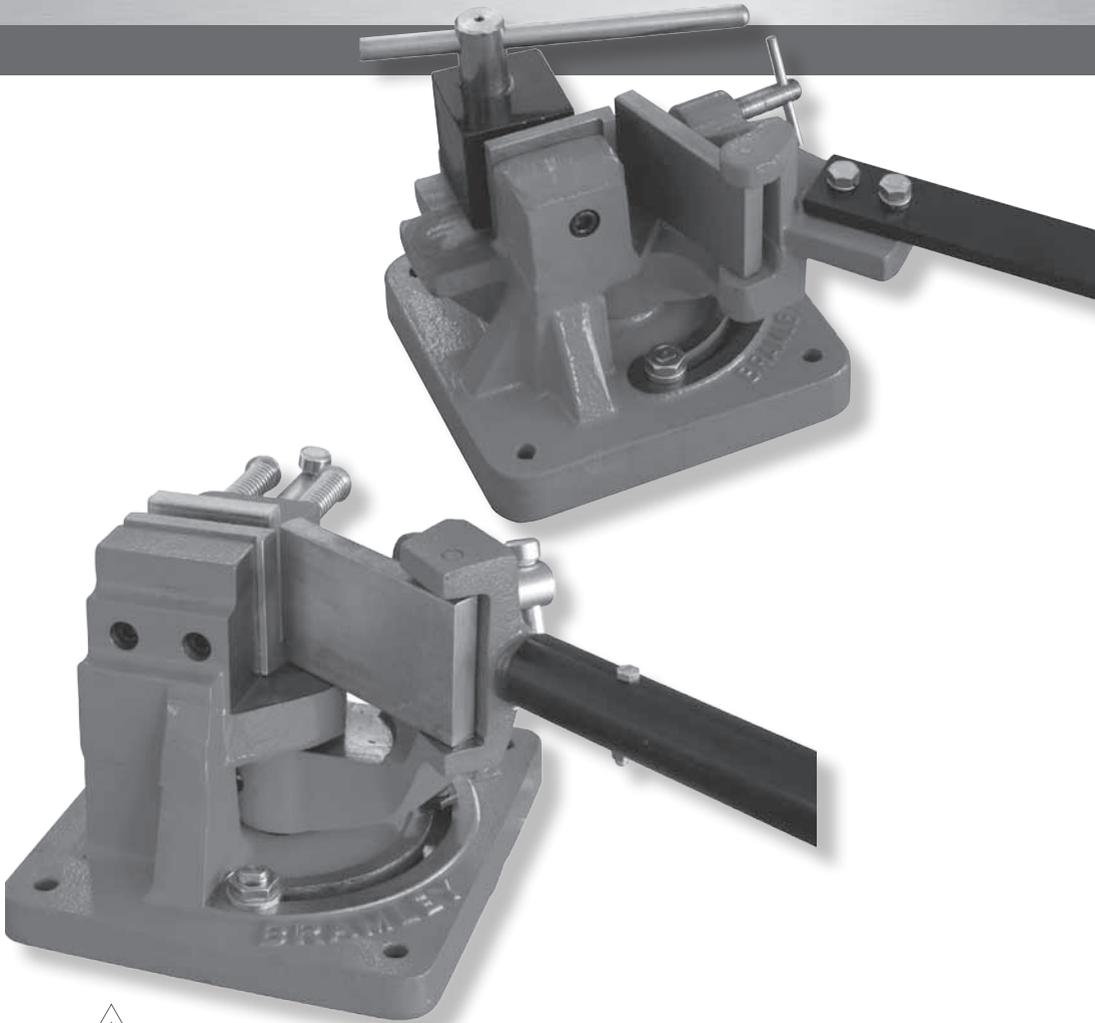


Operating Instructions & Parts List

Bramley Models 42 (AB2) & 62 (AB1) Angle Bending Machines



BRAMLEY

Bramley Models 42 (AB2) & 62 (AB1) Angle Bending

Thank you for purchasing a Bramley Angle Bending Machine.

These machines are designed for general purpose bending of flat, round and square metal bar.

Operation and Assembly

Upon receipt of the Angle Bending Machine bolt it down securely to either a sturdy table or the optional extra Angle Bender Stand - (Part # 060 TBSTAND).

Ensure that the Swivel casting (P4202 / P6202) is well lubricated by the grease nipple located in its central boss. It is important to ensure that this grease nipple is kept lubricated during the life of the bender.

Attach the Handle (P6208 / P4214) supplied to the bender using the bolts supplied.

Select material to be bent and clamp it in the vice of the machine.

The No. 2 Angle Bender has a screw type Vice and the No. 1 Angle Bender has an Eccentric Block (P6204) to achieve clamping of the material.

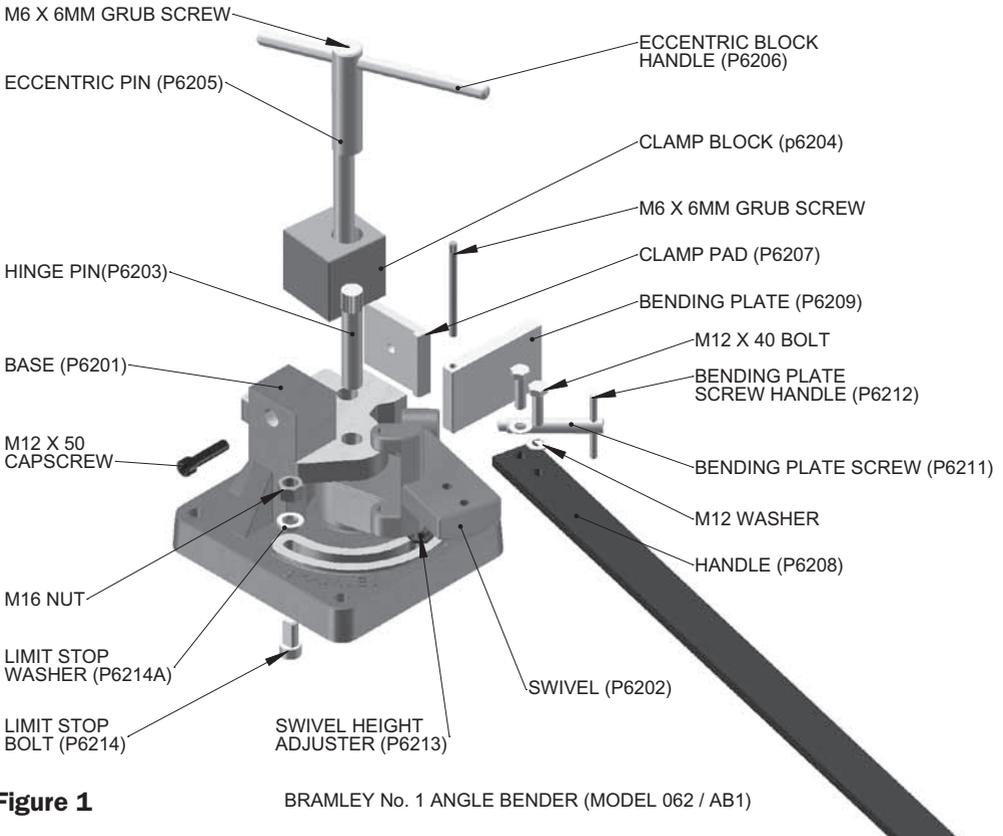


Figure 1

BRAMLEY No. 1 ANGLE BENDER (MODEL 062 / AB1)

Due to the variations between metric and imperial bar specifications the Eccentric Block type clamp may require shimming behind the Clamp Pad (P6207) to achieve sufficient clamping force for some sizes of material.

With the material to be bent secured in the Vice, adjust the Bending Plate (P6209 / P4209) so that it just comes in contact with the material.

By backing the Bending Plate (P6209 / P4209) slightly off the material to be bent a larger bend radius may be achieved.

Then by pulling on the Bending Handle (P6208 / P4214), pull around until the desired bend angle is achieved.

The bend angle can be limited by sliding the Limit Stop (P6214 / P4222) around the angle quadrant

slot and tightening in the desired position. This is useful for multiple bends of the same angle.

By loosening both the Clamp Vise and the Bending Plate, the bent piece of material can then be removed from the machine.

It is not recommended, or necessary, to use heat during the bending process as this destroys the grease lubricant in the swivel casting in which case seizure may result and affect warranty on the machine.

When bending softer materials such as aluminium or copper for electrical bus-bars, it may be preferable to remove the Clamp Pad (P4207 / P6207) from the bender and, with a belt grinder or similar, turn the sharp bending corner into a small radius to avoid cracking of the material.

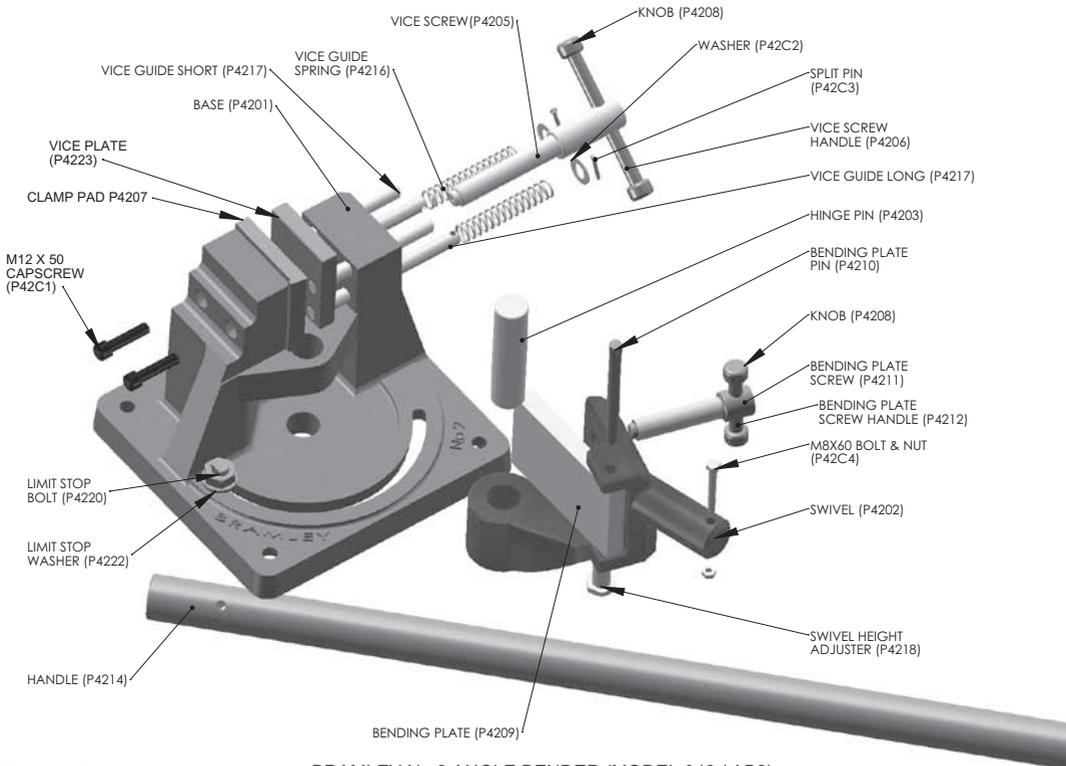
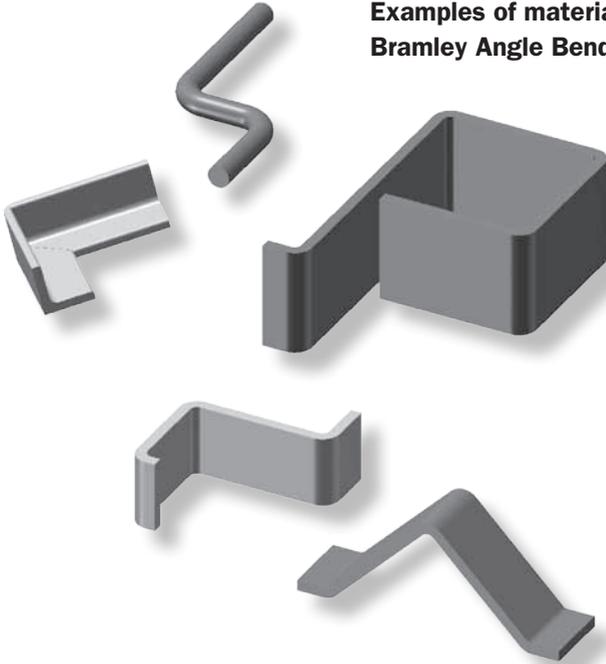


Figure 2

BRAMLEY No.2 ANGLE BENDER (MODEL 042 / AB2)

**Examples of materials bent in the
Bramley Angle Bending Machine.**



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