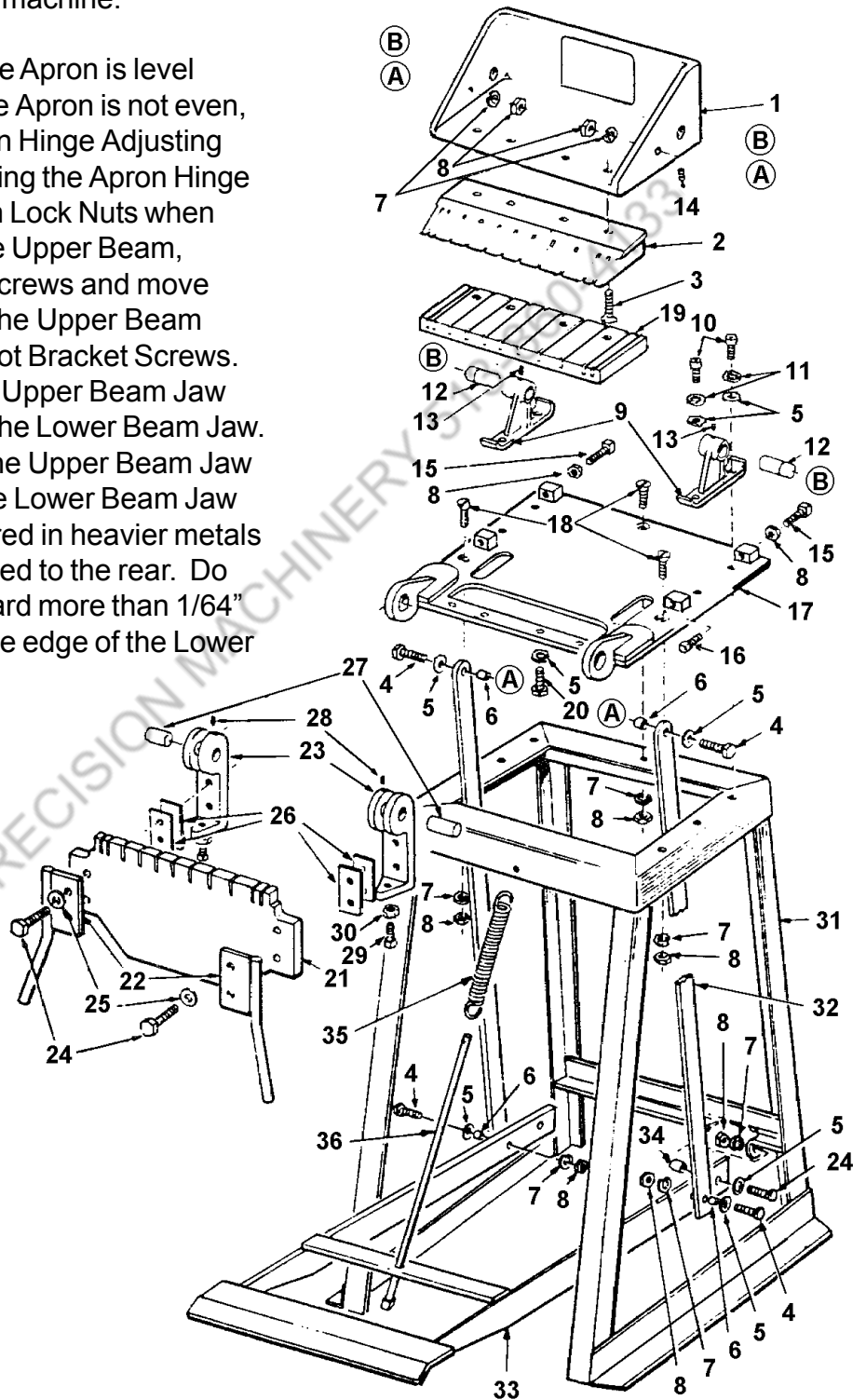


NO. 99 LETTER FORMING BRAKE

INSTRUCTIONS AND PARTS LIST

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.



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NO.99 PARTS LIST

ITEM NO.	PART NO.	PART NAME	QTY.
1	731020190	Upper Beam	1
2	731020189	Upper Beam Jaw	1
3	611012177	Socket Head Cap Screw 3/8-16 x 1 1/4	4
4	601012225	Hex Head Cap Screw 7/16-14 x 1 1/4	2
5	678033105	Flat Washer 3/8	8
6	774630153	Clamping Arm Spacer	4
7	679033105	Lock Washer 3/8	9
8	649023005	Hex Jam Nut 3/8-16	11
9	731200203	Upper Beam Arm Bracket	2
10	611012172	Socket Head Cap Screw 3/8-16 x 5/8	4
11	681033105	Internal Shakeproof Washer 3/8	4
12	731160199	Upper Beam Pivot Pin	2
13	625012126	Socket Set Dog Point Screw 5/16-18 x 3/8	2
14	621012126	Socket Set Screw 5/16-18 x 3/8	2
15	633012179	Square Head Set Screw 3/8-16 x 1 1/2	2
16	633012177	Square Head Set Screw 3/8-16 x 1 1/4	2
17	731020191	Lower Beam	1
18	605012177	Flat Head Cap Screw 3/8-16 x 1 1/4	3
19	731020195	Lower Beam Jaw	1
20	601012177	Hex Head Cap Screw 3/8-16 x 1 1/4	4
21	731010192	Apron	1
22	731460196	Apron Handles	2
23	731500202	Apron Hinges	2
24	601012273	Hex Head Cap Screw 1/2-13 x 1 1/4	4
25	678033107	Flat Washer 1/2	4
26	731720204	Apron Shims	As Req.
27	600000464	Apron Hinge Pins	2
28	621012082	Socket Set Screw 1/4-20 x 1/4	2
29	633012135	Square Head Set Screw 5/16-18 x 1 1/4	2
30	649023004	Hex Jam Nut 5/16-18	2
31	731060193	Stand	1
32	731030197	Clamping Arms	2
33	731810194	Foot Treadle	1
34	774630136	Foot Treadle Bushing	2
35	600184521	Foot Treadle Spring	1
36	731030200	Foot Treadle Spring Rod	1