
2. Press red POWER rocker switch to turn on the machine.
3. Slide Material to desire location.
4. Engage the magnet before bending, either use the foot pedal connected to the brake, or push the green START button on the front of the machine.
5. Rotate the bending arms to bend the metal to the desired angle.
   a. It is recommended to bend a few degrees past the desired angle because, because of springback effects.

Shutdown Procedure
1. Lower the arm, and hold the red off button for 3 seconds to release the magnetic clamp.
2. Turn off the power rocker on the front of the machine.
3. Remove your part.

Tool Usages
- This tool can produce bend angles of 0-180 degrees
- This tool can produce circular bending
- The widest piece this brake can bend is 4ft

Materials
Sheet Metal: works best with aluminum or a mid grade steel
- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Metal sheets are advised to have a max thickness of 1/16 in

Video Link
https://www.youtube.com/watch?time_continue=334&v=zWvMW1Zxoyc
https://www.youtube.com/watch?time_continue=152&v=RnqFnShSJvQ