



MODEL T21319 24" BENDING BRAKE INSTRUCTION SHEET

Introduction

The Model T21319 24" Bending Brake is ideal for a small workshop environment where ease of use is important. The Model T21319 can bend up to 18 gauge (0.473 in. or 12mm) mild steel.

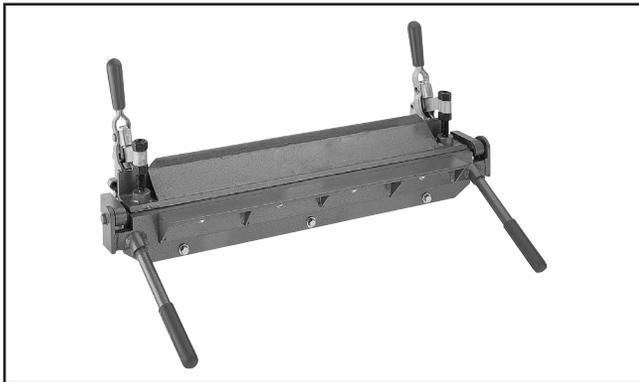


Figure 1. Model T21319 24" Bending Brake.

Inventory (Figure 2)

- A. Bending Brake Assembly 1
- B. Clamping Angle 1
- C. Clamp Assemblies..... 2
- D. Breaker Bar Levers..... 2
- E. Hardware Bag (not shown)
 - Hex Bolts M10-1.25 x 30..... 4
 - Hex Nuts M10 4
 - Lock Washers 10mm 4

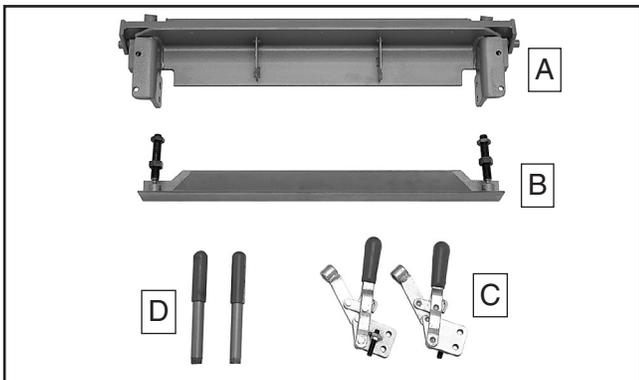


Figure 2. Inventory.

Assembly

To assemble your bending brake:

1. Securely mount the bending brake assembly to a workbench or other stable surface using 8mm hex bolts, flat washers, lock washers and hex nuts. Mounting hole locations are indicated in **Figure 3**.

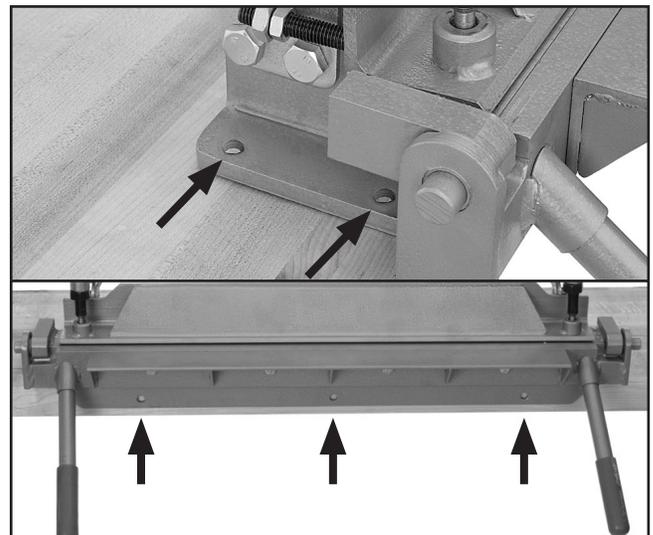


Figure 3. Mounting hole locations (right side of bending brake not shown).

2. Place the clamping angle on the bending brake assembly.
3. Mount each clamp assembly as shown in **Figure 4** on the next page. Ensure that each adjustment set screw shown in **Figure 4** is towards the outside of the bending brake assembly. Secure with hex bolts, lock washers and hex nuts.

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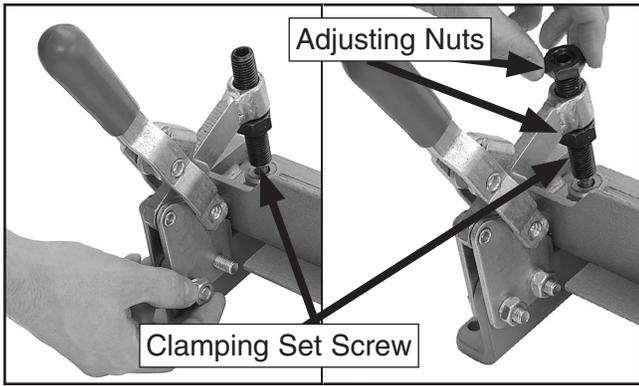


Figure 4. Clamp installation.

4. Screw the two breaker bar levers into the breaker bar holes, as shown in **Figure 5**.



Figure 5. Breaker bar lever installation.

⚠ CAUTION

The bending brake **MUST** be clamped or secured to a workbench before being used. Failure to do so can lead to personal injury or machine damage!

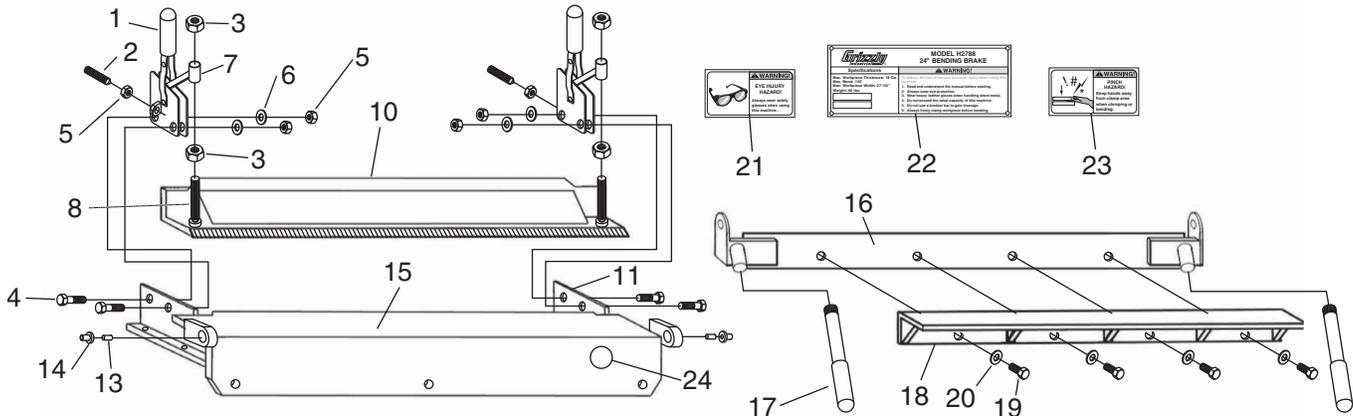
Basic Bending Operations

1. Open the bending brake and place the workpiece beneath the clamping angle.
2. Close the clamp assemblies until they lock. If the workpiece is too thick or too thin for the clamps, adjust the clamps according to **Clamp Adjustment** on this page.
3. When the workpiece is secured in the bending brake, lift the breaker bar levers to form the desired angle.

Clamp Adjustment

1. Without turning the clamping set screw, turn the adjusting nuts clockwise to adjust for thicker workpieces and counterclockwise to adjust for thinner workpieces. Adjust each clamp an equal amount.

T21319 Breakdown and Parts List



REF	PART #	DESCRIPTION
1	PT21319001	CLAMP
2	PSS39M	SET SCREW M10-1.5 X 50
3	PN05M	HEX NUT M16-1.5
4	PB01M	HEX BOLT M10-1.5 X 30
5	PN02M	HEX NUT M10-1.5
6	PLW06M	LOCK WASHER 10MM
7	PT21319007	COLLAR
8	PT21319008	SPECIAL SET SCREW M10-1.5 X 90
10	PT21319010	CLAMPING ANGLE
11	PT21319011	CLAMP MOUNTING PLATE
13	PT21319013	PIVOT PIN 16 X 50

REF	PART #	DESCRIPTION
14	PT21319014	FLANGE BEARING
15	PT21319015	BASE
16	PT21319016	BREAKER BAR
17	PT21319017	THREADED LEVER M20-1.75
18	PT21319018	BREAKER ANGLE
19	PB03M	HEX BOLT M8-1.25 X 16
20	PW01M	FLAT WASHER 8MM
21	PT21319021	PINCH HAZARD WARNING
22	PT21319022	MACHINE ID LABEL
23	PLABEL-11D	SAFETY GLASSES LABEL
24	PPAINT-1	GREEN TOUCH-UP PAINT