

DI-ACRO #24 FINGER BRAKE INSTRUCTION MANUAL



DiAcro[®]
METAL FABRICATION EQUIPMENT

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SAFETY INSTRUCTIONS



Before brake is set up for operation, mount on work bench or stand with brake base flush with the front edge of stand or work bench and bolt in place.

***IF BRAKE IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR**

MAINTENANCE

Lubricate shaft as needed.

SPECIFICATIONS

	Model No. 24	
	in.	mm
Max. Capacity, Mild Steel	16 ga.	1.5
Max. Forming Width	24	609.6
Clearance thru Top Opening	1	25.4
Max. Depth of Box or Pan	3	76.2
Min. Reverse Bend	1/4	6.4
Max. Angle Bend (one operation)	135°	
Max. Back Gauge Adjustment	24	609.6
Shipping Weight	325#	123 kg.
Stand, Shipping Weight	100#	45 kg .

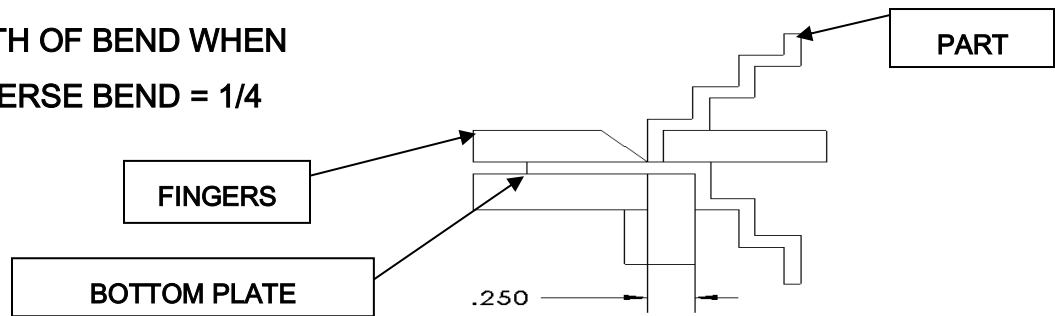
ANGLE ADJUSTMENT

To adjust Brake for bending clearance, raise folding blade 90 degrees, insert material between edges of folding blade and leading edge of fingers (for heavy material, clearance should be twice the thickness, less for lighter gauge or if sharper bend is desired). Adjust finger mount weldment by turning arm adjustment bolts (item 45). To adjust clamping pressure, insert material under fingers and turn arm adjustment bolts until material is held securely when fingers are lowered. To adjust degree of bend, pins (item 47) located on both ends of folding blade for desired degree of bend.

REVERSE BENDS

Remove the five Hex head cap screws 3/8-16 x 1 (item 18) the support bar (item 38) and adjust Brake as shown. **NOTE: Based on 16 GAUGE CAPACITY** (with support bar in place)

MINIMUM LENGTH OF BEND WHEN
FORMING A REVERSE BEND = 1/4



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.

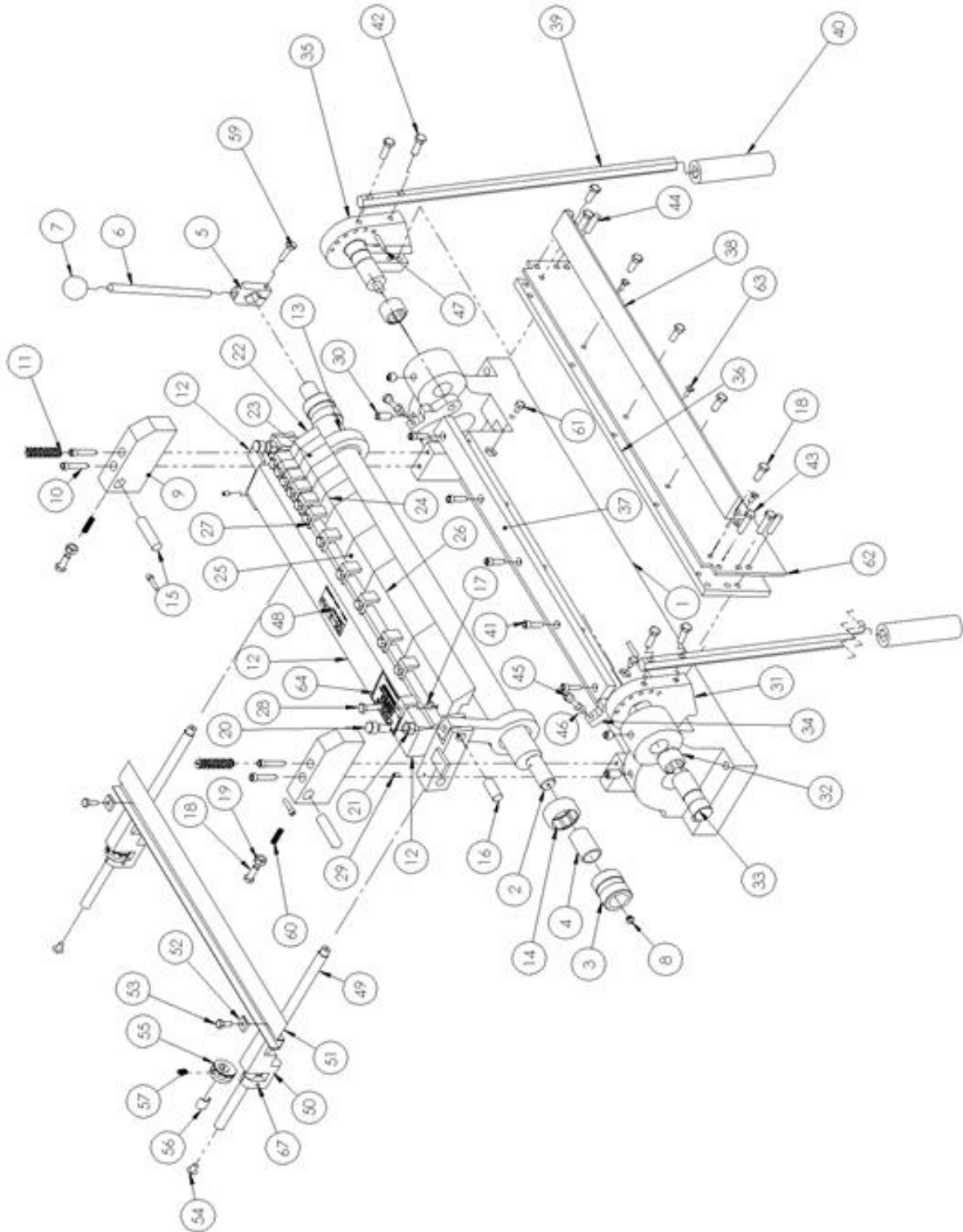
MICROMETER BACK GAUGE ASSEMBLY – 8346144-171

Typically the backgauge is assembled when the finger brake is shipped from the factory. Occasionally it is removed for ease of palletizing. To install and/or zero the gauge follow the instructions below. (Refer to parts breakdown on pages 5, 6, & 7) Install Quik-Set rod (item 49) in holes located in rear of the base casting.

Hold Quik-Set dial nut assemblies (items 55, 56, 57) on zero and screw rods in until gage (item 51) lines up with folding blade. Quik-Set rods can be locked in place by tightening screws located behind folding blade.

To position micrometer backgauge rapidly, turn Quik-Set dial nut assemblies to zero. Depress dial and slide complete back gauge assembly to desired position. For fine adjustment turn Quik-Set dial nut assemblies in regular manner.

24 FINGER BRAKE PARTS BREAKDOWN 8347820-080



PARTS LIST
8347820-080

ITEM	PART NUMBER	DESCRIPTION	QTY
1	8346110-100	BASE-24" FINGER BRAKE	1
2	8346120-200	SHAFT	1
3	8346110-302	BUSHING HOUSING SUB-ASSY	2
	346-1103024	BUSHING HOUSING	2
	8346110-302-1	BRONZE BUSHING (PRESS-FIT)	2
5	346-1208030	CLAMP HANDLE BLOCK	1
6	8500111-300	HANDLE ROD	1
7	8120810-700	PLASTIC KNOB	1
8	8690100-200	DRIVE FITTING-3/16	2
9	8346110-311	SIDE	2
10	20A0516C1104	SCREW-SHCS 5/16-18X1-1/4	4
11	8510211-600	SPRING	2
12	8046110-204	FINGER MOUNT WELDMENT	1
13	8347120-101	CONNECTING ARM	2
14	8310300-900	NEEDLE BEARING	2
15	19A0508X2304	PIN-DOWEL 5/8X2-3/4	2
16	19A0508X1102	PIN-DOWEL 5/8X1-1/2	2
17	22D0X08C0104	SCREW-THMS #8-32 X 1/4	2
18	21A0308C1000	SCREW-HHCS 3/8-16X1	7
19	31X0308C	NUT-JAM 3/8-16	2
20	8346470-101	ADJUSTING SCREW	2
21	31X0102C	NUT-JAM 1/2-13	2
22	8000122-203	FINGER STD 3/4	2
23	8100122-203	FINGER STD 1	2
24	8000122-204	FINGER STD 1-1/4	2
25	8200122-203	FINGER STD 3	2
26	8347122-204	FINGER STD 6	2
27	8347110-203	FINGER CLAMP	12
28	21A0516C1102	SCREW-HHCS 5/16-18X1-1/2	12
29	23A0104C0308	SCREW-SSS 1/4-20X3/8	2
30	23A0102C0102	SCREW-SSS 1/2-13X1/2	4
31	8400122-000	LEFT ARM	1
32	8310300-600	NEEDLE BEARING	2
33	8346120-300	TRUNNION	2

PARTS LIST - CONTINUED

ITEM	PART NUMBER	DESCRIPTION	QTY
34	8500122-000	FOLDING BAR STOP	2
35	8346122-000	RIGHT ARM	1
36	8046122-002	FOLDING BAR BACK	1
37	8346110-400	BOTTOM PLATE	1
38	8146122-000	FOLDING BAR SUPPORT	1
39	8346120-801	HANDLE ARM	2
40	8120310-100	HANDLE GRIP	2
41	20A0516C1000	SCREW-SHCS 5/16-18X1	5
42	21A0308C1104	SCREW-HHCS 3/8-16X1-1/4	4
43	21A0308C1102	SCREW-HHCS 3/8-16X1-1/2	4
44	19A0308X1102	PIN-DOWEL 3/8X1-1/2	2
45	8251470-101	ARM ADJUSTMENT BOLT	2
46	31X0516C	NUT-JAM 5/16-18	2
47	19A0104X1000	PIN-DOWEL 1/4X1	2
48	8150650-110	SERIAL TAG	1
49	8046144-103	QUIK SET ROD	2
50	8346144-103	QUIK SET BRACKET	2
51	8346144-105	GAGE	1
52	8346144-106	BLOCK	2
53	21A0104C0102	SCREW-HHCS 1/4 -20X1/2	2
54	22D0516C0102	SCREW THMS 5/16-18X1/2	2
55	8210143-104	QUIK SET DIAL NUT	2
56	8000143-104	QUIK SET DIAL SHOE	2
57	8210510-204	SPRING	2
59	21A0516C1104	SCREW-HHCS 5/16-18X1-1/4	1
60	8060510-205	SPRING	2
61	21A0104C0102	SCREW-HHCS 1/4 -20X1/2	2
61A	0104WILLIAMSWASHER	WASHER-1/4	2
62	8046122-001	FOLDING BAR FRONT	1
63	20C0104C0508	SCREW-FHSCS 1/4 -20X5/8	3
64	8030650-300	CAUTION SIGN	1
66	0330-6503001	PINCH POINT (NOT SHOWN) GOES ON TOP OF FINGER MOUNT WLDMT	1
67	22B0104C0708	SCREW-FLHMS 1/4-20X7/8	2

OPTIONAL STAND PART NUMBER 8346110-900

STAND DIMENSIONS ARE: 38" WIDE, 15" DEEP, 33-1/4" HIGH

CALL DI-ACRO FOR PRICE AND AVAILABILITY



Fasteners needed to attach Finger Brake to stand are the following:

(Fasteners to attach stand to floor are not included.)

PART NUMBER	DESCRIPTION	QTY
21A0102C3102	SCREW-HHCS 1/2-13X3-1/2	4
61X0102	WASHER-FLAT 1/2	4
30X0102C	NUT-FULL 1/2-13	4

Warranty & Limitation of Liability

Defective parts, of a product manufactured by DI-ACRO, will be replaced or repaired at no charge for twelve (12) months following delivery to the original purchaser. Labor is included for the first 90 days. This warranty becomes void when products have not been used according to instructions furnished by DI-ACRO, nor does it cover any altered parts or unauthorized repairs. We cannot be responsible for the cost of repairs made or attempted outside of our factory. All other warranty claims are made FOB our plant, providing such items(s) is returned freight prepaid to our plant for examination.

This warranty does not apply to parts, components or systems not manufactured by DI-ACRO. These products are covered instead by the existing warranties, if any, of their manufacturers. Normal service items with a reasonable life expectancy of less than one year are warranted only to the extent of the reasonable life under normal use and service.

Authorization must be obtained from DI-ACRO before returning parts or equipment to the factory. DI-ACRO will satisfy this warranty by replacing the product or refunding the purchase price upon receipt, inspection and defect identification.

DI-ACRO's liability under this warranty shall not exceed the amount paid for the product.

THIS IS DI-ACRO'S SOLE WARRANTY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, WHICH ARE HEREBY EXCLUDED, INCLUDING IN PARTICULAR ALL WARRANTIES OF MERCHANTABILITY, FITNESS OR ANY LOSS, DAMAGE OR EXPENSES DIRECTLY OR INDIRECTLY RELATED TO THE USE OF ITS PRODUCT OR FROM ANY OTHER CAUSE OR FOR CONSEQUENTIAL DAMAGES INCLUDING, WITHOUT LIMITATION, LOSS OF TIME AND LOSS OF PRODUCTION.

IT IS EXPRESSLY UNDERSTOOD THAT DI-ACRO IS NOT RESPONSIBLE FOR DAMAGE OR INJURY CAUSED TO OTHER PRODUCTS, MACHINERY, PROPERTY OR PERSONS BY REASON OF THE USE OF ITS PRODUCTS.



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