

Eastwood®

DO THE JOB RIGHT.®

Item #21560

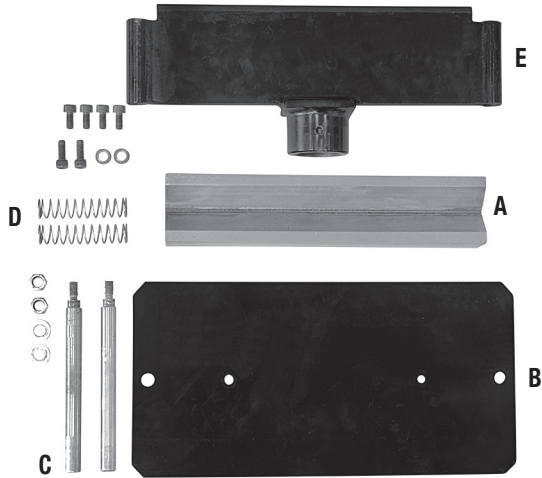
PRESS BRAKE ATTACHMENT INSTRUCTIONS



The **EASTWOOD PRESS BRAKE ATTACHMENT** is a precision engineered metal working tool designed to produce accurate, variable length bends in angles up to 90°, in mild steel and aluminum, in widths up to 12" [305mm] and thicknesses up to 3/8" [10mm]. Create complex shapes, such as floor reinforcement channels and ribs, sections of corrugated pickup bed floors, truck bedside panels, inner fender structures, suspension brackets, engine/transmission mounts and much more.

CONTENTS

- (1) Lower Die – [A]
- (1) Base Plate – [B]
- (2) Slide Posts – [C]
- (2) Release Springs – [D]
- (1) Upper Die – [E]
- (2) M10 Nuts
- (2) M10 Washers
- (2) M8 x 20mm Bolts
- (2) M8 Washers
- (4) M8 Set Screws



SPECIFICATIONS

Attach to Most Standard 12 or 20 Ton Hydraulic Shop Presses.

Max. Bending Width: 12"

Bending Thickness (varies according to metal hardness & width of workpiece).

Mild steel and aluminum:

- 3/16" (5mm) x 12" [304mm] Width
- 5/16" (8mm) x 6" [152mm] Width
- 3/8" (10mm) x 3" [76mm] Width

Stainless:

- 1/8" (3mm) x 12" [304mm] Width
- 3/16" (4.8mm) x 6" [152mm] Width
- 1/4" (6.4mm) x 3" [76mm] Width

▲ NOTICE

**Material temper and hardness vary.
Always make a test bend with a scrap
piece before performing the final bend.**

TOOLS REQUIRED

- (1) 16mm wrench
- (1) 6mm hex key

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.



⚠ READ INSTRUCTIONS

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



⚠ WARNING PINCH AND CRUSH HAZARD!

- The Eastwood Press Brake Attachment consists of moving components that quickly generate extreme crushing force 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 12 to 20 ton hydraulic press which is securely bolted to a sturdy workbench or anchored to the floor or wall.
- Strenuous physical force may need to be applied to the Press Brake Attachment 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 Press Brake Attachment 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 Press Brake components and host hydraulic press for looseness or damage.

ASSEMBLY

- Locate the Lower Die [A] to the Base Plate [B] with two M8 x 20 mm screws and washers (FIG 1). Tighten with a 6mm hex key.
- Insert threaded ends of Slide Posts [C] into holes in Base Plate [A] and secure with two M10 Nuts and Washers (FIG 1). Tighten with a 16mm wrench.
- Place two Release Springs [D] over Slide Posts [C] (FIG 2).
- Slide sleeves of the Upper Die [E] over the Slide Posts [C] (FIG 3).
- Thread four (4) M8 Set Screws into the cup feature of the Upper Die [E].

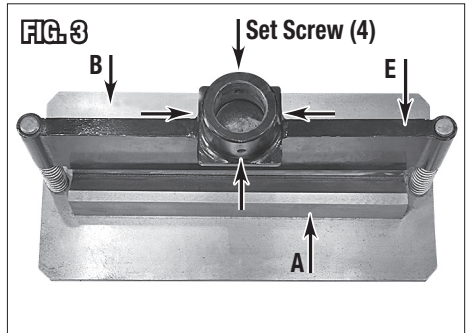
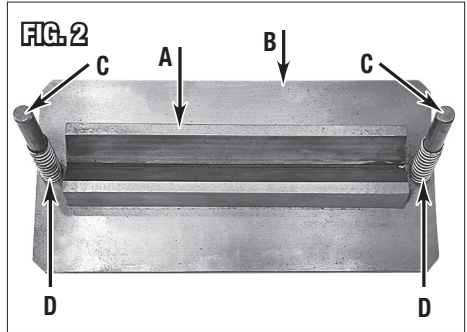
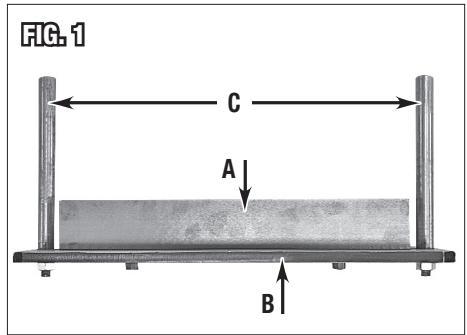
SET-UP

The Eastwood 12" Press Brake Attachment is designed as an accessory for use in a 12 to 20 ton hydraulic press.

⚠ NOTICE

Use only in a Shop Press of 20 Tons or less.

- Center Press Brake over the crossbar of hydraulic press (not included).
- Slowly draw down the ram of the hydraulic press so that it nests within the cup on the top of the Upper Die [E]. Secure to ram by tightening the four Set Screws with a 6mm hex key.



OPERATION

- Follow specific operating instructions supplied with the particular hydraulic press to be used.
- 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.
- Center metal panel in Press Brake.
- Gently and slowly draw down the hydraulic ram of the hydraulic press to begin creating the desired bend. **NOTE:** The use of an angle gauge or protractor (not included) is recommended.
- Depending on the particular 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 with scrap material before making final bends.

MAINTENANCE

- Keep all areas of the tool 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 lubricant film of oil or suitable protectant to prevent rust formation.

ADDITIONAL ITEMS

- #28038 Sheet Metal Gauge
- #13475 Electric Metal Cutting Shears
- #32044 Bead Roller Kit
- #51088 Shrinker/Stretcher Set
- #31664 Mini Metal Saw

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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