

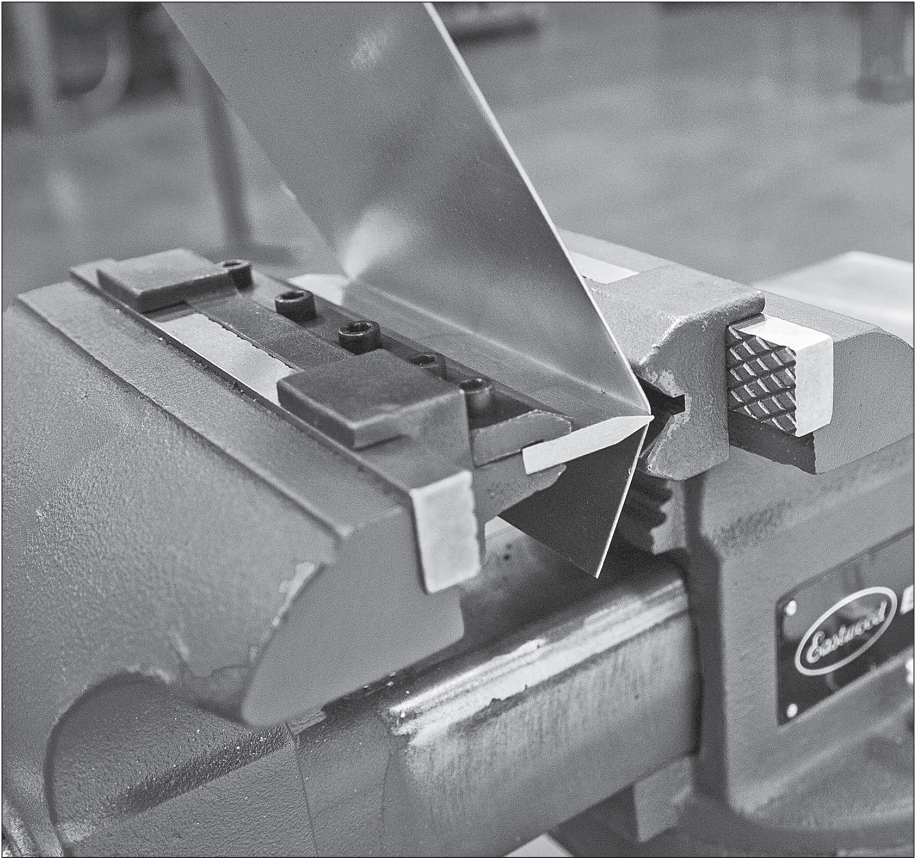


DO THE JOB RIGHT.®

Item #21640
#21641

VICE PRESS BRAKE

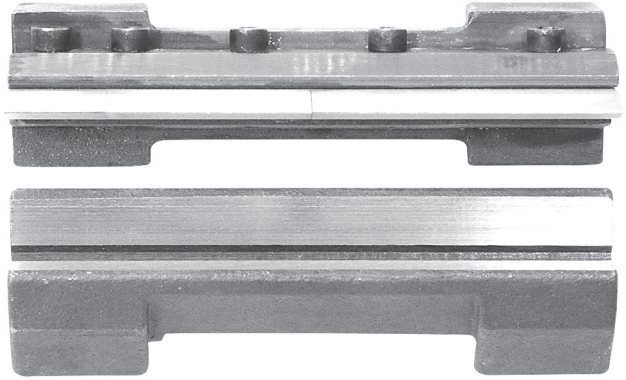
INSTRUCTIONS



The **EASTWOOD 4" AND 6" VISE PRESS BRAKES** are precision engineered metal working tools designed to produce crisp, accurate, bends at angles up to 90° in mild steel and aluminum up to 14 gauge, and 18 gauge stainless in widths up to 4" for the 21640 and 6" for 21641. Create complex shapes such as reinforcement channels, ribs and much more all with one convenient, easy to store tool.

CONTENTS

- (1) Male Die Holder/Dies
- (1) Female Die



SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.

SAFETY INFORMATION



⚠ READ INSTRUCTIONS

- Thoroughly read and understand this manual before using.
- Save for future reference.



⚠ WARNING PINCH AND CRUSH HAZARD!

- The Eastwood Vise Press Brake consists of sharp metal components which can present a hand/finger pinch hazard and cause potentially serious injuries. Avoid pinching hands while handling. Keep fingers and hands away from moving parts when operating.



⚠ WARNING CUT HAZARD!

- Handling sharp metal can cause serious cuts. Wear thick, well-fitting work gloves to prevent cuts from handling sharp metal.



⚠ WARNING EYE INJURY HAZARD!

- Metal particles can be ejected from the metal surface when bending. Sheet metal edges and corners are sharp and can injure eyes. Always wear ANSI approved eye protection when operating this tool.



⚠ WARNING

- Before beginning ANY work with this tool, it is absolutely necessary that it be mounted in a properly sized vise securely bolted to a sturdy, workbench anchored to the floor or wall.
- Strenuous physical force may need to be applied to the Vise Press Brake during use. Failure to ensure proper footing can quickly result in a fall which could inflict serious personal injury or property damage. Always work in a clean, uncluttered environment.
- Be sure there is sufficient working room around the tool to allow for safe handling of various sizes of metal.

⚠ NOTICE

- Excessive resistance while operating could indicate a defect with the workpiece material or broken or damaged Vise Press Brake components. To avoid injury, stop work immediately and inspect workpiece material for nicks, dents, welds, excessive scale or remaining coatings. Clean or repair as necessary or discard and begin with a new piece. Also inspect Vise Press Brake components for looseness or damage.

SET-UP

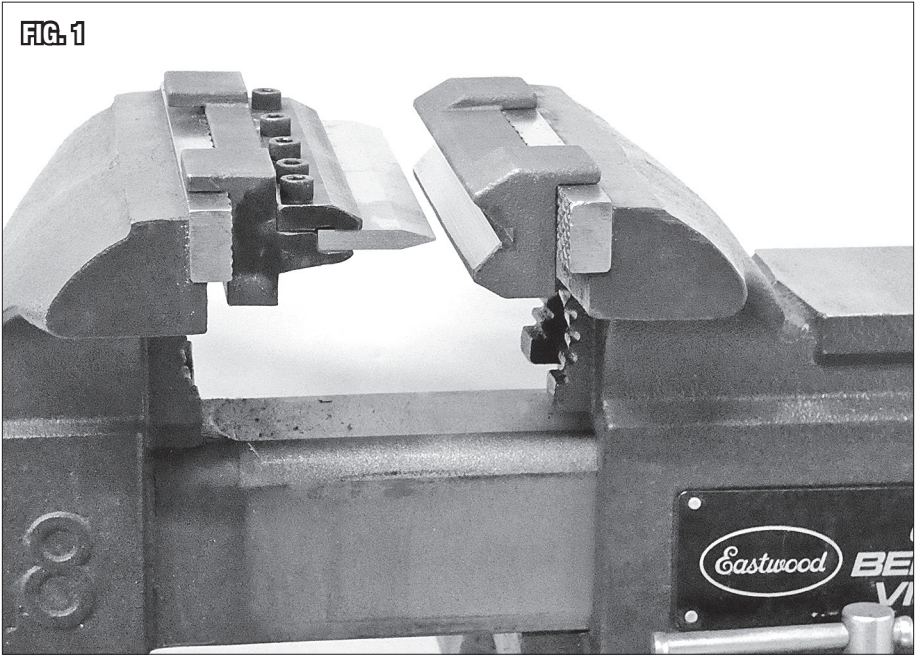
▲ NOTICE

The Eastwood Vise Press Brakes are designed only for use in a properly and securely mounted Vise.

Use only in a vise properly sized for the Eastwood Vise Press Brake. Use a 4" or larger vise for the 4" Vise Press Brake and a 6" or larger vise for the 6" Vise Press Brake.

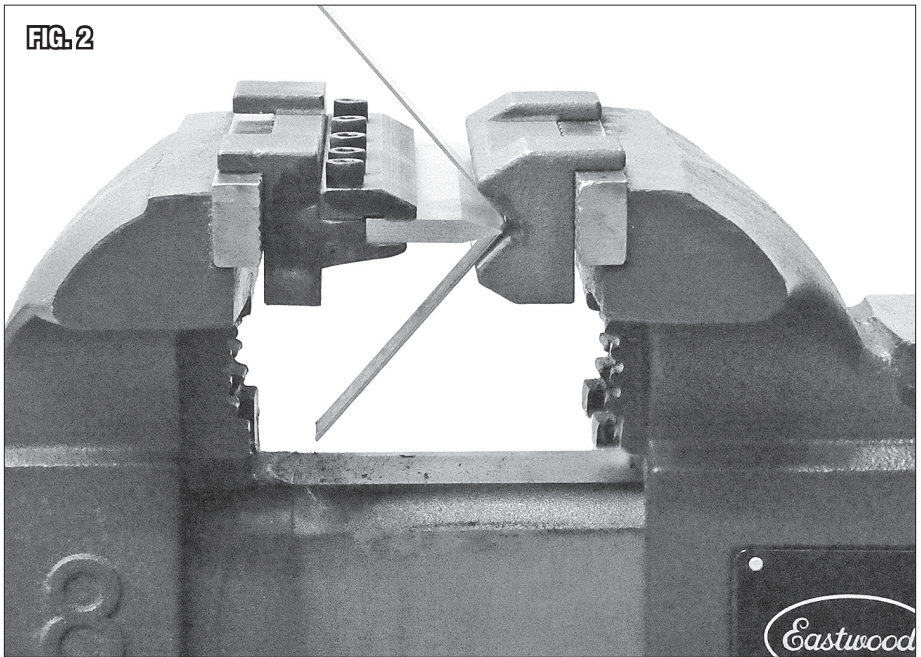
- Place into Vise jaws with the built-in magnets against the face of the jaws and the cast-in locating tabs over the top of the jaws (**FIG 1**).

FIG. 1



OPERATION

- Measure and mark the desired bend line on the workpiece panel.
- Slide metal panel between the Dies lining up your pre-marked bend line with the sharp, beveled edge of the Male Die (**FIG 2**).
- Gently and slowly draw the Vise jaws together to begin creating the desired bend.
NOTE: The use of an angle gauge or protractor (not included) is recommended.
- Depending on the alloy being bent, it may be necessary to push the dies slightly beyond the desired finished angle to allow for “springback”. Some trial and error is suggested using scrap material before making final bends.



REMOVING & REPLACING DIE FINGERS

The individual Die Fingers located in the Male Die may be removed and rearranged for greater precision in bending workpieces or may be replaced if nicks or damage should occur.

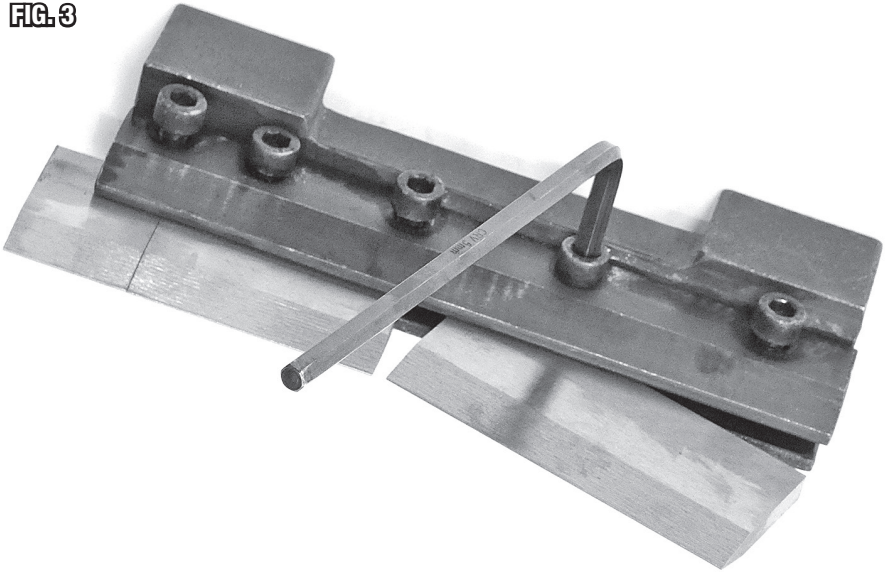
- **To Remove**

Using a 5mm Hex Key (not included), loosen the socket head cap screws and remove the desired Die Fingers (**FIG 3**).

- **To Replace**

Insert Die Fingers into the Male Die as required, use care to properly align the sharp bending edges then, once again, using a 5mm Hex Key, tighten all screws.

FIG. 3



MAINTENANCE

- Keep all areas of the Dies clean, particularly those surfaces that contact sheetmetal workpieces. Dirt and metal chips can cause uneven clamping and inaccurate bends.
- Store in a clean & dry environment when not in use. Coat all machined surfaces with a light film of oil, or suitable protectant, to prevent rust formation.

ADDITIONAL ITEMS

- #28038 Sheet Metal Gauge
- #13475 Electric Metal Cutting Shears
- #28187 Bead Roller Kit
- #51088 Shrinker/Stretcher Set

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: techhelp@eastwood.com

PDF version of this manual is available at eastwood.com

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