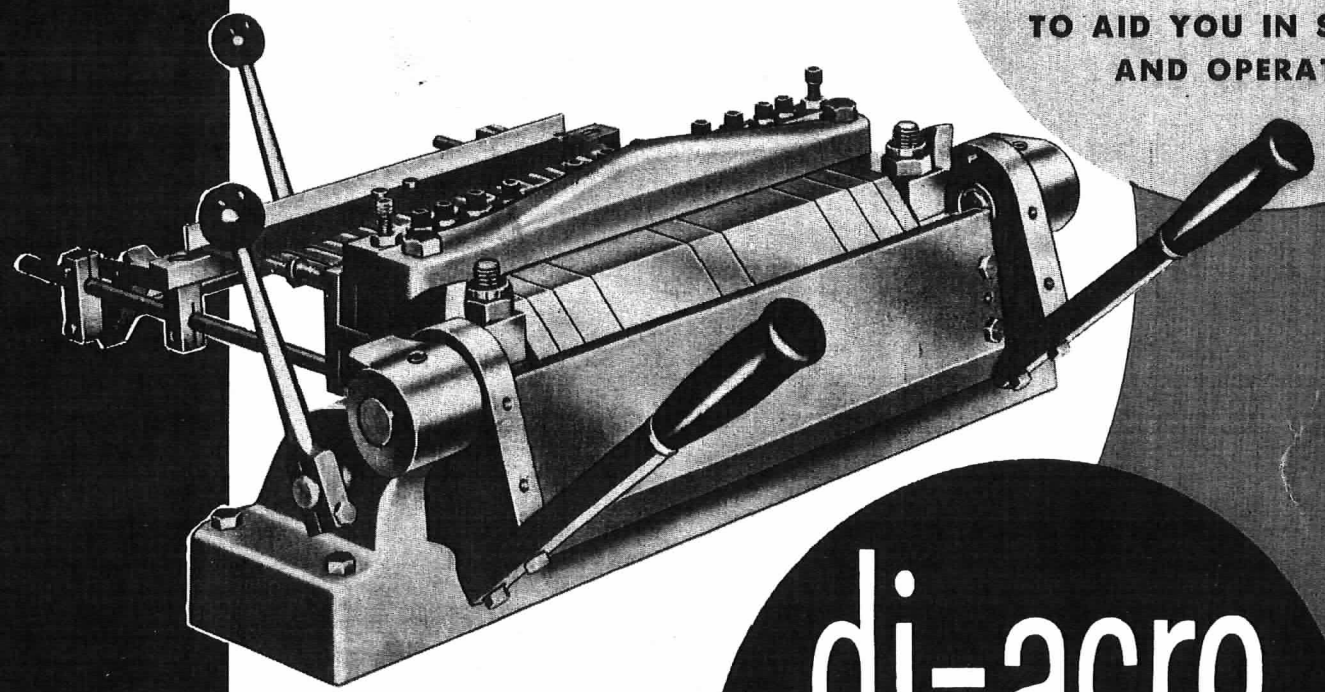
INDEX

di-acro PRECISION METALWORKING MACHINES

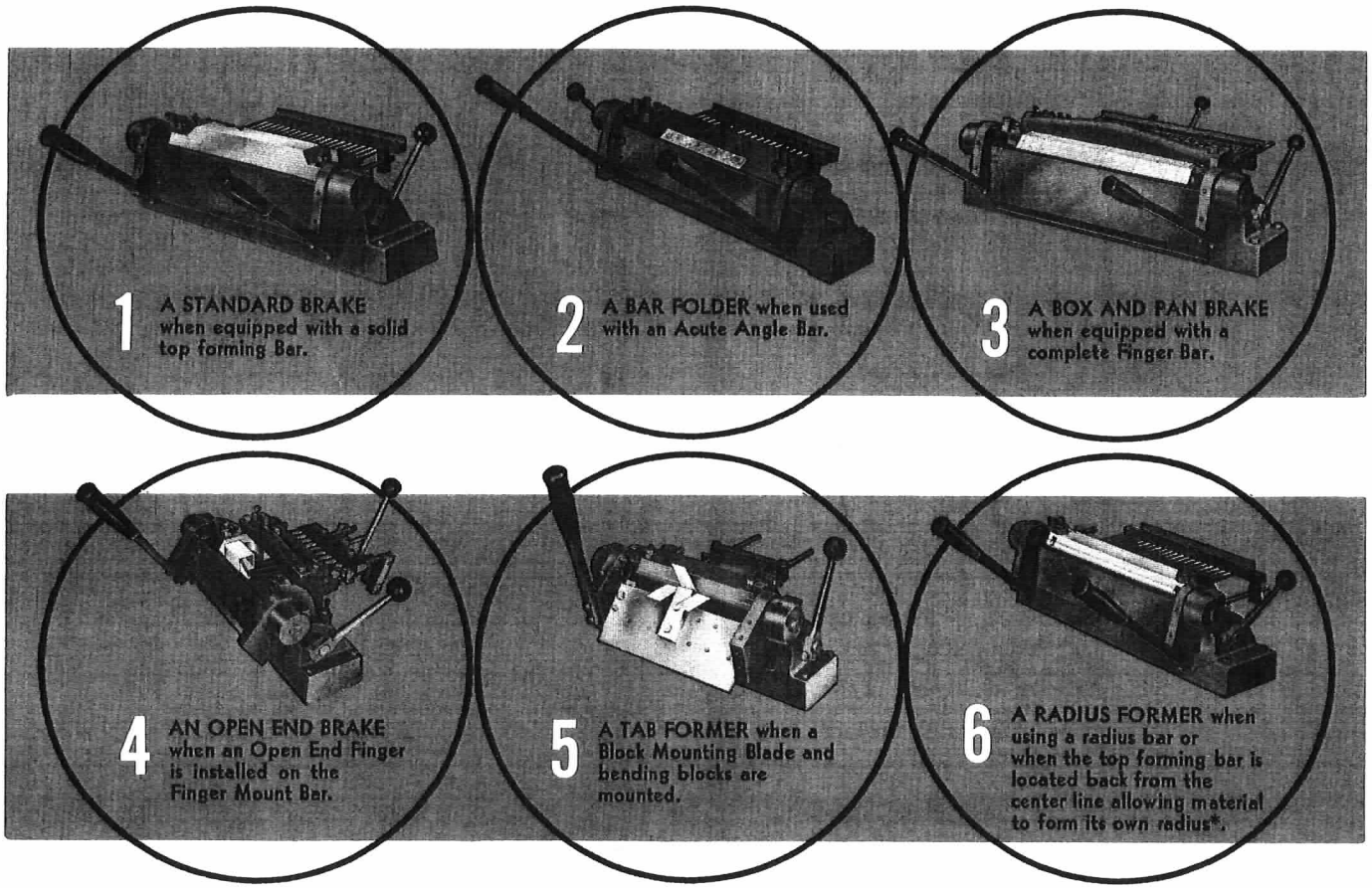


handy quide

TO AID YOU IN SELECTING AND OPERATING

di-acro brakes

DI-ACRO BRAKE IS . . .



1 A STANDARD BRAKE when equipped with a solid top forming Bar.

2 A BAR FOLDER when used with an Acute Angle Bar.

3 A BOX AND PAN BRAKE when equipped with a complete Finger Bar.

4 AN OPEN END BRAKE when an Open End Finger is installed on the Finger Mount Bar.

5 A TAB FORMER when a Block Mounting Blade and bending blocks are mounted.

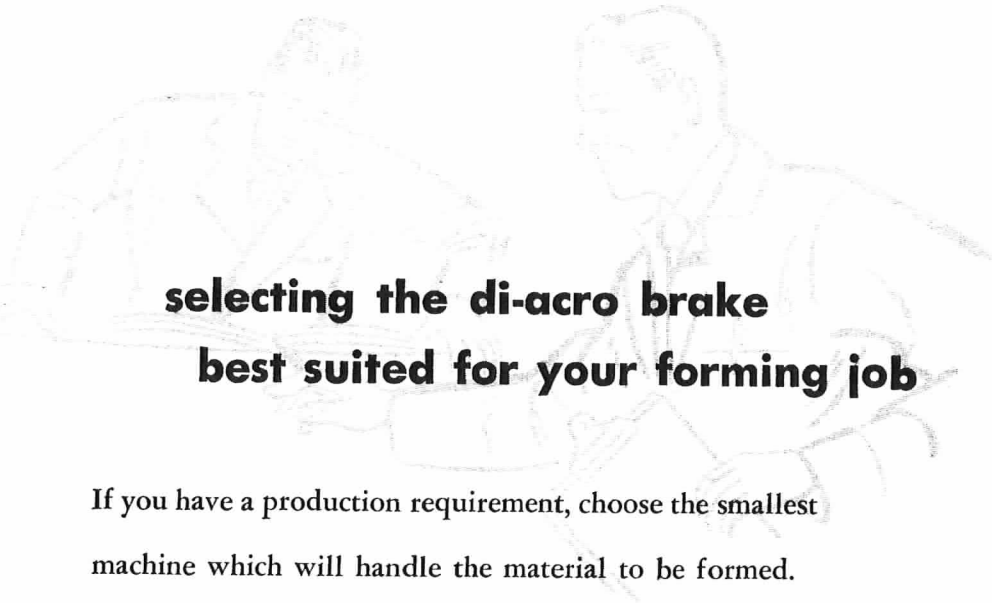
6 A RADIUS FORMER when using a radius bar or when the top forming bar is located back from the center line allowing material to form its own radius*.

versatile di-acro brakes

SIX-IN-ONE FORMING TOOLS

Simply Change the Forming Bar to Meet the Application

*When true centerline radius forming is required, a Di-Acro Radius Brake must be used



selecting the di-acro brake best suited for your forming job

If you have a production requirement, choose the smallest machine which will handle the material to be formed. You'll get faster production that way.

If you require a brake for use in the Model Shop, as well as for short run production, it would be well to choose a machine which gives you maximum forming capacity.

Select your Di-Acro Brake on the basis of the maximum number of jobs which you can perform with it now.

Don't base your selection on the exceptional jobs which may never materialize.

THESE CONSTRUCTION FEATURES ASSURE TROUBLE FREE PERFORMANCE—LONG

REMOVABLE HANDLES can be mounted in three different positions for maximum ease of operation and highest rate of production.

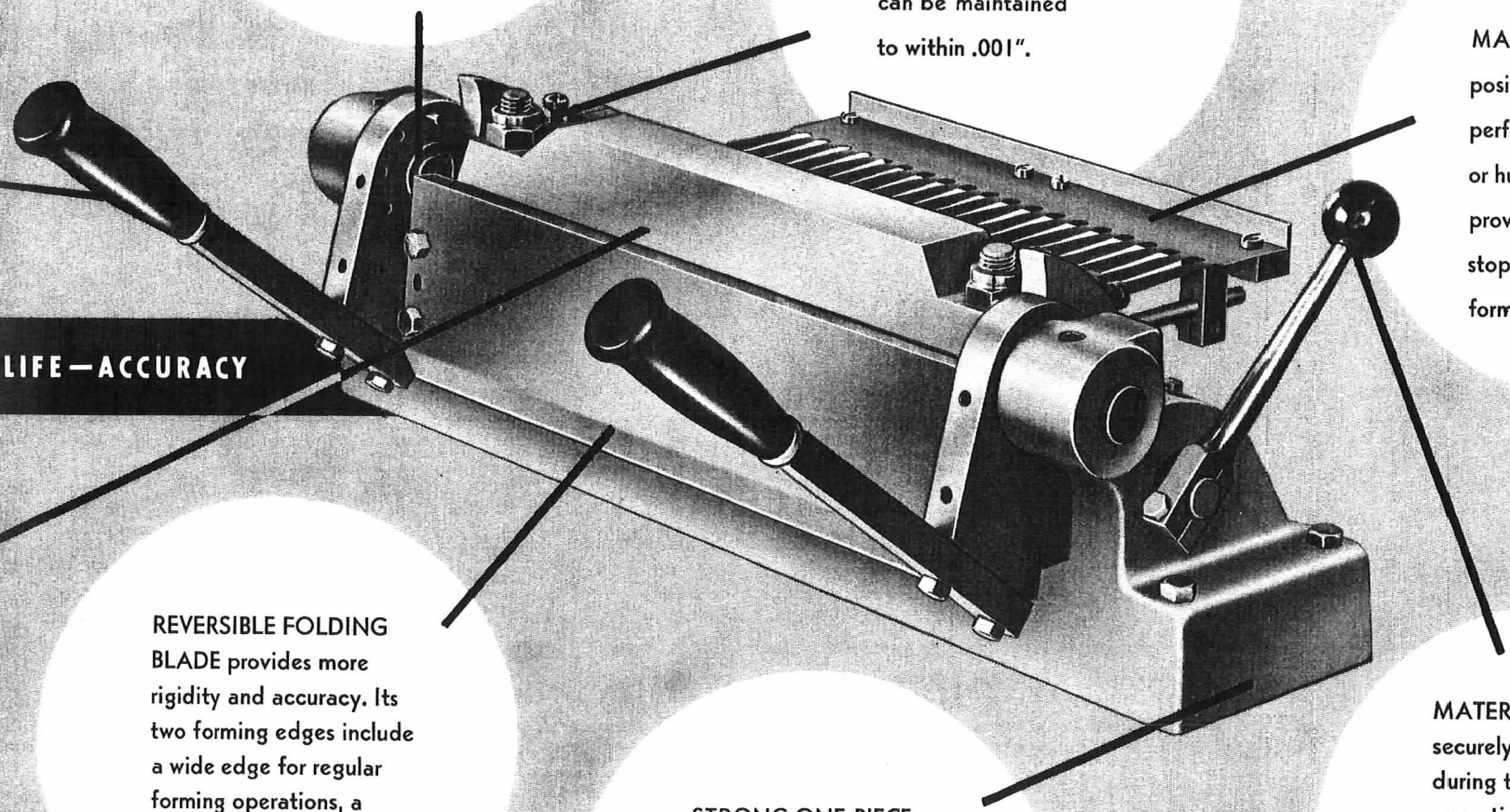
TOP FORMING BAR AND FINGERS are made of cold rolled steel, hardened and precision ground.

All Di-Acro Brakes are basically the same in construction and operating characteristics. Additional strength is built into each successively larger unit to adequately cover its greater forming range.

TORRINGTON ROLLER BEARINGS make for smooth easy operation on the toughest forming jobs.

ADJUSTABLE STOPS are quickly set to control the degree of bend. Tolerances can be maintained to within .001".

MATERIAL GAUGE positions the material for the perfect duplication of one or hundreds of parts, provides a positive and full stop across the entire forming width.



LIFE—ACCURACY

REVERSIBLE FOLDING BLADE provides more rigidity and accuracy. Its two forming edges include a wide edge for regular forming operations, a narrow edge for extremely close reverse bends.

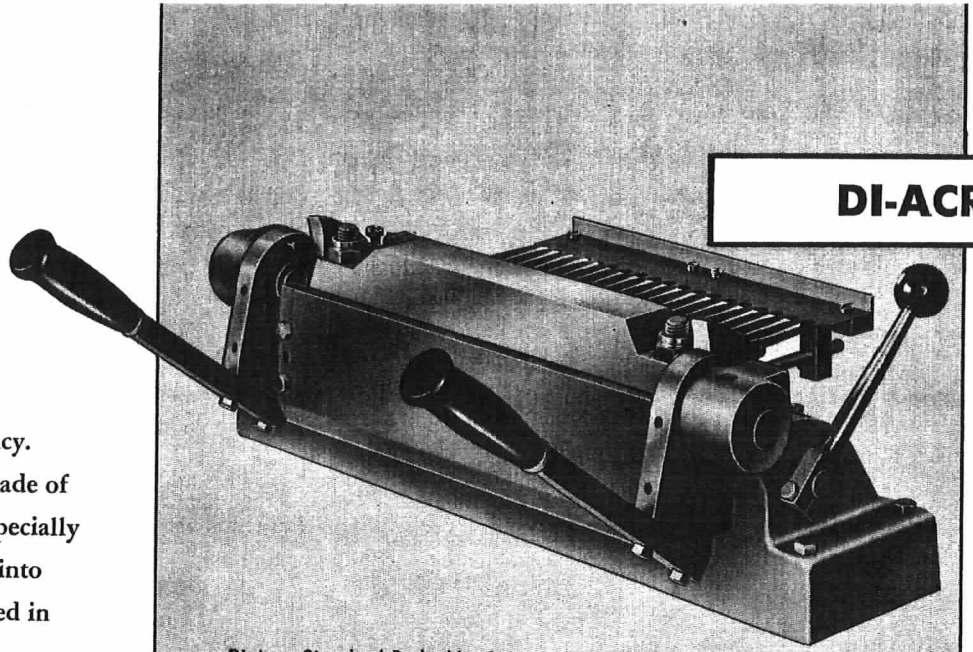
STRONG ONE-PIECE RIBBED BASE CASTING provides rigidity during the bending operation, makes for accuracy.

MATERIAL CLAMP securely locks material during the forming operation, assuring a sharp bend that can be duplicated to die accuracy. Clamp instantly releases for easy removal of the formed part.

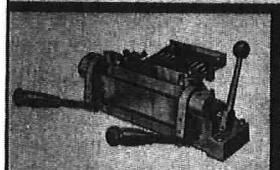
DI-ACRO STANDARD BRAKES

DI-ACRO BRAKE STAND

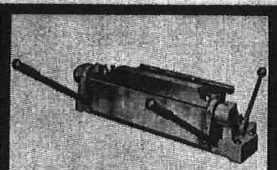
is especially designed to increase forming efficiency. Stand is 33" high and made of heavy plate steel and specially formed sections welded into a sturdy unit. It is finished in light machine tool gray.



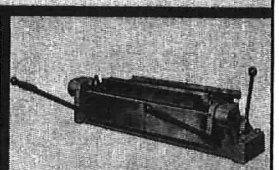
Di-Acro Standard Brake No. 2



Di-Acro Standard Brake No. 1



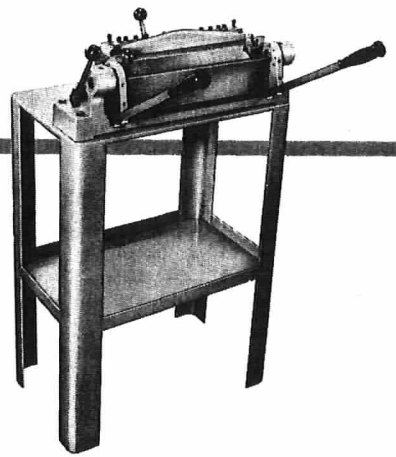
Di-Acro Standard Brake No. 3



Di-Acro Standard Brake No. 4

Form countless, simple and reverse bends in all types of ductile material with a Di-Acro Standard Brake. Numerous stock accessories are available, and with just a few simple tooling changes, specialized forming operations can be performed.

The material gauge included as standard equipment with this brake is the same as the Adjustomatic Gauge described on page 5 except that it is not lever operated. Di-Acro Standard Brakes are available in four models.



DI-ACRO BRAKE STAND
available for all brakes

STANDARD EQUIPMENT INCLUDES:

Standard Forming Bar
Standard Gauge

AVAILABLE ACCESSORIES ARE:

Acute Angle Bar
Box Finger Mount Bar complete with set of Box Fingers
Open End Finger
Block Mounting Blade
Adjustomatic Gauge
Brake Stand

SPECIFICATIONS AND CAPACITIES

DI-ACRO STANDARD BRAKE with Standard Gauge.	No. 1	No. 2	No. 3	No. 4
Maximum Forming Width	6"	12"	18"	24"
Material Capacity—Sheet Steel	16 gauge	16 gauge	16 gauge	16 gauge
Maximum Bend—Standard Bar	125°	125°	125°	125°
Maximum Bend—Acute Angle Bar	150°	150°	150°	150°
Net Weight	50 lbs.	100 lbs.	190 lbs.	275 lbs.

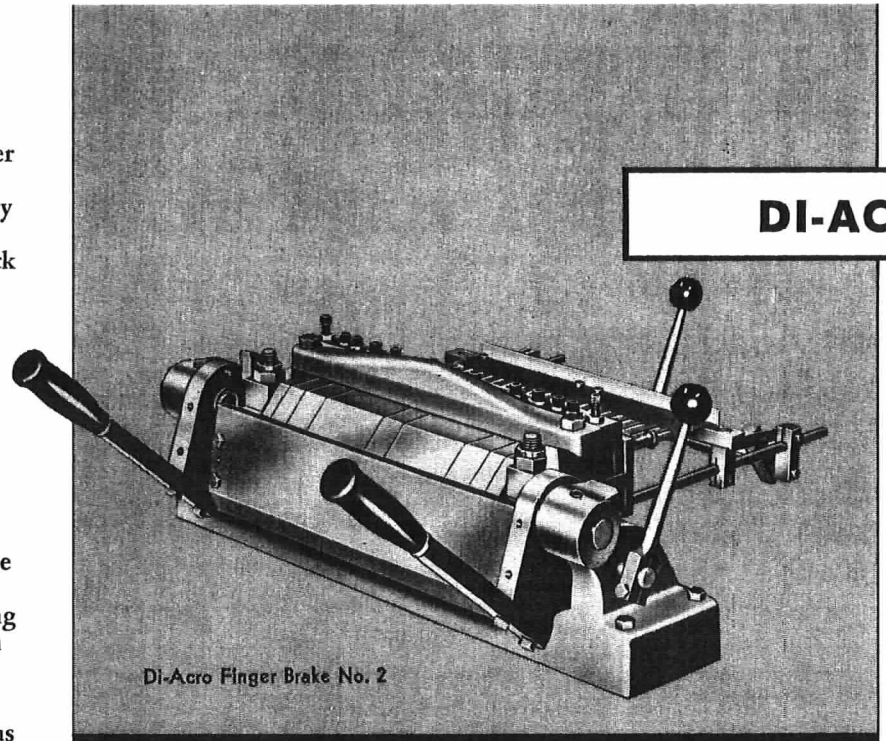
ADJUSTOMATIC GAUGE

is included on all Di-Acro Finger Brakes as standard equipment. It is a simple to operate accessory that accurately positions the material to be formed. Just a flick of the lever and it is set. Twist fingers of clock spring steel are located below the forming bar and provide a positive and parallel stop across the full forming width.

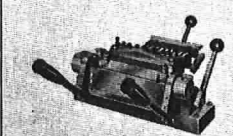
DI-ACRO BOX FINGER BAR

contains fingers graduated in size so when used in combinations they cover the entire box forming range from ½" to the maximum size of each model Di-Acro Brake in ⅛" steps.

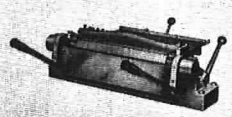
All Di-Acro Standard and Radius Brakes can be quickly converted into Finger Brakes by merely replacing their Standard or Radius Forming Bar with a Di-Acro Box Finger Bar.



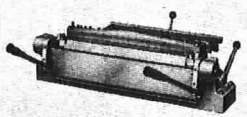
Di-Acro Finger Brake No. 2



Di-Acro Finger Brake No. 1



Di-Acro Finger Brake No 3



Di-Acro Finger Brake No. 4

DI-ACRO FINGER BRAKES

When you want maximum versatility, you'll want the Di-Acro Box Finger Brake.

Its hardened and precision ground steel fingers are graduated in size to allow fast setup for box forming and other specialized operations. When used in combination, these precision fingers cover the entire box forming range from ½" to the maximum width of each model in steps of ⅛".

By simply changing the tooling, a Di-Acro Finger Brake is easily converted into an Open End Brake, a Bar Folder, a Tab Former or a Standard Brake.

Di-Acro Box Finger Brakes are available in four models.

DI-ACRO BRAKE	No. 1	No. 2
Finger Bar Depth	2"	2½"
Maximum Capacity—Sheet Steel	16 gauge	16 gauge
Net Weight	12 lbs.	30 lbs.
DI-ACRO BRAKE	**No. 3**	**No. 4**
Finger Bar Depth	2½"	3"
Maximum Capacity—Sheet Steel	16 gauge	16 gauge
Net Weight	50 lbs.	70 lbs.

STANDARD EQUIPMENT INCLUDES:

Box Mounting Bar complete with set of Box Fingers

Adjustomatic Gauge

AVAILABLE ACCESSORIES ARE:

Acute Angle Bar

Standard Bar

Open End Finger

Block Mounting Blade

Brake Stand

SPECIFICATIONS AND CAPACITIES

DI-ACRO FINGER BRAKE with Adjustomatic Gauge.	No. 1	No. 2	No. 3	No. 4
Maximum Forming Width	6"	12"	18"	24"
Material Capacity—Sheet Steel	16 gauge	16 gauge	16 gauge	16 gauge
Maximum Bend—Finger Bar	125°	125°	125°	125°
Maximum Bend—Acute Angle Bar	150°	150°	150°	150°
Net Weight	60 lbs.	125 lbs.	235 lbs.	335 lbs.

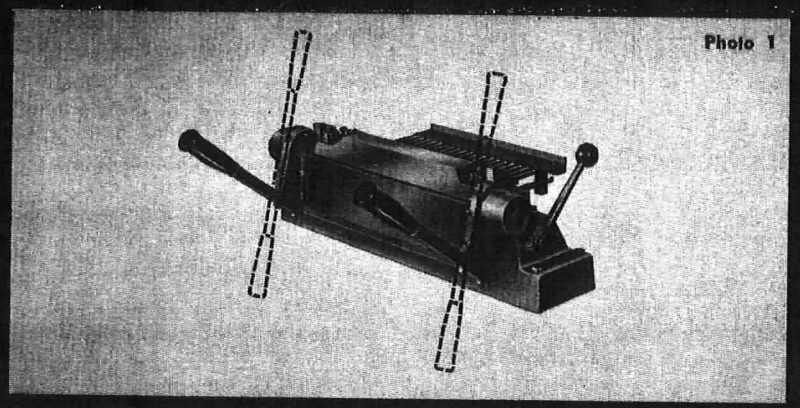
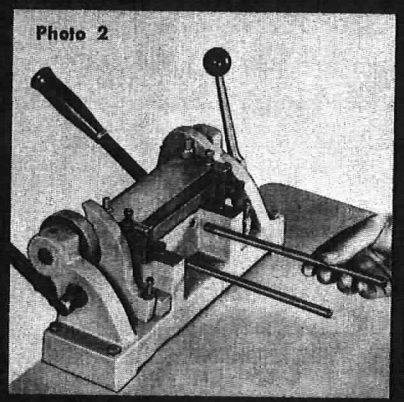


Photo 1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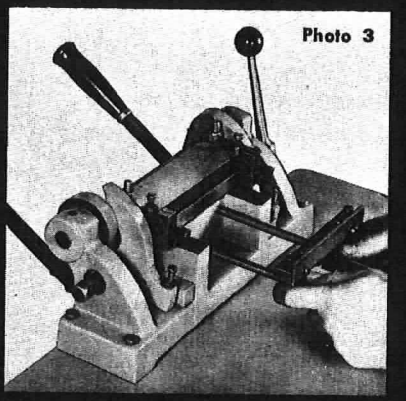


Photo 3

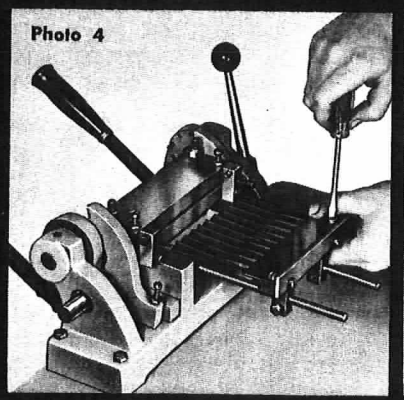


Photo 4

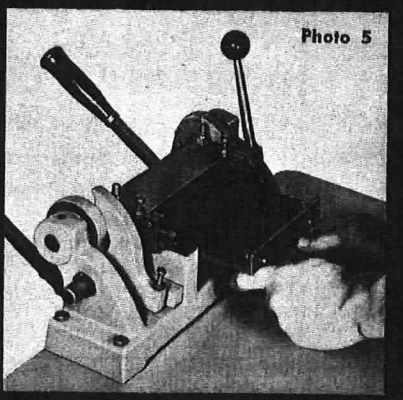


Photo 5

OPERATING INSTRUCTIONS FOR DI-ACRO STANDARD AND FINGER BRAKE

All Di-Acro Brakes are shipped partially knocked down. To set up for operation, the following procedure is suggested:

SETUP INSTRUCTIONS:

1. Attach handles to right and left brake arms. Three mounting positions are available (photo 1). When 20 gauge material (or lighter) is being formed, it is suggested that the handles be placed at an angular position or vertical with handle grips up. For heavier material, handles should be placed in a vertical position with the handle grips pointing downward. Either of the handles may be removed if material can be formed by the pressure exerted on just one handle.

2. On Di-Acro Standard Brake No. 1 *only,* the adjustable back gauge is also shipped knocked down. To mount, follow this simple procedure:

A. Mount gauge rods in rear of brake base (photo 2)

B. Mount Material Gauge on gauge rods (photo 3)

C. Mount Finger Gauge on Material Gauge Bar and lock in place with the two screws provided (photo 4)

D. Slide unit forward until Finger Gauge is between forming Bar and Bottom Plate. Adjust to desired position and lock in place (photo 5)

3. For most efficient operation, bolt the Di-Acro Brake to flat surface such as a rigid bench or stand. Shim if necessary to assure level mounting. The Brake should be positioned as close to the edge of the bench as possible so that the Folding Blade will overhang and allow close reverse bends to be formed in long lengths of material without interference from the bench.

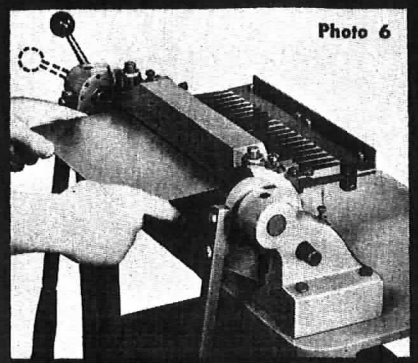
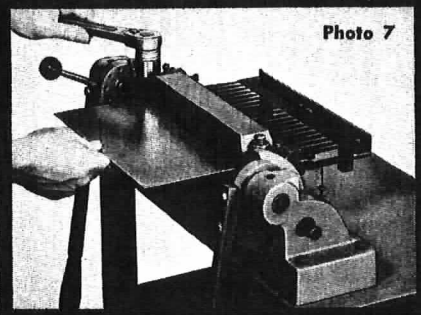


Photo 6



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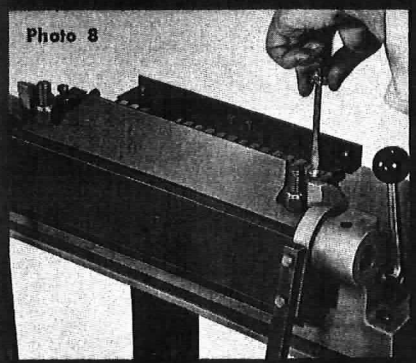

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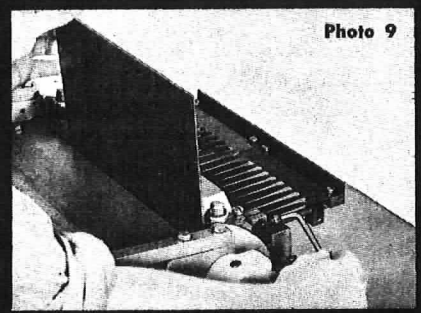

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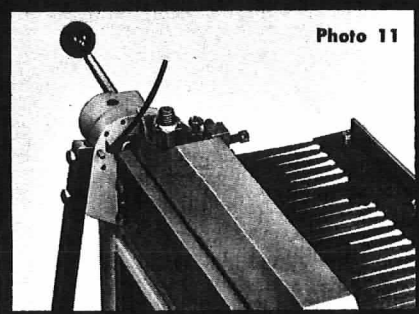


Photo 11

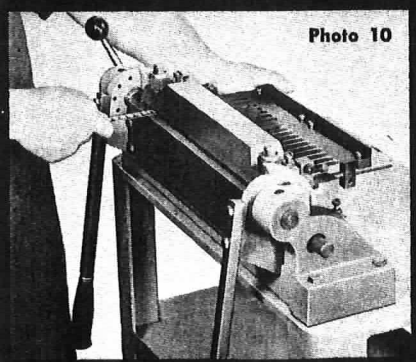


Photo 10

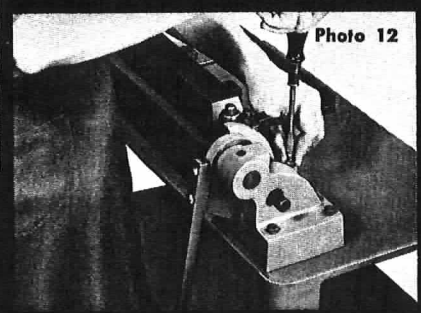


Photo 12

OPERATING INSTRUCTIONS

1. Insert material to be formed between Forming Bar and Bottom Plate and lock material in position by pulling forward on Clamp Handle (photo 6).

Adjust for material thickness by tightening Stop Nuts on top of Forming Bar so that Forming Bar exerts even pressure across the entire width of the inserted material (photo 7).

Enough pressure should be applied by the Forming Bar to securely hold the material during forming. However, the pressure should not be so great that it is difficult to clamp the material in place.

NOTE: The heel of the Forming Bar has an adjustable bolt on each end to provide proper support to the back edge of the Forming Bar. Bolts should be adjusted to allow the material to easily pass below the Forming Bar when the Material Clamp is disengaged. An extremely sharp bend can be obtained by adjusting these bolts so that the heel of the Forming Bar is raised causing greater pressure to be exerted on the material at the forming edge (photo 8).

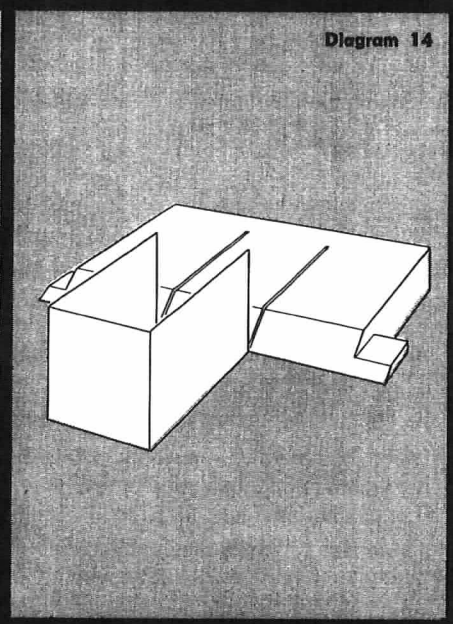
2. Adjust the Forming Bar so that the material being formed will fit snugly between the front edges of the Forming Bar and Folding Blade. To make this adjustment, raise the Folding Blade so that it is in the same plane as the Forming Bar. Adjust bolts on right and left Bar Stops (photo 9) and lock in place. To assure a sharp, even bend along the entire width of material, it is important that the front edge of the Forming Bar be exactly parallel with the forming edge of the Folding Blade.

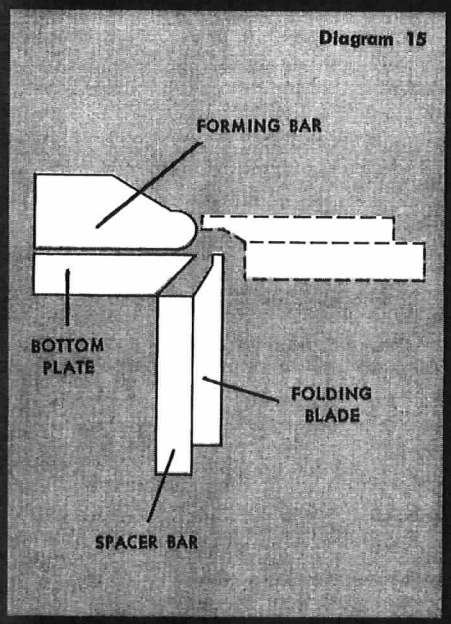
3. Adjust Finger Gauge to properly locate bend in material (photo 10).

When forming material longer than the depth of the Forming Bar, remove the Finger Gauge and use the Material Gauge to accurately gauge bends.

4. To adjust brake to form the correct degree of bend, first place the dowel pins in the holes provided on both right and left hand Brake Arms. That will give a degree of bend close to that which is desired (photo 11). Fine adjustment can now be made by adjusting the right and left Blade Stops to the required degree of bend (photo 12).

IMPORTANT—If you wish to duplicate a quantity of parts having several bends, the best rate of production can usually be obtained by forming the first bend in all parts before adjusting the brake for the next bend.





TOOLING DI-ACRO BRAKES

All Di-Acro Brakes as mentioned previously can be converted into a Standard Brake, Box and Pan Brake, Bar Folder, Open End Brake, Radius Brake and Tab Forming Brake by simply mounting the proper Forming Bar on the Brake. For example, to convert a Di-Acro Standard Brake into a Box and Pan Brake—

1. Remove the Standard Forming Bar, Material Gauge and Bar Stops.
2. Mount Bar Stop Spacer Assembly A (photo 13) and replace Bar Stops using longer Block Mounting Bolts supplied with Spacer Assembly. Mount twist finger gauges on Material Support Bar.
3. Mount the Box Finger Bar.

Forming Bars for special forming operations can also be mounted on a Di-Acro Brake. They can be purchased from the factory or can be made in your own shop.

FORMING LARGE BOXES

When forming a box with dimensions greater than the capacity of a Di-Acro Finger Brake, a special forming bar with the required dimension can be made and mounted in place of the Box Finger Bar. The bar can be slotted to the required depth (diagram 14).

When forming operations require that a part of the Standard or Special Forming Bar be cut away to relieve interference, it can be done provided the remaining portion of the bar has sufficient strength to withstand the bending pressure of the material to be formed. The bottom side of the Forming Bar can also be slotted or undercut to accept previously formed edges or projections.

RADIUS FORMING

Radius bends can be formed on a Standard or Finger Brake in two ways:

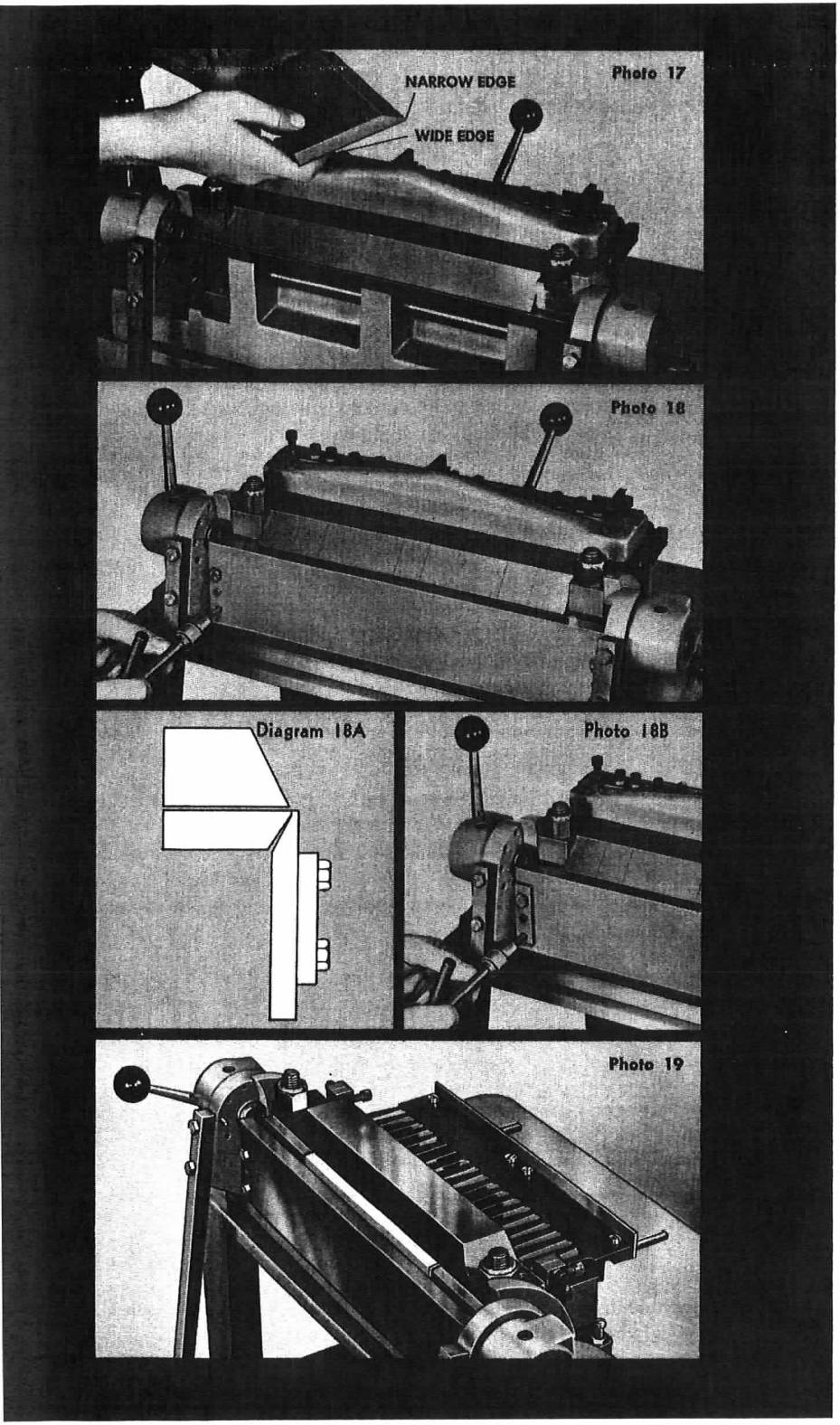
1. By moving the forming bar back from the center line which will allow material to form its own natural radius.
2. By replacing the forming bar with a Radius Bar.

To form a radius bend of 90° or less, mount the desired Radius Bar and reverse the Folding Blade so that its narrow edge faces upward and outward (diagram 15). When forming radius bends greater than 90°, use additional spacers so that the Folding Blade is positioned further out from forming center line allowing it to swing in an arc slightly greater than that of Radius Bar.

The Radius Bars listed for Di-Acro Brakes on page 12 are also available for Di-Acro Standard and Finger Brake No. 2 and 4.

FORMING BENDS GREATER THAN 125°

The Di-Acro Standard and Box Finger Bars are designed to form bends up to 125°. Using an Acute Angle Bar makes it possible to form bends up to 150° (photo 16). These bars are available from stock. Special Bars having greater angularity than 150° can be made on special order by the factory or in your own shop. Sufficient strength must always be retained in the forming edge to withstand the bending pressure.



FORMING CLOSE REVERSE BENDS

All Di-Acro Standard and Finger Brakes are equipped with a special Folding Blade having a wide edge and a narrow edge (photo 17). The wide edge is used for the majority of the forming operations. However, when it is desirable to form close reverse bends in material it is necessary to use the narrow edge.

To set up the Folding Blade for close reverse bends, remove the bolts on the right and left side of blade (photo 18), also the spacers located between the Folding Blade and the Brake Arms. Then reverse the Folding Blade so that the beveled side butts up against the beveled side of the Bottom Plate (diagram 18A). The narrow edge of the Folding Blade is then at the center line of forming.

Both spacers should be placed on the outside of the Folding Blade so that the same bolts may be used for holding the Folding Blade in place (photo 18B).

When forming sharp angles in heavy material, first form a 125° bend with a Standard Forming Bar, then complete the bend with a special Forming Bar having the required angle. This procedure will prevent distortion to the thin edge of the special Forming Bar.

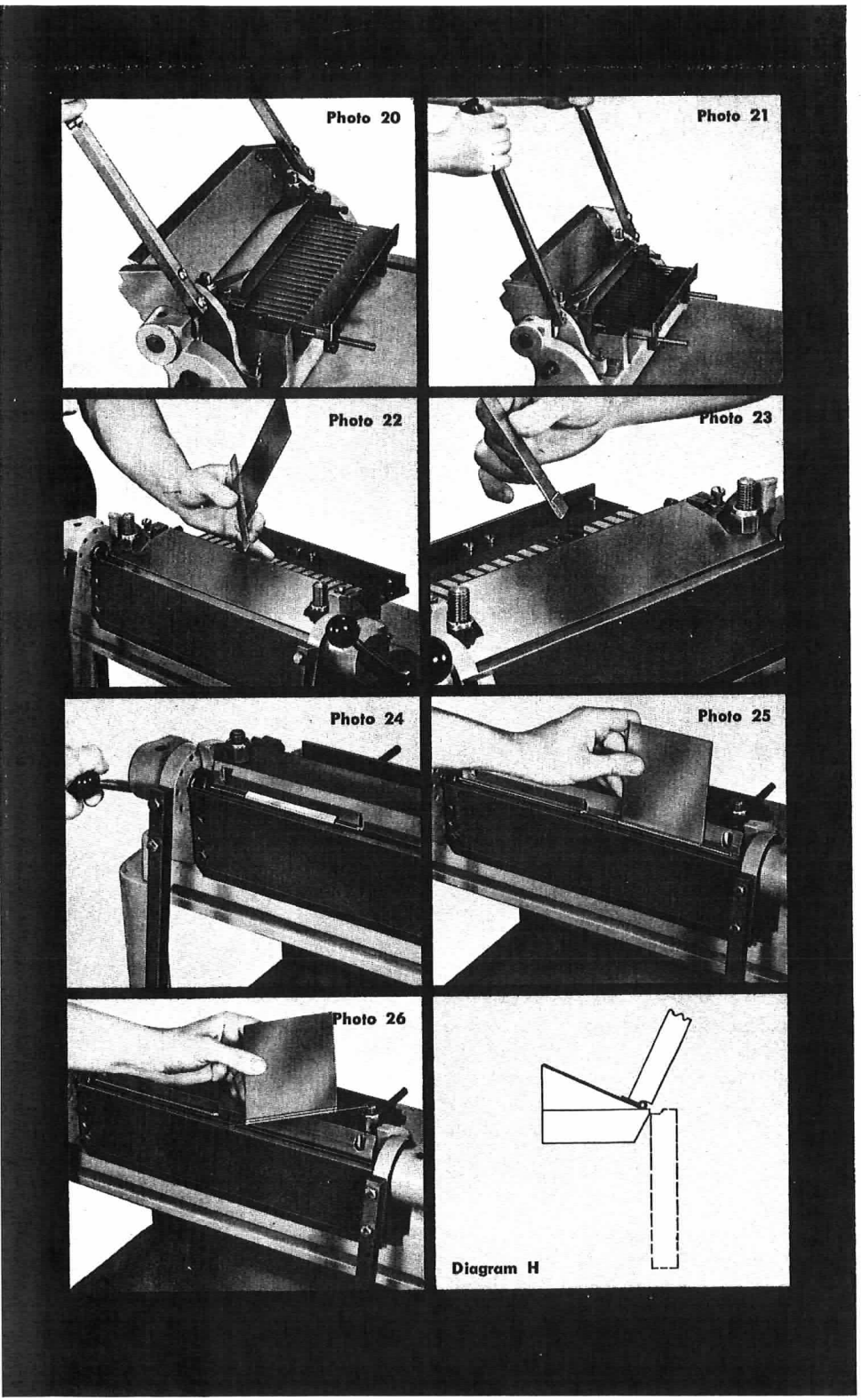
RELIEVING INTERFERENCE FROM THE BOTTOM PLATE

The Bottom Plate on a Di-Acro Brake is bolted to the Base Casting and acts as a material rest. It also makes for rigidity and accuracy during the forming operation.

If you find that this plate interferes with the forming of a part having edges protruding downward, the interference can usually be overcome by grooving or cutting away a portion of the Bottom Plate.

FORMING NARROW CHANNELS

Bending operations such as the forming of extremely narrow channels can be easily done on a Di-Acro Brake by machining a Forming Bar so that the edge will not interfere with the part to be formed (photo 19). As mentioned previously, sufficient strength must be retained in the Forming Bar to withstand bending pressure.



FORMING SINGLE HEMS

Single hems can be formed with a Di-Acro Brake in just two operations. Form an acute angle in the first operation (photo 20). Flatten the material in the second (photo 21). All light material can be formed in this manner with a Standard Forming Bar.

When forming a hem in heavier material, it is suggested that an Acute Angle Bar be used to form a bend greater than the 125° obtained with a Standard Forming Bar—the greater angle eases the flattening operation.

NOTE: When performing the flattening operation, move the Forming Bar back from the center line of forming approximately twice the thickness of the material. This provides a space for the material between the Forming Bar and the edge of the Folding Blade as it is being flattened.

When flattening heavy material, it is sometimes necessary to use a Standard Forming Bar rather than an Acute Angle Bar because the angle of the Standard Bar provides a greater space for flattening of the heavier material. *When flattening, the Forming Bar should always be locked against the Bottom Plate.*

If an open hem is desired for insertion of flat material (photo 22), follow the same procedure except insert a piece of spacer material in the angle formed by the first bend. Remove spacer material after the flattening operation.

FORMING DOUBLE HEMS

To form a double hem (photo 23,) first form a single hem as described in the preceding operation and then duplicate the operation. It is especially important that sufficient material clearance (3-4 times the thickness of material) be provided between the edges of the Forming Bar and the Folding Blade.

FORMING MATERIAL WITH A WIRE EDGE

Forming material around a length of wire can be done in just two operations by using a Folding Blade with a radius groove cut along its inner edge and a special Radius Bar that has a flat forming edge on one end for the flattening operation. First form a radius bend on the Radius Side of the Forming Bar (photo 24). Then insert the wire in the radius bend and close by placing the material against the flat edge of the Forming Bar and flattening (photo 25, 26).

The groove in the Folding Blade provides clearance for the wire and allows the material to be closed around the wire during the flattening operation (diagram H). The Folding Blade must be grooved the diameter of the wire and twice the thickness of the material.

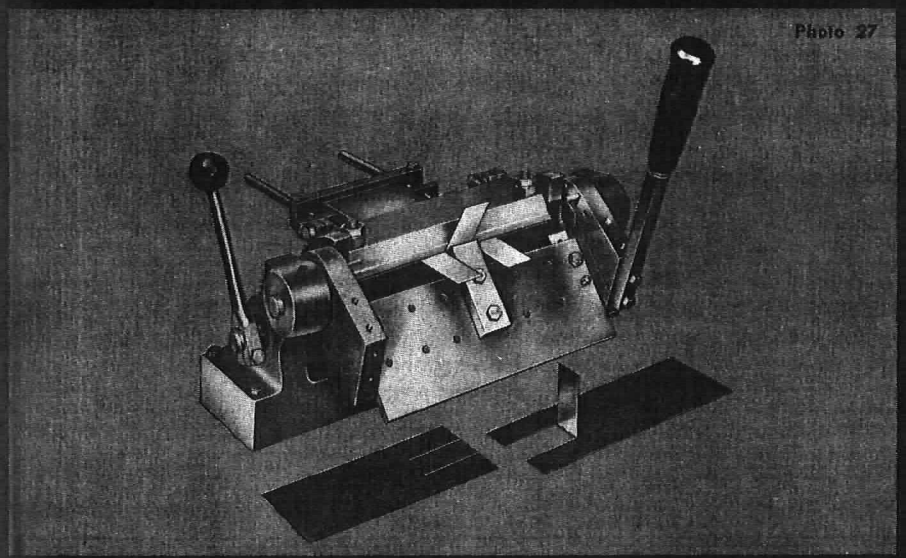


Photo 27

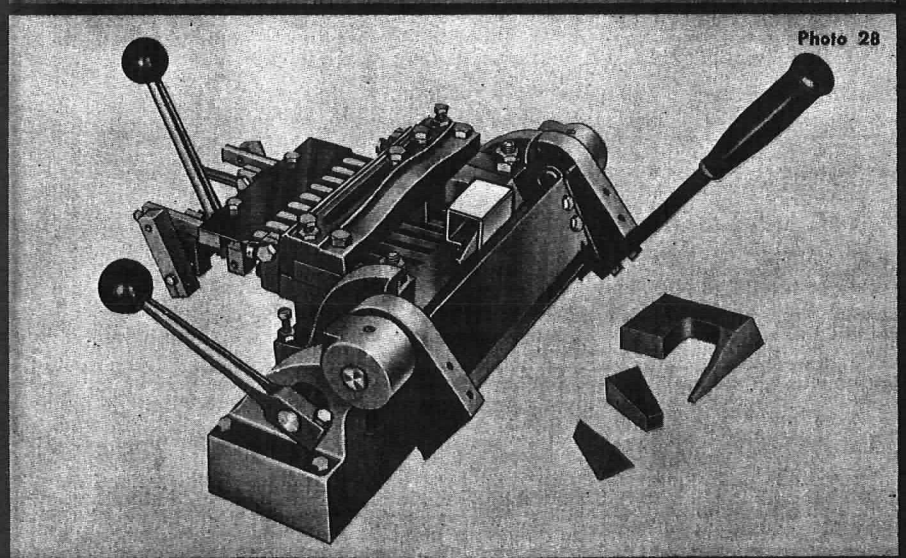


Photo 28

TAB FORMING

Tab Forming—forming a center section of a part without disturbing the flat material on either side of it—is easily performed on a Di-Acro Brake with a Block Mounting Blade (photo 27). Numerous tapped holes in the Block Mounting Blade allow one or a series of bending blocks to be mounted for the production of special parts.

Brakes No. 1 and 2 use a 3/8" thick Block Mounting Blade, and the No. 3 and 4 models use a 1/2" thick Blade. The Block Mounting Blade is positioned approximately 3/4" below the Bottom Plate.

Proper size bending blocks can be made to your specification or are easily prepared in your own plant.

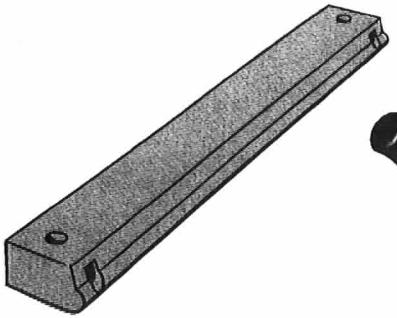
FORMING RECTANGULAR, SQUARE AND TAPERED SHAPES WITH THE OPEN END FINGER

The Open End Finger (photo 28) makes it possible to form triangular, square and rectangular tubes as well as other parts that entirely enclose the Forming Bar. The formed part is easily slipped off the open end of the Finger. The Open End Finger is mounted on the Finger Mount Bar used with the Box Finger Brake setup.

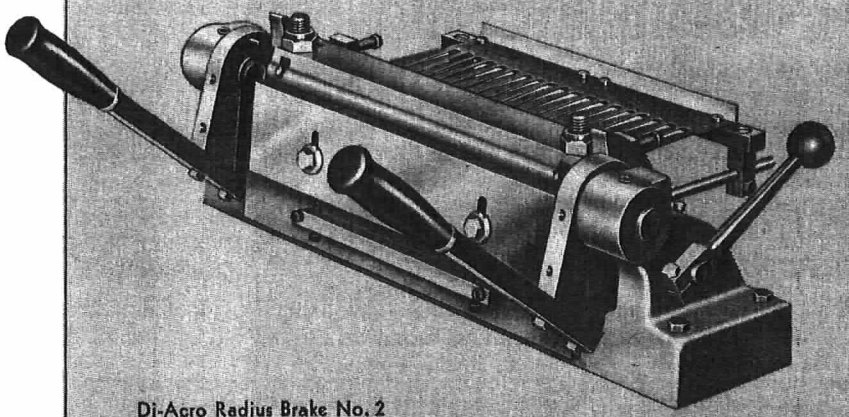
DI-ACRO BRAKE	No. 1	No. 2	No. 3	No. 4
Open End Finger*	3/4" x 3"	1 1/2" x 6"	1 1/2" x 6"	1 1/2" x 9"
Maximum Capacity—Sheet Steel	18 gauge	18 gauge	18 gauge	18 gauge
Net Weight	2 lbs.	6 lbs.	6 lbs.	9 lbs.

*The tapered shape of the Open End Finger allows forming parts of smaller dimensions when the length of the part is less than the dimension shown here.

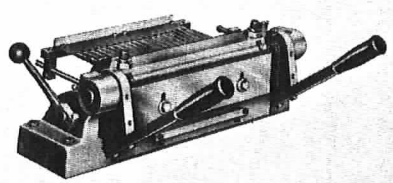
DI-ACRO RADIUS BRAKES



A complete range of radius bars from 1/16" to ½" can be quickly mounted on this brake to provide the exact radius for bending various gauges of alloy materials.



Di-Acro Radius Brake No. 2



Di-Acro Radius Brake No. 4

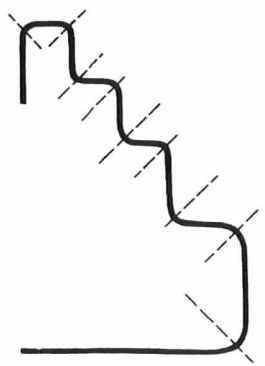
Primarily designed for use by the Aircraft Industry, the Di-Acro Radius Brake forms radius bends in materials of low ductility—without fracture—to standards recommended by the Air Force for Aircraft Construction.

The possibility of fracturing low ductile material has been eliminated because the Folding Blade swings a true arc around the edge of the Radius Bar, thus positively controlling the material during the forming operation.

Also, the crystalization of material during center line radius forming has been reduced because the bending stress on the material is distributed evenly over the entire forming area.

Equipment supplied with the Di-Acro Radius Brake includes a Standard Forming Bar (installed at factory) for sharp "no radius" bends and a choice of ONE of the Radius Bars listed below. Each Radius Bar contains two radius edges. Additional Radius Bars are available on special quotation.

All accessories for use with Di-Acro Standard and Finger Brakes can be mounted on Di-Acro Radius Brake. Two models of the Radius Brake are available.



The Di-Acro Radius Brake forms a true center line radius in sheet materials.

STANDARD EQUIPMENT INCLUDES:

Standard Forming Bar
Choice of ONE Radius Bar
Standard Gauge

AVAILABLE ACCESSORIES ARE:

Radius Bars (as described in table)
Acute Angle Bar
Finger Mount Bar Complete with set of Box Fingers
Open End Finger
Block Mounting Blade
Adjustomatic Gauge
Brake Stand

SPECIFICATIONS AND CAPACITIES

DI-ACRO RADIUS BRAKE with Standard Gauge	No. 2	No. 4
Maximum Forming Width	12"	24"
Material Capacity—Sheet Steel	16 gauge	16 gauge
Maximum Bend—Radius Bar	125°	125°
Net Weight	110 lbs.	290 lbs.

Radius Bars Available—Both Models

Radius Bar A	1/16" R and 3/32" R
Radius Bar B	1/8" R and 5/32" R
Radius Bar C	3/16" R and 7/32" R
Radius Bar D	1/4" R and 5/16" R
Radius Bar E	3/8" R and 1/2" R

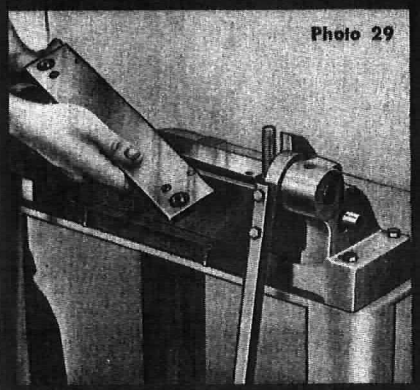


Photo 29

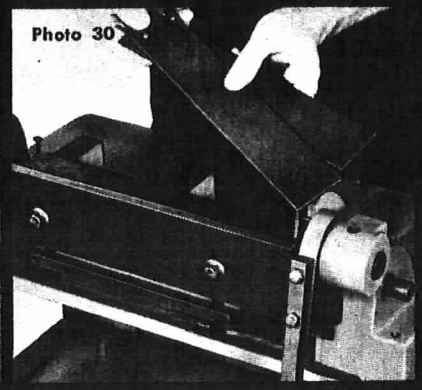


Photo 30

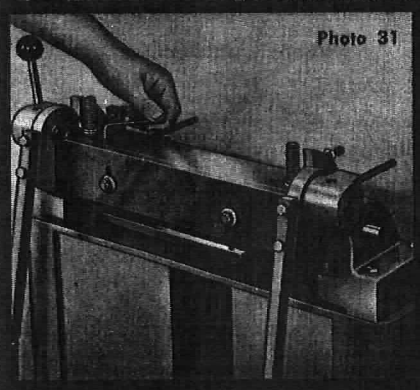
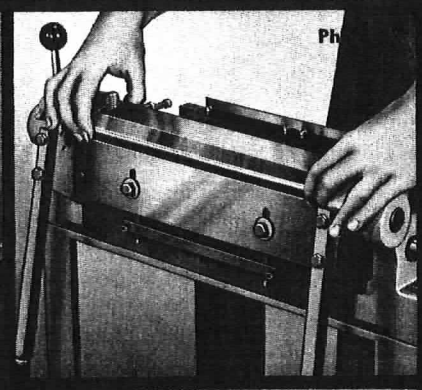


Photo 31


Ph

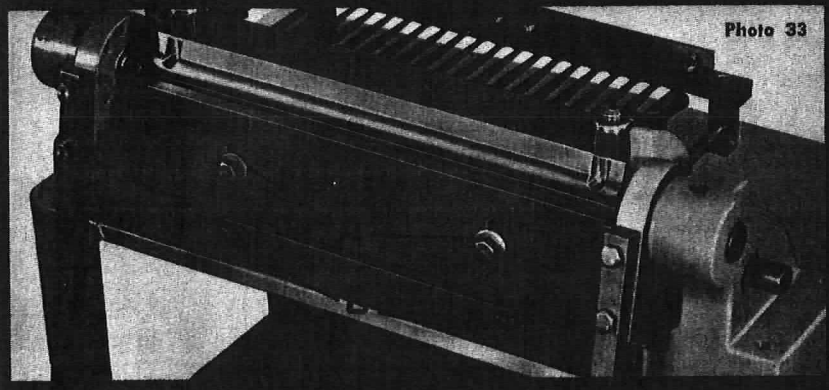


Photo 33

OPERATING INSTRUCTONS FOR DI-ACRO RADIUS BRAKE

To operate a Radius Brake, follow the same general setup procedure as given for the Di-Acro Standard and Finger Brake described on pages 6-7. Vertical adjustment of the Folding Blade is described in the section on FORMING TRUE RADIUS BENDS.

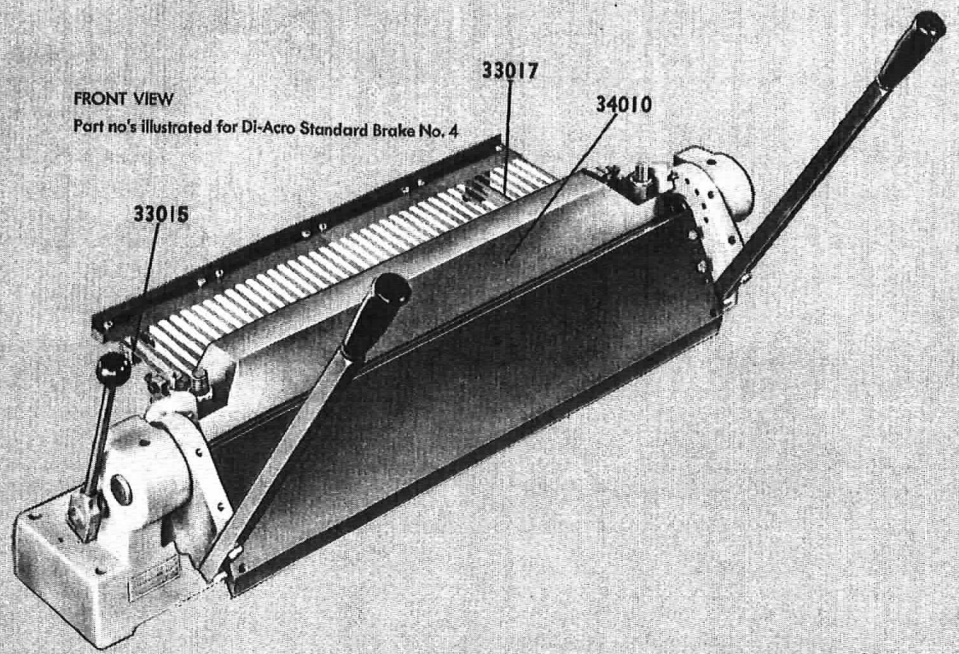
FORMING SHARP "NO RADIUS" BENDS

When it leaves the factory, the Di-Acro Radius Brake is pre-set with a Standard Top Forming Bar to form sharp "no radius" bends. Seven removable spacers (two 1/32", two 1/16" and three 1/8" thick) are positioned below the Bottom Plate. The purpose of these spacers is to bring the top surface of the Bottom Plate to the center line of forming. When forming sharp "no radius" bends, all spacers are in place so that the top edge of the Folding Blade is exactly level with the top surface of the Bottom Plate.

FORMING TRUE RADIUS BENDS

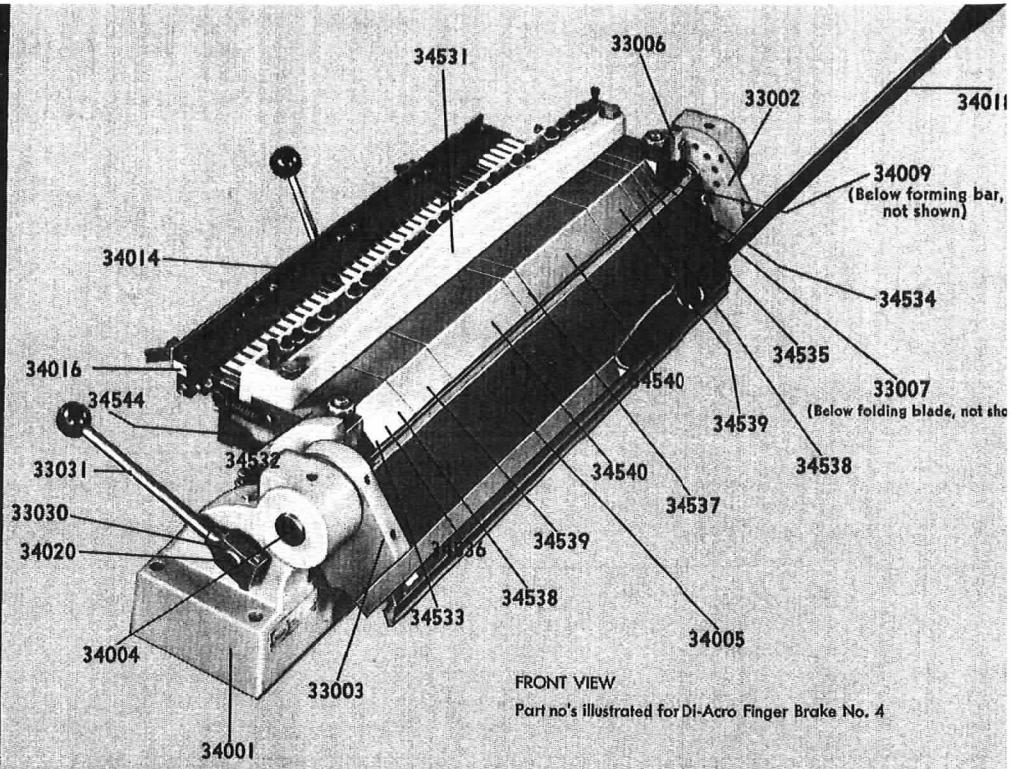
The Di-Acro Radius Brake can be set up for forming any radius to 1/2" simply by removing the proper number of spacers and installing the required Radius Bar. The number of spacers which are removed must equal the thickness of the material to be used plus the radius to be formed. For example, to form a 1/8" radius bend in material 1/16" thick—

1. Remove the Bottom Plate (photo 29)
2. Remove 1/8" and one 1/16" spacer to lower the Bottom Plate the required distance to 3/16" (photo 30)
3. Replace the Bottom Plate (photo 31)
4. Mount a 1/8" Radius Bar on the Brake (photo 32)
5. Adjust Folding Blade to exact level of Bottom Plate. Vertical positioning is made by loosening two hexagon bolts A in Folding Blade and adjusting set screws B (photo 33). See point No. 2 on page 7 for information on horizontal adjustment of Radius Bar.



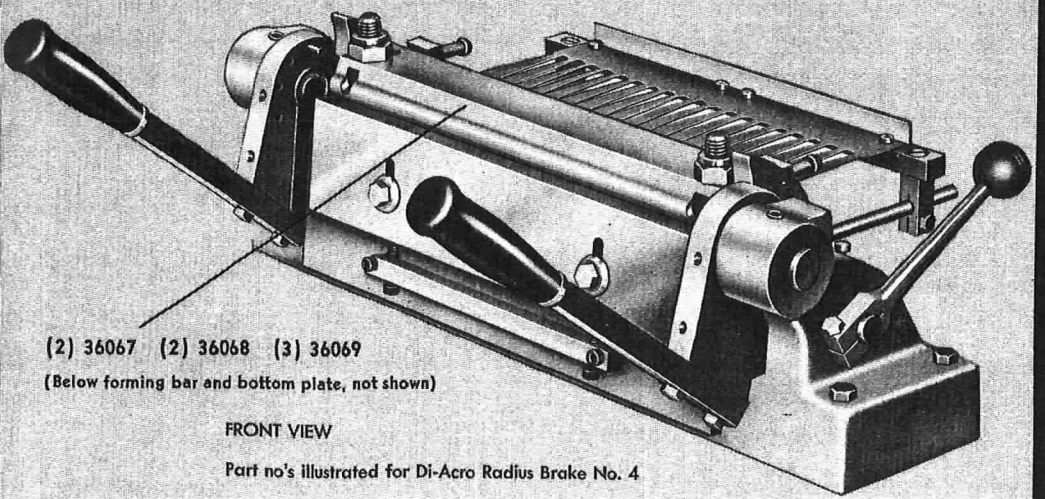
FRONT VIEW

Part no's illustrated for Di-Acro Standard Brake No. 4



FRONT VIEW

Part no's illustrated for Di-Acro Finger Brake No. 4

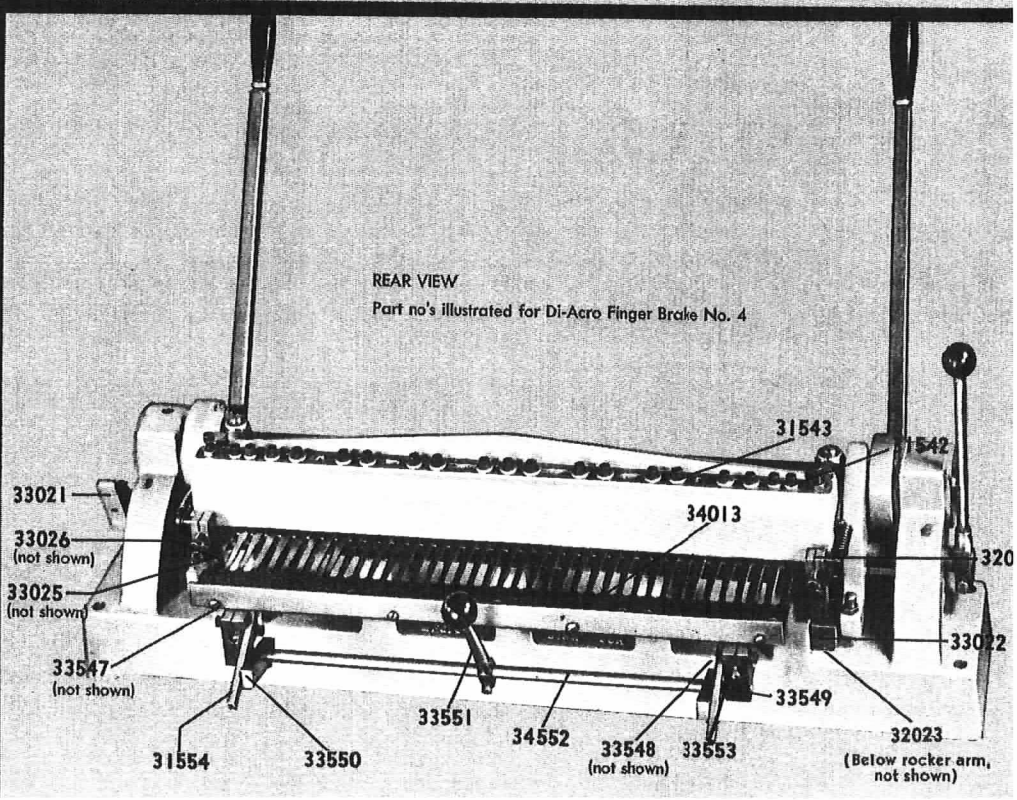


(2) 36067 (2) 36068 (3) 36069

(Below forming bar and bottom plate, not shown)

FRONT VIEW

Part no's illustrated for Di-Acro Radius Brake No. 4



REAR VIEW

Part no's illustrated for Di-Acro Finger Brake No. 4

parts list

	NO. 1 BRAKE		NO. 2 BRAKE			NO. 3 BRAKE		NO. 4 BRAKE		
	Std. Model	Box Finger Model	Std. Model	Box Finger Model	Radius Model	Std. Model	Box Finger Model	Std. Model	Box Finger Model	Radius Model
Base	31001	31001	32001	32001	35001	33001	33001	34001	34001	36001
Arm (right)	31002	31002	32002	32002	32002	33002	33002	33002	33002	36002
Arm (left)	31003	31003	32003	32003	32003	33003	33003	33003	33003	36003
Trunnion	.....	.....	.....	.....	.....	33004	33004	34004	34004	34004
Folding Blade	31005	31005	32005	32005	35005	33005	33005	34005	34005	36005
Folding Blade Stop	31006	31006	32006	32006	32006	33006	33006	33006	33006	33006
Spacer	31007	31007	32007	32007	.....	33007	33007	33007	33007	.....
Bottom Plate	31008	31008	32009	32009	35009	33009	33009	34009	34009	36009
Standard Forming Bar	31010	31010	32010	32010	32010	33010	33010	34010	34010	34010
Bar Stop	31012	31012	32012	32012	35012	32012	32012	32012	32012	36012
Finger Gauge	31013	31013	32013	32013	34013	33013	33013	34013	34013	34013
Material Stop	31014	31014	32014	32014	32014	33014	33014	34014	34014	34014
Material Stop Clamp	31015	31015	31015	31015	31015	33015	33015	33015	33015	33015
Material Support Bar	31016	31016	32016	32016	35016	33016	33016	34016	34016	34016
Rod	31017	31017	31017	31017	31017	33017	33017	33017	33017	33017
Handle Arm	31018	31018	32018	32018	32018	33018	33018	34018	34018	34018
Clamp Handle Arm	31019	31019	31019	31019	31019	.....	.....	.....	.....	.....
Shaft	31020	31020	32020	32020	32020	33020	33020	34020	34020	34020
Shaft Stop	.....	.....	.....	.....	.....	33021	33021	33021	33021	33021
Rocker Arm	31022	31022	32022	32022	32022	33022	33022	33022	33022	33022
Rocker Arm Spacer	31023	31023	32023	32023	32023	32023	32023	32023	32023	32023
Roller	.....	.....	.....	.....	.....	33025	33025	33025	33025	33025
Roller Shaft	.....	.....	.....	.....	.....	33026	33026	33026	33026	33026
Clamp Handle Block	.....	.....	.....	.....	.....	33030	33030	33030	33030	33030
Clamp Handle Rod	.....	.....	.....	.....	.....	33031	33031	33031	33031	33031

	NO. 1 BRAKE		NO. 2 BRAKE			NO. 3 BRAKE		NO. 4 BRAKE		
	Std. Model	Box Finger Model	Std. Model	Box Finger Model	Radius Model	Std. Model	Box Finger Model	Std. Model	Box Finger Model	Rad Mod
Finger Mount	.....	31531	.....	32531	.....	.....	33531	.....	34531	....
Clamp Arm	.....	31532	.....	32532	.....	.....	33532	.....	34532	....
½" Finger	.....	31533	.....	32533	.....	.....	32533	.....	34533	....
⅝" Finger	.....	31534	.....	32534	.....	.....	32534	.....	34534	....
¾" Finger	.....	31535	.....	32535	.....	.....	32535	.....	34535	....
⅞" Finger	.....	31536	.....	32536	.....	.....	32536	.....	34536	....
1" Finger	.....	31537	.....	32537	.....	.....	32537	.....	34537	....
1⅛" Finger	.....	31538	.....	32538	.....	.....	32538	.....	34538	....
3" Finger	.....	.....	.....	32539	.....	.....	32539	.....	34539	....
6" Finger	.....	.....	.....	.....	.....	.....	33540	.....	34540	....
Finger Mount Washer A	.....	31542	.....	31542	.....	.....	31542	.....	31542	....
Finger Mount Washer B	.....	31543	.....	31543	.....	.....	31543	.....	31543	....
Bar Stop Spacer Assembly A	.....	31544-1	.....	32544	.....	.....	33544	.....	34544	....
Adjustomatic Clamp (right)	.....	31547	.....	31547	.....	.....	33547	.....	33547	....
Adjustomatic Clamp (left)	.....	31548	.....	31548	.....	.....	33548	.....	33548	....
Adjustomatic Trunnion	.....	31549	.....	31549	.....	.....	33549	.....	33549	....
Adjustomatic Arm	.....	31550	.....	31550	.....	.....	33550	.....	33550	....
Adjustomatic Handle Arm	.....	31551	.....	31551	.....	.....	33551	.....	33551	....
Adjustomatic Shaft	.....	31552	.....	32552	35552	.....	33552	.....	34552	....
Adjustomatic Rod	.....	31553	.....	31553	.....	.....	33553	.....	33553	....
Adjustomatic Link	.....	31554	.....	31554	.....	.....	31554	.....	31554	....
1/32" Spacer	.....	.....	.....	.....	35067	.....	.....	.....	.....	36067
1/16" Spacer	.....	.....	.....	.....	35068	.....	.....	.....	.....	36068
1/8" Spacer	.....	.....	.....	.....	35069	.....	.....	.....	.....	36069

WHEN ORDERING PARTS PLEASE ORDER BY NUMBER
ALSO SPECIFY MODEL AND SERIAL NUMBERS