

*Eastwood*

**DO THE JOB RIGHT.**

Item #14042

# **VERSA-BEND 20" OFFSET SHEET METAL BRAKE**

## **INSTRUCTIONS**



The **EASTWOOD VERSA-BEND 20" OFFSET SHEET METAL BRAKE** is a precision engineered metal working tool designed to produce both standard variable length bends as well as accurate 1/2" offset bends up to 90° in mild, 20 gauge sheet steel and 18 gauge aluminum in widths up to 20". Also capable of creating bends in 18 gauge steel in widths less than 12". Create floor reinforcement channels and ribs, sections of corrugated pickup bed floors; truck bedside panels, inner fender structures and much more all with one convenient vise or bench mount tool.

## SAFETY INFORMATION



### READ INSTRUCTIONS!

Thoroughly read and understand manual before using the Brake tool.

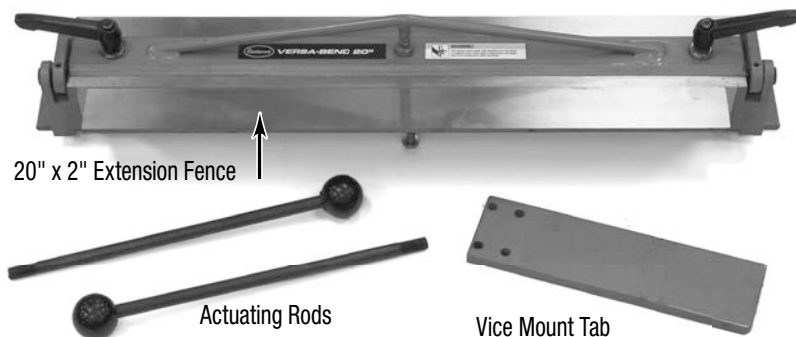


### WARNING!

- **WARNING! This tool has pinch points with amplified leverage which can quickly cause severe injury!** Keep fingers and hands away from moving parts when operating.
- Wear thick, well-fitting gloves to prevent cuts from handling sharp metal.
- Frequently inspect moving parts. If damage is observed, discontinue use immediately.
- Make sure the brake is securely fastened to a solid work surface before use.
- Always wear eye protection when working with sheet metal as it may have sharp edges.



### OFFSET METAL BRAKE ASSEMBLY



## INCLUDES

- (1) Offset Metal Brake Assembly
- (2) Actuating Rods
- (1) Vice Mount Tab and Hardware

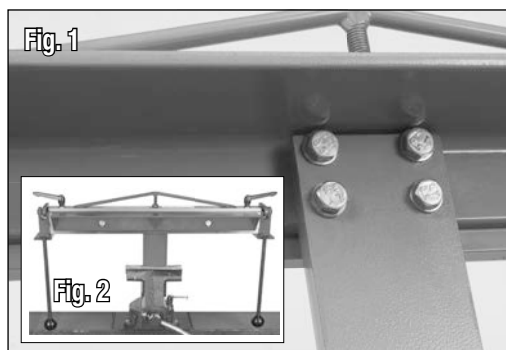
## ASSEMBLY

Assemble the two Actuating Rods to the pivoting Bending bar by inserting threaded ends into the threaded holes and tighten firmly.

## SET-UP

### VICE MOUNTING

- Attach the supplied Vice Mount Tab by bolting in place on the brake body and tighten the four bolts (included) securely (**Fig 1**).
- Using a 6" or larger vice, place the assembled unit with the vice mount tab pointing downward and between vice jaws. Be sure to firmly tighten vice jaws to prevent tool movement (**Fig 2**).



### BENCH MOUNTING

- Place the Eastwood Versa-Bend on a clean, stable, level surface at a comfortable working height. Mount securely to the work surface using 4 suitable 5/16" [8mm] lag screws or bolts (not included) through the four 21/64" [8.3mm] diameter holes in the base (**Fig 3**).

# OPERATION

## STANDARD BENDS UP TO 90°

With the 2" x 20" Extension Fence in place on the Bending Bar, conventional bends can be made in 20 gauge mild steel panels up to 20" wide and 18 gauge in widths of 12" or less. To do so;

- Measure and mark the desired bend line on your sheet metal panel.
- Loosen the Clamping Beam Hold-down T-Handles.
- Slide panel under the Clamping Beam lining up your pre-marked bend line with the lower, beveled edge of the Clamping Beam. Note: this edge is set back slightly from the main body of the brake to allow for a sufficient bend radius of the metal and the most accurate bends (**Fig 4**).
- Tighten the Clamping Beam Hold-down T-Handles to hold the panel in place.
- Grasping both handles of the moveable Bending Bar, lift upward, bending your panel until the desired bend angle is achieved.

**NOTE:** The use of an angle gauge or protractor (not included) is recommended (**Fig 5**).

- Depending on the particular alloy being bent, it may be necessary to rotate the Bending Bar slightly beyond the desired angle to allow for "springback". Some trial and error is suggested in scrap material before making final bends.

## OFFSET "JOGGED" BENDS UP TO 90°

With the 2" x 20" Extension Fence removed from the Bending Bar, 1/2" offset bends can be made in 20 gauge mild steel panels up to 20" wide and 18 gauge in widths of 12" or less.

**NOTE:** It is strongly recommended to make a mockup of your final piece in heavy construction paper or manila folder material prior to beginning as it is very easy to make a mistake and create a bend in the wrong direction.

- Loosen and remove the 2 bolts securing the 2" x 20" Extension Fence to the Bending Bar.

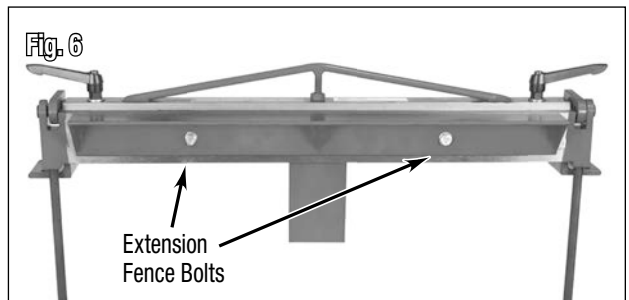
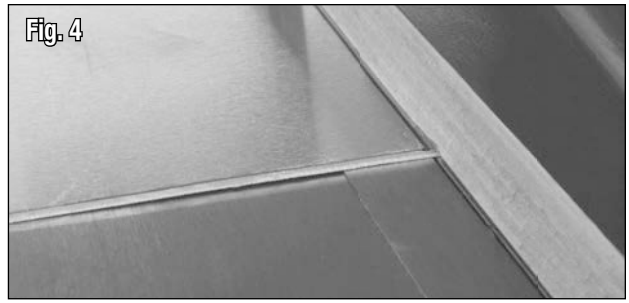
**CAUTION!** This Extension Fence is heavy and may cause personal injury if dropped. Use care to support it during removal (**Fig 6**).

- Measure and mark the desired bend lines on your sheet metal panel.
- Loosen the Clamping Beam Hold-down T-Handles.
- Slide panel under the Clamping Beam lining up your pre-marked bend line with the lower, beveled edge of the Clamping Beam.
- Tighten the Clamping Beam Hold-down T-Handles to hold the panel in place.
- Grasping both handles of the moveable Bending Bar, lift upward, bending your panel until the desired bend angle is achieved.

**NOTE:** this edge is set back slightly from the main body of the brake to allow for a sufficient bend radius of the metal and the most accurate bends (**Fig 4**).

- Depending on the particular alloy being bent, it may be necessary to rotate the Bending Bar slightly beyond the desired angle to allow for "springback". Some trial and error is suggested in scrap material before making final bends.
- For successive bends, loosen the Clamping Beam, flip the panel over, place in under the Clamping Beam then repeat steps outlined above.

(**Fig 7a, 7b, 7c**).



## TOOL MAINTENANCE

- Provide several drops of oil to pivot points periodically to prevent binding.
- Keep all areas of the tool clean particularly those surfaces that contact Sheet metal work pieces. 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 lubricant film of oil or suitable protectant to prevent rust formation.

## ACCESSORIES

- #28038 Sheet Metal Gauge
- #13475 Electric Metal Cutting Shears
- #28187 Bead Roller Kit
- #51088 Shrinker/Stretcher Set
- #20257 5pc Sheet Metal Layout Kit
- #20258 Protractor
- #20259 Ruler

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

The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: [techelp@eastwood.com](mailto:techelp@eastwood.com)  
PDF version of this manual is available online >> [eastwood.com/14042manual](http://eastwood.com/14042manual)

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