



DI-ACRO BRAKES

MODEL 12

OPERATIONS MANUAL

Operating characteristics of both the Model 12 and 24 Di-Acro leaf type Brakes are identical, the only difference being the additional forming width of Model No. 24. Before Brake is set up for operation mount on work bench or stand *with Brake base flush with the edge, and bolt in place.

Position handle arms to one of the three locations provided on the handle holders for most convenient operation.

Insert back gauge rods in holes in rear of casting and secure in position with screws in front of casting behind the folding blade (see Micrometer Back Gauge instructions on inside page).

* If Brake is mounted on its own stand secure stand to floor.

Di-Acro®

METAL FABRICATION EQUIPMENT

579 SCHOMMER DR - STE C

HUDSON, WI 54016

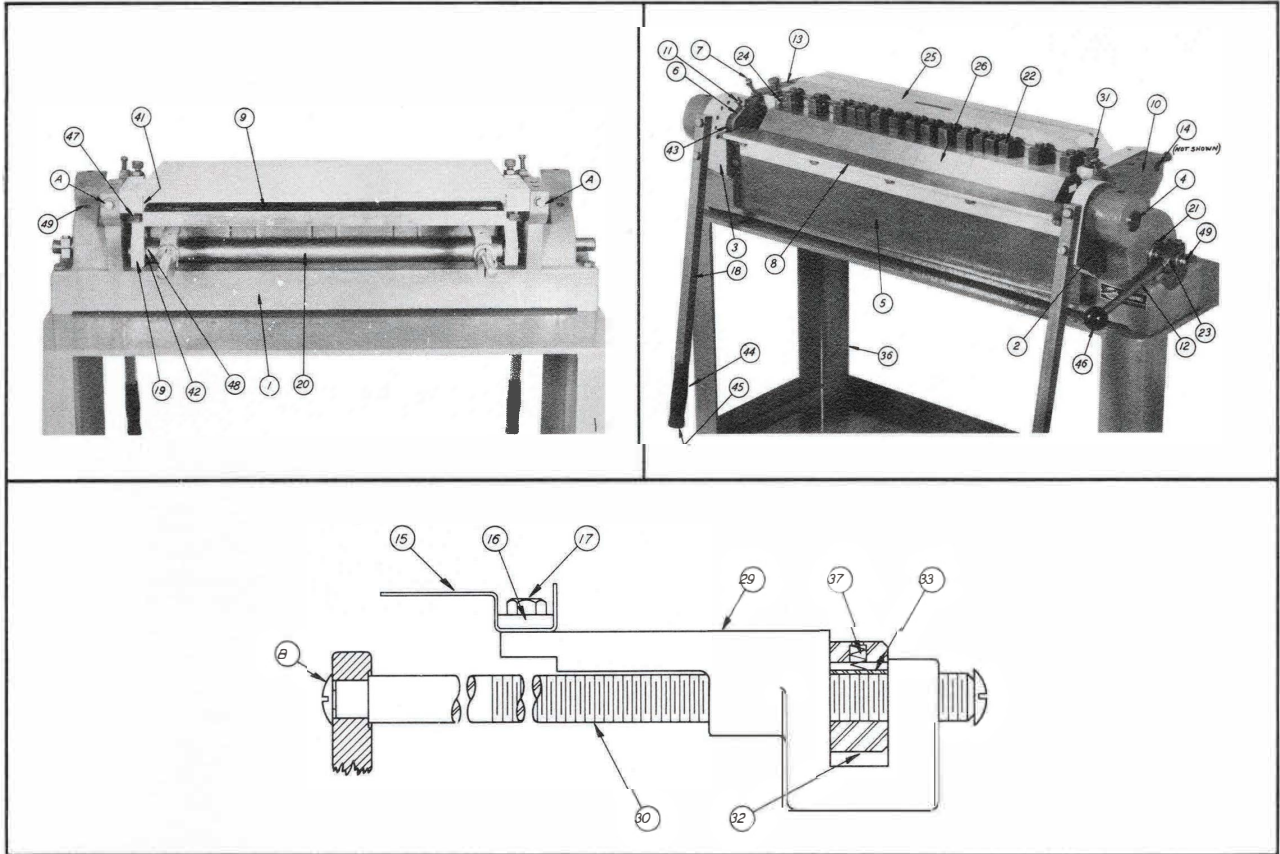
(651) 342-1756 (P)

OBSOLETE MACHINE **MANUAL DISCLAIMER**

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Reverse Bends

Remove five angle support bar bolts and support bar (8) and adjust Brake as above.

NOTE: Di-Acro Brakes are rated for 1" minimum flange when bending full capacity. Caution should be used if necessary to bend heavier gauge material in short widths.

Accessories

	Model No. 12 Part No.	Model No. 24 Part No.
Open End Finger	326-1222041	346-1222041
Block Mounting Bar	326-1222021	346-1222021
Extension Box Finger R	346-1222043	346-1222043
Extension Box Finger L 1/8"	346-1222044	346-1222044
Radius Extension Fingers R 1/8"	346-1222063	346-1222063
Radius Extension Fingers L 1/16"	346-1222064	346-1222064
Radius Extension Fingers R 1/16"	346-1222053	346-1222053
Radius Extension Fingers L	346-1222054	346-1222054

When Ordering Parts Be Sure To Specify Part No., Brake Model and Serial No.

No.	Nomenclature	Model No. 12 Part No.
1	Base	326-1101001
2	Arm R.	326-1220002
3	Arm L.	326-1220003
4	Trunnion	326-1204004
5	Folding Bar	326-1220005
6	Folding Bar Stop	326-1220006
7	Arm Adj. Bolt	251-4701015
8	Folding Bar Support	326-1220008
9	Bottom Plate	326-1104009
10	Side Assembly R.	326-1103010
11	Pin	1203149
12	Handle Rod	
13	Side Assembly L.	326-1103011
14	Spring	060-5102057
15	Gauge	326-1441061
16	Block	326-1441014
17	Cap Screw	326-1441016
18	Handle Arm	326-1208018
19	Connecting Arm	326-1201019
20	Shaft	326-1211020
21	Bearing Housing	326-1103024
22	Finger Clamp	347-1102030
23	Clamp Handle Block	326-1208029
24	Clamp Pin	156-1203010
	Pitman Pin	326-1203015
25	Finger Mounting Assembly	326-1102031
	Acute Forming Bar	326-1222017
	Standard Forming Bar	326-1222012
26	3/4" Finger	347-1222035
	1" Finger	347-1222037
	1-1/4" Finger	347-1222042
	3" Finger	347-1222039
	6" Finger	
29	Quik-Set Bracket	346-1441038
30	Quik-Set Rod	346-1441039
31	Adjusting Screw	326-4701042
32	Quik-Set Dial Nut	210-1441042
33	Quik-Set Dial Shoe	210-1431043
36	Brake Stand	326-1109000
37	Spring	210-5102048
41	Pin	1203112
42	Needle Bearings	3103007
43	Needle Bearings	3103005
44	Handle	410-1208033
45	Pushnut	4704001
46	Plastic Knob	1208106
47	Spring	5102115
48	Retaining Ring	4705103
49	Grease Fitting	6901002
	Wrench	6101002

Angle Adjustment

To adjust Brake for bending clearance, raise folding blade (5) 90 degrees, insert material between edges of folding blade and leading edge of fingers (26) (for heavy material, clearance should be twice the thickness, less for lighter gauge or if a sharper bend is desired).

Adjust finger mount bar by turning finger mount bar adjustment screws (A). To adjust clamping pressure insert material under fingers and turn material adjustment screws (31) until material is held securely when fingers are lowered.

To adjust degree of bend, set angle stops (6, 7) located on both ends of folding blade for desired degree of bend.

Micrometer Back Gauge

Micrometer back gauge should be zeroed when first installed. To install and zero gauge:

- A. install gauge rods in holes located in rear of base casting.
- B. hold micrometer dial on zero and screw rods in until material stop (15) lines up with folding blade. Rods can be locked in place by tightening screws (B) located behind folding blade.

To position micrometer back gauge rapidly, turn micrometer dials to zero, depress dial and slide complete back gauge assembly to desired position. For fine adjustment turn micrometer dials in regular manner.