

**** INSTRUCTIONS****

CONNECTICUT BOX & PAN BRAKE

Set the brake on a level bench and shim under the feet until it rests evenly and will not rock. Fasten to bench with lag screws.

CONNECTIUCUT UNIVERSAL BENCH BRAKES are rated according to the catalog capacity for a full length bend in mild steel at least 3/8" from the edge of the sheet. An adjustment of 1/8" is provided in the position of the beam for material thickness and radius of bend. This is controlled by eccentric pins No. 66 and locking set screws at the rear of the machine, each end. There should be clearance of at least one and one-half times the thickness of material between the apron and edge of beam, when the apron is at the 90 degree position. For bending stainless, reduce the capacity by 4 gauges.

The work is clamped between the Bed and the tips of the Fingers by means of Eccentric Levers No. 26. With all fingers in place, the Universal Brake operates the same way as the plain Bench Brake. To make a bend, raise the apron handles to the desired angle, forcing the clamped work to bend around to tips of the fingers. In making a box or pan, the sides are bent up first. To bend the ends, group the fingers to a total width equal to the box, leaving a space each side of this group by omitting a Finger. Clamp the end of the box under the grouped Fingers. When the Apron is raised to bend up the end, the sides already formed will pass to each side of the Fingers, avoiding interference. The maximum depth of box is 3".

Clamping pressure is controlled by nuts No. 45. This pressure should be adjusted with a small piece of the material to be bent clamped in each end of the machine. Move the nuts so that the levers No. 26 pull against the stops with equal effort. Excessive clamping pressure is not required. Use only enough to hold the material firmly in the brake

These brakes are not intended for bending rods, wires, multiple thicknesses or across lock seams. Operations of this type will result in denting the edge of the apron and springing the machine out of line.

Lubricate the moving parts of the machine with light grease or heavy oil. Lasting accuracy depends on proper lubrication.

Parts List For U-218, U-322, U-422, 218, 322, 422

<u>No.</u>	<u>Description</u>	<u>Part No.</u>
9	Bed Assembly	Consult Brennan
14	Tie Rod Nut	643023007
17	Strap bolt	457160098
18	Strap Nut	643023007
24	Toggle Assembly	LH 757860021 RH 757860022
24B	Toggle Bushing 2"	757080020
26	Eccentric Assembly (Inc. Bushing)	RH 757030024 LH 757030025
26B	Eccentric Bushing	757080023
26G	Handle Grip	633356335
29	Apron Assembly	Consult Brennan
34	Hinge Pin	757160083
45	Toggle Nut	643023007
49	Set Screw	621012083
57	Snap Ring	656164301
59	Lower Toggle Pin	757160030
63	Lock Nut	666023009
63B	Spring Washer	657033155
66	Eccentric Slide Pin	757160031
66B	Slide Pin Bushing	757080039
66S	Slide Pin Set Screw	621012083
76	Beam Assembly	Consult Brennan
126	Finger 2" Assembly complete	255940011
126	Finger 3" Assembly complete	255940012
126	Finger 4" Assembly complete	255940013
127	Finger clamp 2"	757010042
	3"	757010043
	4"	757010044
151	Finger Screw	613012135

