

Figure 4. Clamp installation.

4. Screw the two breaker bar levers into the breaker bar holes, as shown in **Figure 5**.

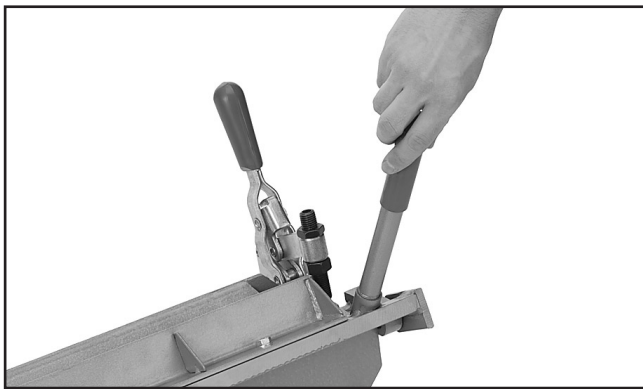


Figure 5. Breaker bar lever installation.

## ⚠ CAUTION

The bending brake **MUST** be clamped or secured to a workbench before being used. Failure to do so can lead to personal injury or machine damage!

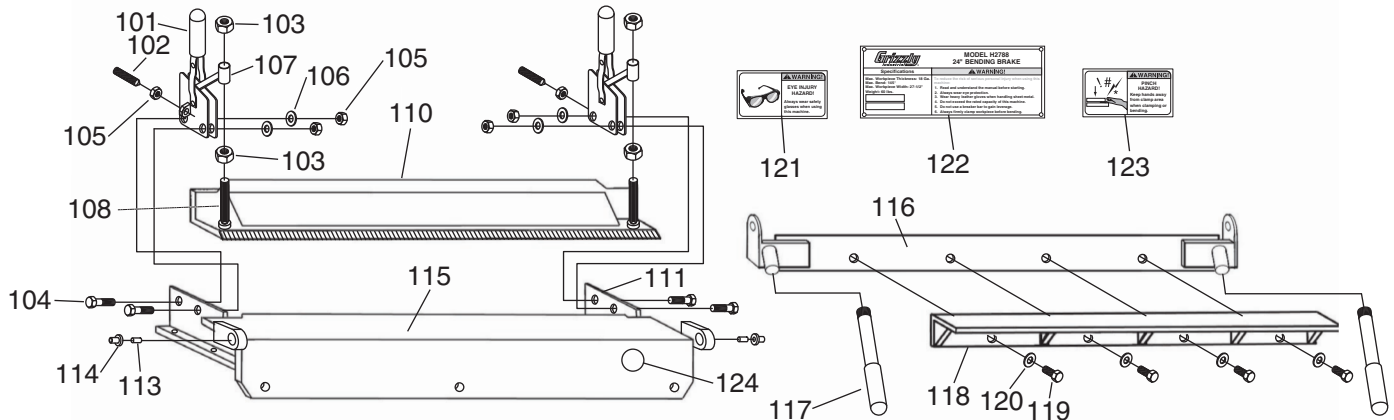
### Basic Bending Operations

1. Open the bending brake and place the workpiece beneath the clamping angle.
2. Close the clamp assemblies until they lock. If the workpiece is too thick or too thin for the clamps, adjust the clamps according to **Clamp Adjustment** on this page.
3. When the workpiece is secured in the bending brake, lift the breaker bar levers to form the desired angle.

### Clamp Adjustment

1. Without turning the clamping set screw, turn the adjusting nuts clockwise to adjust for thicker workpieces and counterclockwise to adjust for thinner workpieces. Adjust each clamp an equal amount.

## H2788 Breakdown and Parts List



REF	PART #	DESCRIPTION
101	PH2788101	CLAMP
102	PSS39M	SET SCREW M10-1.5 X 50
103	PN05M	HEX NUT M16-1.5
104	PB01M	HEX BOLT M10-1.5 X 30
105	PN02M	HEX NUT M10-1.5
106	PLW06M	LOCK WASHER 10MM
107	PH2788107	COLLAR
108	PH2788108	SPECIAL SET SCREW M10-1.5 X 90
110	PH2788110	CLAMPING ANGLE
111	PH2788111	CLAMP MOUNTING PLATE
113	PH2788113	PIVOT PIN 16 X 50

REF	PART #	DESCRIPTION
114	PH2788114	FLANGE BEARING
115	PH2788115	BASE
116	PH2788116	BREAKER BAR
117	PH2788117	THREADED LEVER M20-1.75
118	PH2788118	BREAKER ANGLE
119	PB03M	HEX BOLT M8-1.25 X 16
120	PW01M	FLAT WASHER 8MM
121	PH2788121	PINCH HAZARD WARNING
122	PH2788122	MACHINE ID LABEL
123	PLABEL-11D	SAFETY GLASSES LABEL
124	PPAINT-1	GREEN TOUCH-UP PAINT