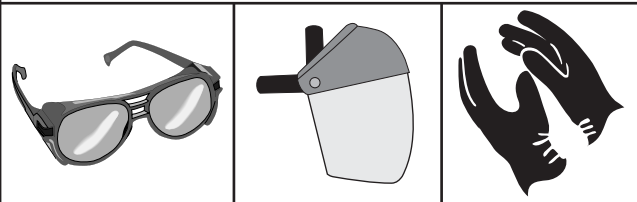




MODEL H3243/H3244/H3245 VISE BRAKE INSTRUCTIONS

⚠ WARNING

Damage to your eyes, face, and hands could result from using this item without proper protective gear, such as safety glasses, face shield, and heavy leather gloves.



Specifications

Maximum Bend	90°
Workpiece Material.....	Cold Rolled Mild Steel
Maximum Workpiece Thickness	14 Gauge
Male Die Thickness.....	1/4"
Male Die Length to Tip.....	1 1/4"
Male Die Total Width	
— Model H3243.....	4"
Two 1" Dies & One 2" Die	
— Model H3244.....	5"
Two 1" Dies & One 3" Die	
— Model H3245.....	6"
Two 1" Dies & One 4" Die	
Male Die Angle.....	25°
Female Die Angle.....	90°
Vise Mounting Type.....	Magnetic

If you need help with your new vise brake, call our Tech Support at: (570) 546-9663.

Inventory

Refer to **Figure 1** and the table below to inventory the contents of the shipping box.

REF	PART #	DESCRIPTION	QTY
1	PH3243001	FEMALE DIE 4" (H3243)	1
1	PH3244001	FEMALE DIE 5" (H3244)	1
1	PH3245001	FEMALE DIE 6" (H3245)	1
2	PH3243002	MALE DIE HOLDER 4" (H3244)	1
2	PH3244002	MALE DIE HOLDER 5" (H3244)	1
2	PH3245002	MALE DIE HOLDER 6" (H3245)	1
3	PSB04M	CAP SCREW M6-1 X 10	4
4	PH3243004	MALE DIE 2" (H3243)	1
4	PH3244004	MALE DIE 3" (H3244)	1
4	PH3245004	MALE DIE 4" (H3245)	1
5	PH3243005	MALE DIE 1"	2
6	PH3243006	MALE DIE PLATE 4" (H3243)	1
6	PH3244006	MALE DIE PLATE 5" (H3244)	1
6	PH3245006	MALE DIE PLATE 6" (H3245)	1

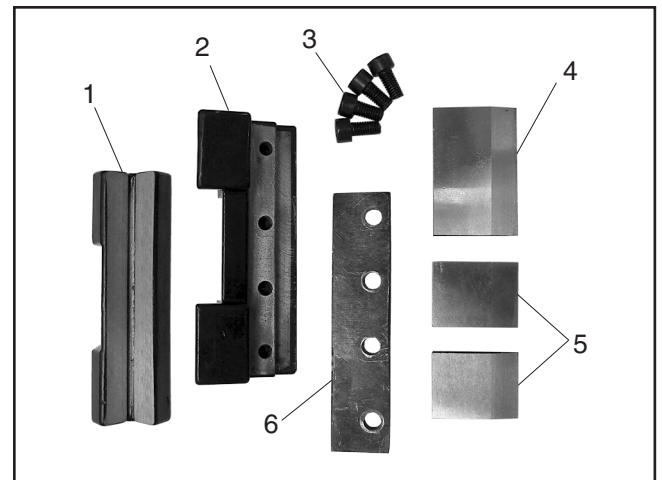


Figure 1. Model H3243/H3244/H3245 inventory.

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Operation

1. Put on heavy leather gloves.
2. Loosen the cap screws and configure the male dies for your operation, then re-tighten the cap screws.
3. Place the vise brake assembly on the vise as shown in **Figure 2**.

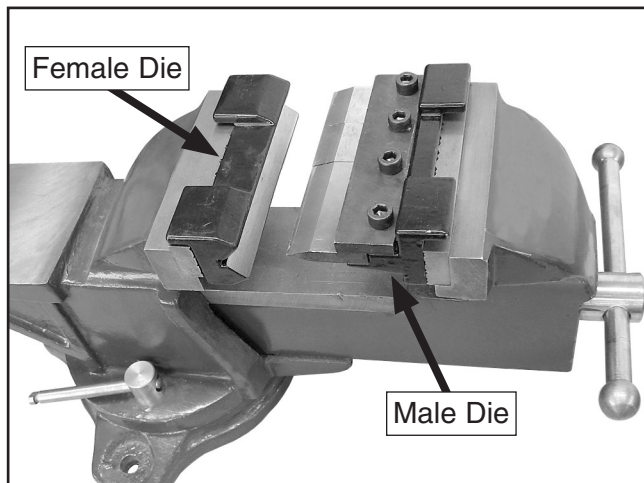


Figure 2. Example of vise brake mounted on a bench-top vise (Model H3243 shown).

4. Position the workpiece between the dies, then slowly bring the vise jaws together to perform the bend.

⚠ CAUTION

The edges of the dies and the workpiece are sharp and can easily cut fingers and hands. Always wear heavy leather gloves when handling the dies and bending metal workpieces.

Maintenance

Clean away debris and grime from the vise brake parts, then apply a thin coat of metal protectorate to the die surfaces to prevent rust (see **Figure 3** for recommended products).

Store the vise brake in a clean, dry area and protect the die surfaces from damage.



Figure 3. Recommended products for protecting the unpainted dies.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz Spray

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

H3788—G96® Gun Treatment 12 oz Spray

H3789—G96® Gun Treatment 4.5 oz Spray

