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INSTRUCTIONS FOR SETTING UP AND OPERATING #209 POWER BRAKE.

See that the Brake sets level on the floor. The direction of the motor is shown by an arrow in the rear view.

All main bearings are lubricated by the Alemite-Zerk pressure grease gun furnished with the machine.

OPERATION:

Before raising the apron (#31) be sure the stop (#50) is fastened to the rack (#26). This prevents raising the apron too far. To raise the apron, after starting motor, pull clutch handle (#32) away from Brake. This will raise the apron until the operator pushes the handle into neutral (straight up and down) or until the stop (#50) strikes the automatic throw-out. To lower the apron push the clutch handle towards the brake. When the apron is all the way down, the clutch handle will return to neutral.

Before bending any material the top jaw should be set back three times the thickness of the material, from the bending edge. This is done by loosening cap screws (#51) and moving the slot casting backward or forward by means of adjustment screws (#52) and #53). When the top jaw is in the proper position, tighten cap screws (#51).

To raise the top (#34) lift up on handle (#33). When the top has been raised as required, release the handle. Set the nuts (#54) against the handle and when the top is raised thereafter, the handle will be released automatically at the right time.

When the material to be bent is in position, press down on handle (#33) bringing the top down and clamping the material. As soon as the handle starts to kick, release it. Holding the handle down after it starts to kick causes excess wear on bronze clutch A (Detail A).

Raise the apron to the desired point. If a number of bends of the same angle are to be made, set the stop (#50) against the automatic throw-out device (#12). On all bends made thereafter, the apron will stop at this point and be lowered automatically.

See clutch instruction sheet for adjustment of clutch.

Should the metal bend over further on one end than the other, set the end of the upper jaw back, on which the sheet is bent over the furthest.

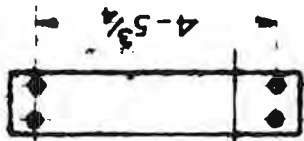
Short, heavy pieces should be bent in the center of the brake, as the strain is equalized thereby.

The reinforcing angle bar and the high carbon steel bar on the bending leaf can be removed when narrow reverse bends are desired.

Further instructions will be given gladly on any point, regarding which you may desire information.

DREIS & KRUMP MFG. COMPANY
7400 SOUTH LOOMIS BLVD.,
CHICAGO, ILLINOIS

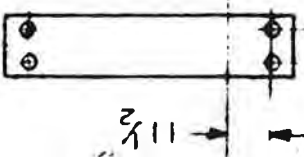
No. 188 POWER BRAKE
 DREIS & KRUMP MFG. CO.
 CHICAGO, ILL.



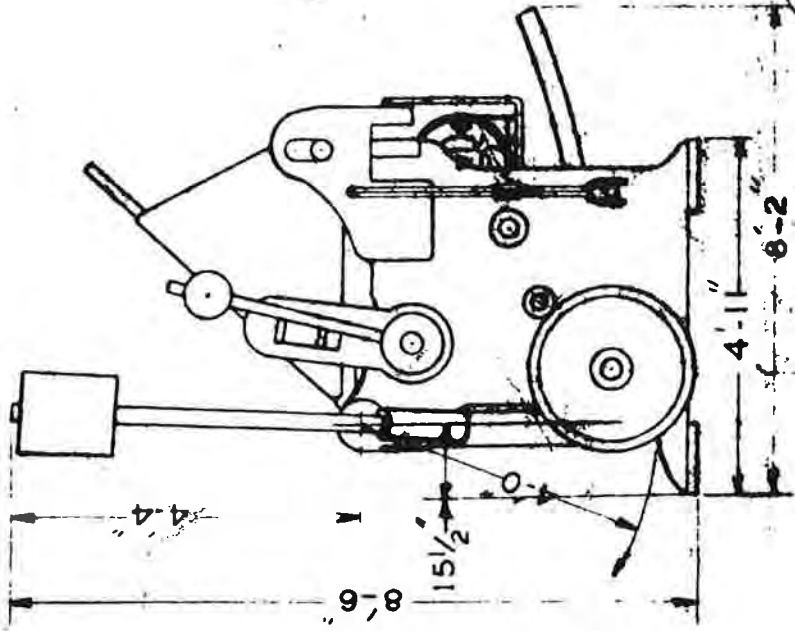
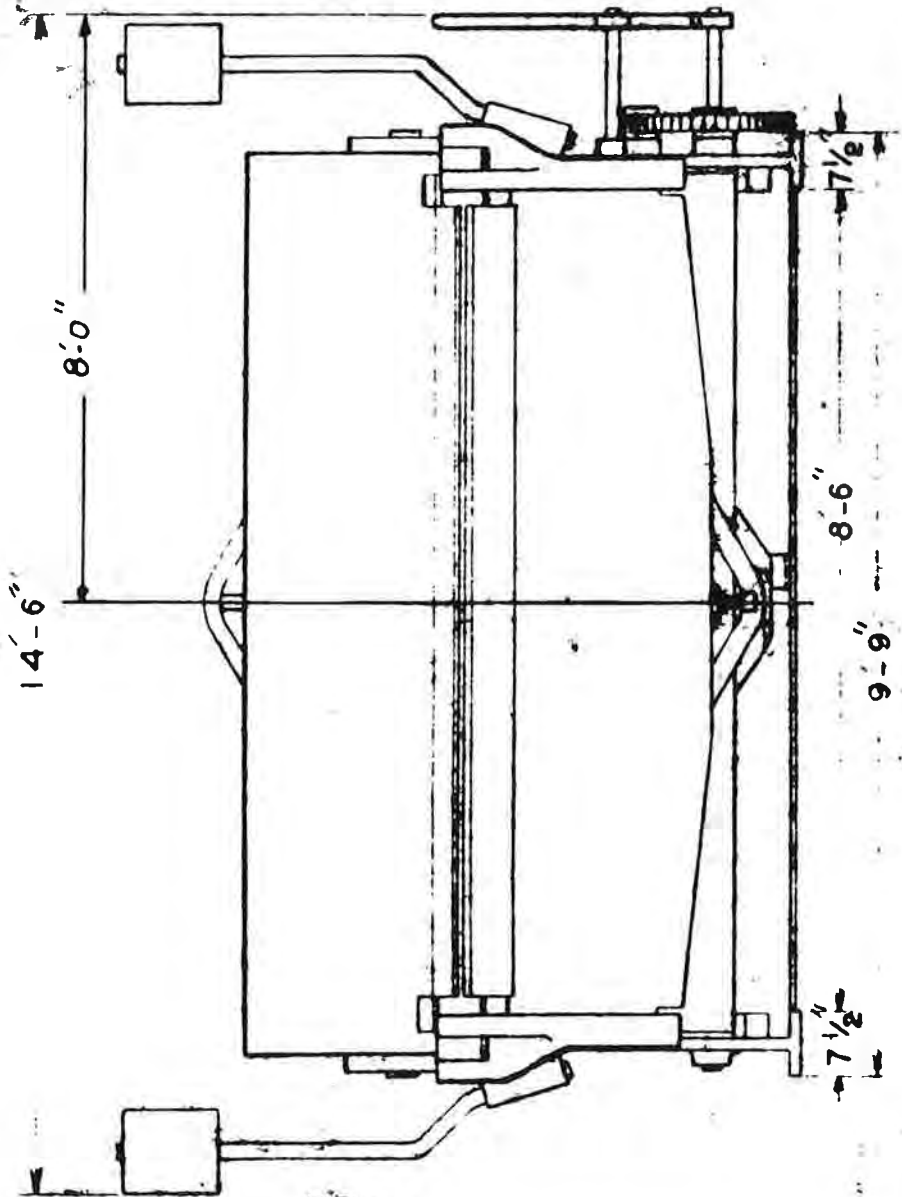
Bending Line I 1" Holes

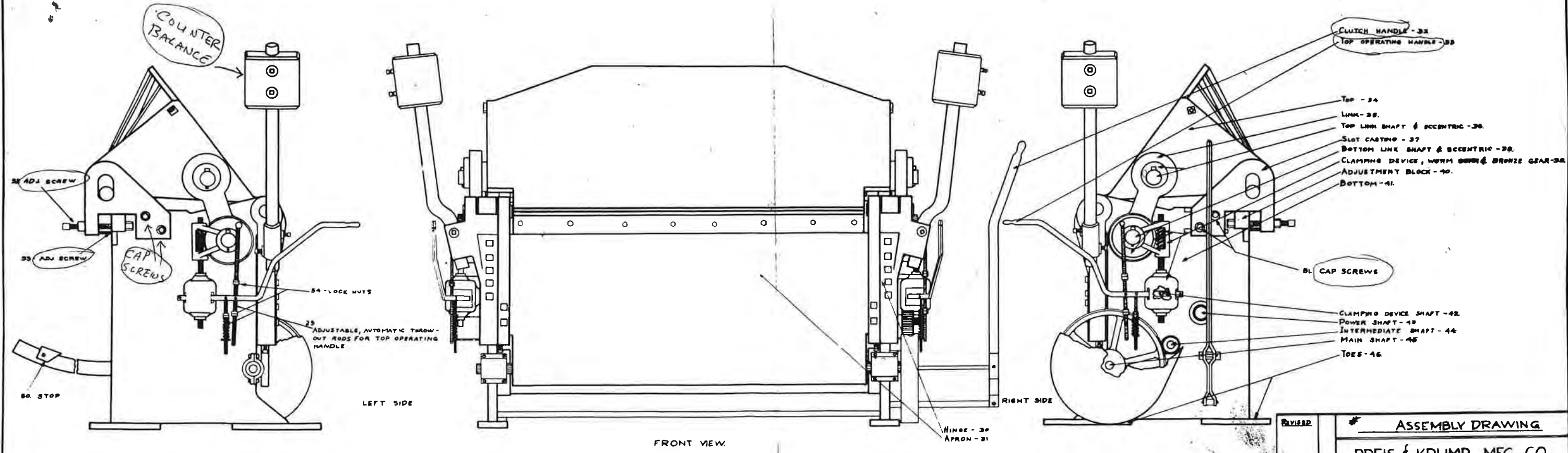
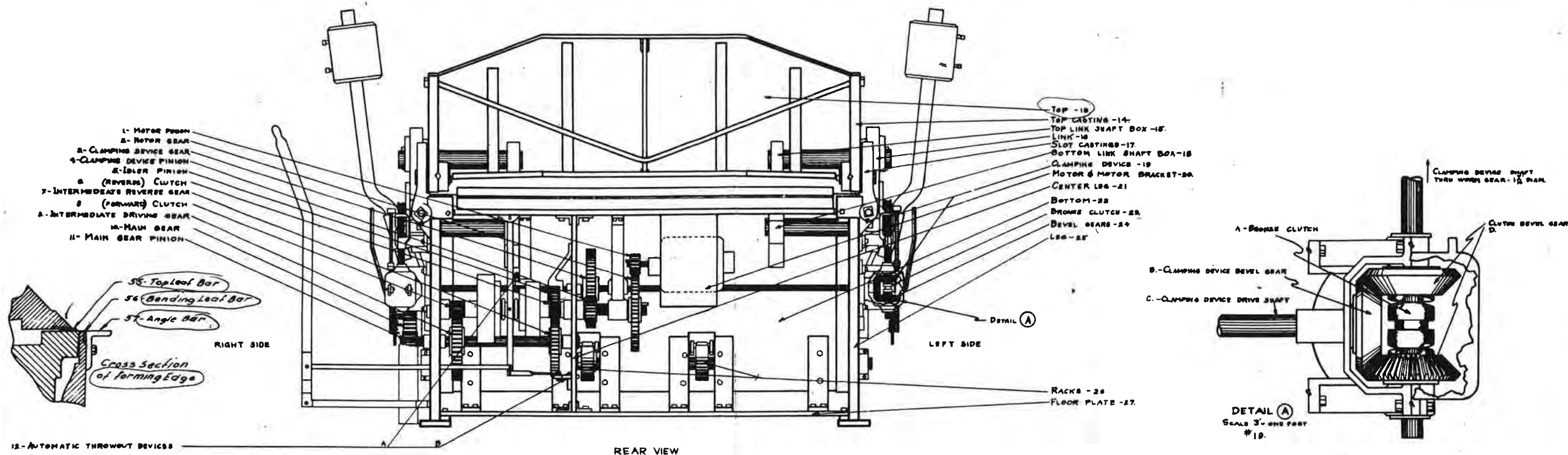
3/4 Bolts

8'-8 1/2" 9'-7"



11 1/2"





NOTE: WHEN ORDERING PARTS PLEASE REFER TO THIS DRAWING, # PB-209-1

REVISED	# ASSEMBLY DRAWING	
	DREIS & KRUMP MFG. CO.	
DATE: JUNE 11, 1941	SCALE: 3/4 - ONE FOOT	
DRAWN BY: W.H. GALL	DRAWING NO.	
CHECKED BY:	PB-209-1	
APPROVED BY:		