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# MODEL T28657 28" HEAVY-DUTY BENCHTOP BRAKE

## Introduction

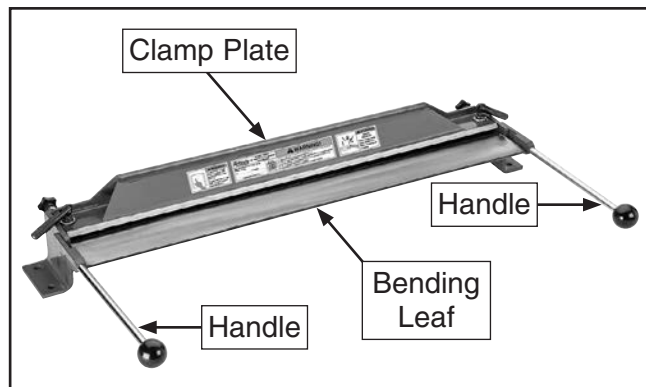
This metal bender will quickly and easily perform repeatable bends in sheet metal up to 135°.

## Specifications

- Maximum Bending Capacity
  - Aluminum.....14 Gauge
  - Mild Steel.....18 Gauge
  - Stainless Steel.....20 Gauge
- Maximum Bending Angle ..... 135°

## Setup

1. Degrease unpainted surfaces with solvent cleaner or citrus-based degreaser.
2. Mount machine to workbench or stand.
3. Install handles on bending leaf (see **Figure 1**).

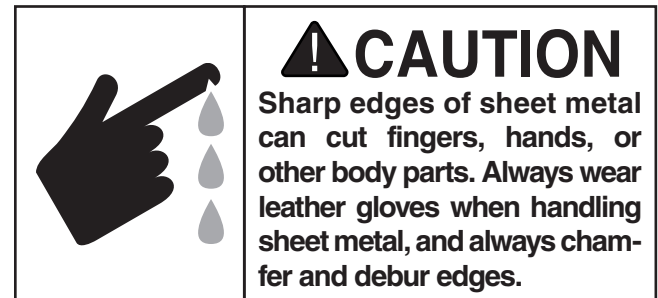


**Figure 1.** Benchtop brake components.

## Determining Setback

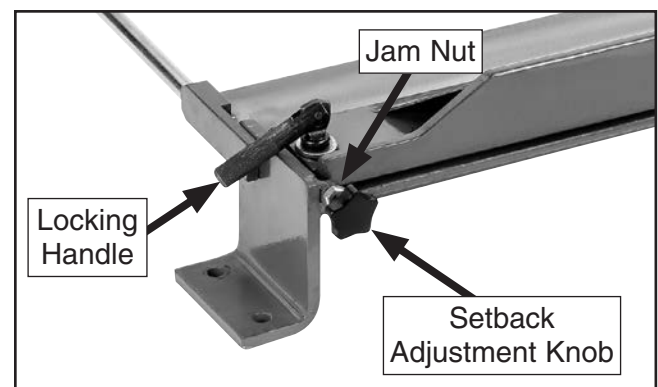
Setback is the required distance between the bending leaf and the clamp plate (see **Figure 1**) to properly make a bend. Factors that help determine the correct setback distance are bend radius and material thickness.

Sources to help you calculate the correct setback for your operation include metalworking handbooks, the internet, and experienced sheet metal workers.



## Operation

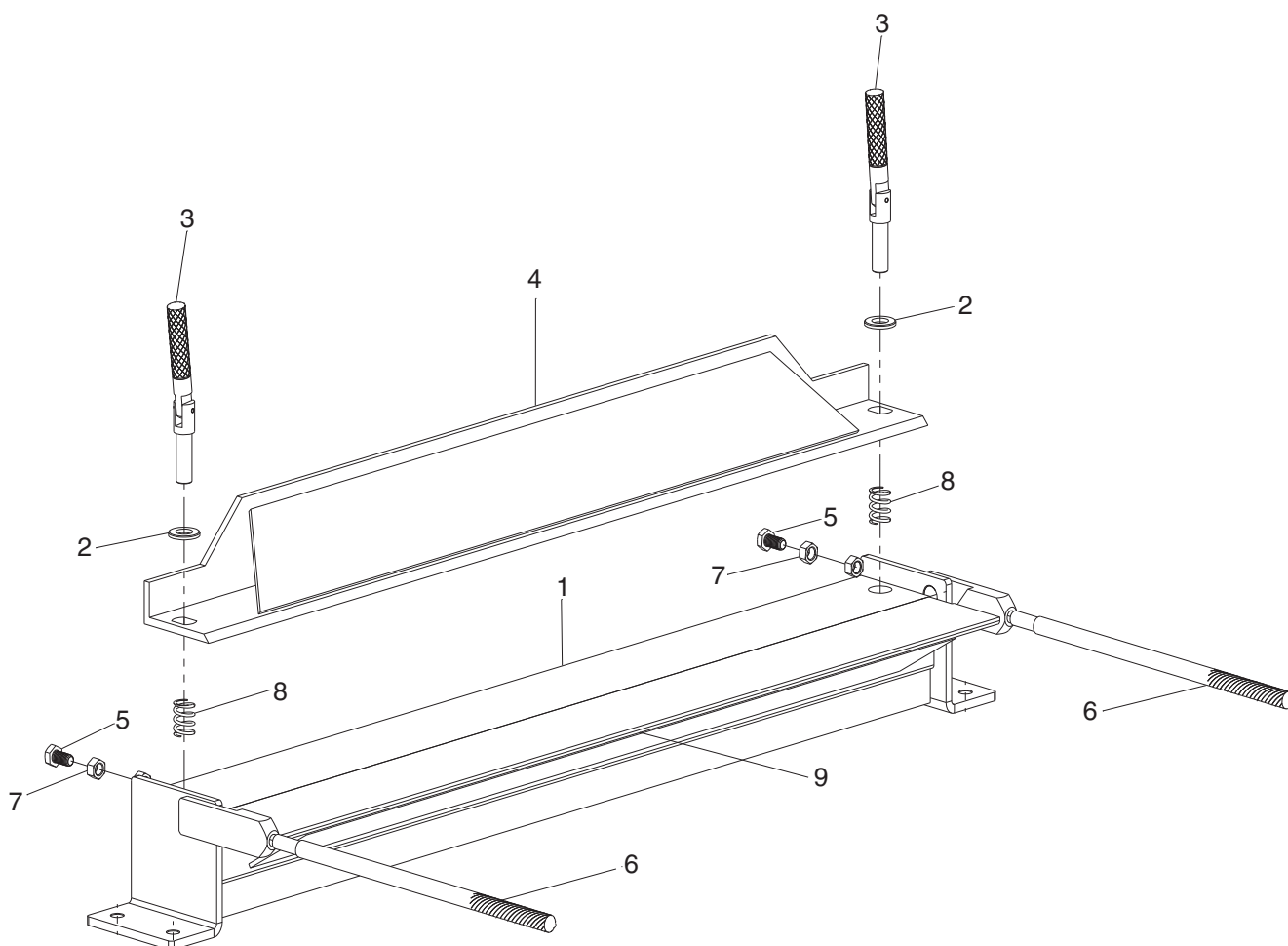
1. Adjust clamp plate setback (see **Figure 2**) using adjustment knobs, then secure position by tightening jam nuts at each end of brake.
2. Mark bending line on workpiece. Line up mark with front edge of clamping plate, then secure position by tightening locking handles (see **Figure 2**).



**Figure 2.** Bending components.

3. Bend metal using both bending leaf handles until workpiece is at desired angle.

# Parts Breakdown & List



REF PART #	DESCRIPTION
1	PT28657001 BED
2	PT28657002 FLAT WASHER 16MM
3	PT28657003 LOCKING HANDLE M12-1.75 X 33
4	PT28657004 CLAMP PLATE
5	PT28657005 SETBACK ADJUSTMENT KNOB

REF PART #	DESCRIPTION
6	PT28657006 HANDLE
7	PT28657007 HEX NUT M8-1.25
8	PT28657008 COMPRESSION SPRING 1.5 X 16 X 26
9	PT28657009 BENDING LEAF

**Please Note:** We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at [www.grizzly.com](http://www.grizzly.com) to check for availability.

