

Instructions and Parts List for No. 99 Letter Forming Brake

CARE: An occasional oiling with light machine oil of moving parts is sufficient care of this machine.

OPERATION: Always make sure the Apron is level and even with the Lower Beam. If the Apron is not even, adjust up or down by loosening Apron Hinge Adjusting Screw Nuts and adjust Apron by turning the Apron Hinge Adjusting Screw. Be sure to retighten Lock Nuts when adjustment is complete. To adjust the Upper Beam, loosen Upper Beam Pivot Bracket Screws and move Upper Beam to desired position by the Upper Beam Adjusting Screws. Retighten the Pivot Bracket Screws. For a sharp bend in most metals the Upper Beam Jaw should line up with the front edge of the Lower Beam Jaw. If bending 26 or 28 gauge material the Upper Beam Jaw may have to be moved forward of the Lower Beam Jaw about 1/64". If a slight radius is desired in heavier metals the Upper Beam Jaw should be moved to the rear. Do not move the Upper Beam Jaw forward more than 1/64" or backward more than 3/32" from the edge of the Lower Beam Jaw.

Item No.	Part No.	Part Name	No. Req'd.
1	99-1	Upper Beam	1
2	99-1-3	Upper Beam Jaw	1
3	WS 539	3/8-16 x 1-1/4 Socket Head Cap Screw	4
4	WS 49	7/16-14 x 1-1/4 Hex Head Cap Screw	2
5	WS1704	3/8 Flat Washer	14
6	99-10	Clamping Arm Spacer	4
7	WS1729	3/8 Lock Washer	9
8	WS1333	3/8-16 Hex Jam Nut	11
9	NS 420-40	Upper Beam Arm Bracket	2
10	WS 535	3/8-16 x 5/8 Socket Head Cap Screw	4
11	WS 1748	3/8 Internal Shakeproof Washer	4
12	99-11	Upper Beam Pivot Pin	2
13	WS 896B	5/16-18 x 3/8 Socket Set Dog Point Screw	2
14	WS 829	5/16-18 x 3/8 Socket Set Screw	2
15	WS 632	3/8-16 x 1-1/2 Square Head Set Screw	2
16	WS 631	3/8-16 x 1-1/2 Square Head Set Screw	2
17	99-2	Lower Beam	1
18	WS 318	3/8-16 x 1-1/4 Flat Head Cap Screw	3
19	99-6	Lower Beam Jaw	1
20	WS 34	3/8-16 x 1-1/4 Hex Head Cap Screw	4
21	99-3	Apron	1
22	99-8	Apron Handles	2
23	99-14	Apron Hinges	2
24	WS 64	1/2-13 x 1-1/4 Hex Head Cap Screw	4
25	WS 1706	1/2 Flat Washer	4
26	99-15	Apron Shims	as req.
27	99-13	Apron Hinge Pins	2
28	WS 813	1/4-20 x 1/4 Socket Set Screw	2
29	WS 618	5/16-18 x 1-1/4 Square Head Set Screw	2
30	WS 1332	5/16-18 Hex Jam Nut	2
31	99-4	Stand	1
32	99-9	Clamping Arms	2
33	99-5	Foot Treadle	1
34	129-68	Foot Treadle Bushings	2
35	247-62	Foot Treadle Spring	1
36	99-12	Foot Treadle Spring Rod	1

