

MODEL W1×305(12")

70 34

MODEL W1×610(24")

**HAND BRAKE
INSTRUCTION MANUAL**

Please read this manual carefully before installation and operation.

1. Usage

This machine is suitable for Processing carbon steel plate with thickness no more than 1mm (model W01-1x305) (12") (model W01-1x610) (24"), with width no more than 305mm (model W01-1x305) or 610mm (model W01-1x610) and other plate materials, such as non-ferrous metal, etc. with similar thickness.

2. Main technical specification

- 2.1 Max. bending thickness : 1.0 mm
- 2.2 Effective bending width: 305 / 610 mm
- 2.3 Gross weight: 23 / 32 kgs
- 2.4 Net weight: 17 / 24 kgs
- 2.5 Outside dimension: 470 × 250 × 300 mm
775 × 250 × 300 mm

3. Main structure

The structure of this machine is welded high quality steel. The clamping part is cam device. The brake part is heat-treated. This machine has many advantages.

4. Installation and caution

4.1 Installation

- 4.1.1 Please check whether the parts of this machine are fully equipped and not damaged according to the parts list.

4.1.2 This machine should be mounted on a hard floor or a specific stand (not supplied).

4.1.3 Please leave plenty room around the machine for your easy operation, in order to avoid injury.

4.1.4 Please remove the anti-rust grease on the processing surfaces and some parts included with kerosene.

4.2 Caution

4.2.1 Please study this manual before operation and make yourself understand its structure and principle completely.

4.2.2 Please don't operate the material longer than its max. processing width range.

4.2.3 Please don't touch the brake dies during operation.

5. Operation and maintenance

This machine is pre-adjusted before out of factory.

When you want to bend, please raise handle (14#), upper press assembly (04#) will leave the work table with adjustment because of the connecting rod-resulted from the eccentric shafts (13#, 22#).

Please insert the workpiece and let its bending line with the oblique angle of upper dies which being under the upper press assembly (04#), and then lower the handle (14#) tightly until until the eccentric shafts (13#, 22#) are on the dead points without bouncing back.

Then this workpiece can be pressed tightly. you can bend it to an degree which you required .

When you want to bend thicker or thinner workpiece, please adjust blots (10#) and eccentric shafts (05#), the upper press assembly (04#) will move back and forth as you like for a little distance, which will do good for bending and pressing the workpiece.

6 Lubrication

Please lubricate the rotating parts of the machine every day.

7 Parts list

Item#	Description	Qty.	Item#	Description	Qty.
01	Bending assembly	1	12	Bushing	2
02	Shaft	1	13	Right eccentric shaft	1
03	Body	1	14	Screw rod	1
04	Upper press assembly	1	15	Handle jacket	1
05	Eccentric shaft	2	16	Pin-shaft	2
06	Connecting block	2	17	Split pin	2
07	Washer 6	4	18	Screw M5×8	4
08	Screw M6×10	4	19	Flat key	2
09	Nut M10	2	20	Bushing	4
10	Bolt	2	21	Small shaft	2
11	Nut M10	2	22	Left eccentric shaft	1

8. Diagram

