



MODEL T10052 14" PORTABLE BENCHTOP BRAKE INSTRUCTIONS

!WARNING

1. Overloading this tool can cause injury from flying parts. Do not exceed the machine capacities.
2. Secure bench hand brake to a sturdy surface before using. Tipping may occur during use and the machine could fall, causing injury or property damage.
4. Always chamfer and de-burr sharp sheet metal edges before bending. Sharp edges on sheet metal can result in severe cuts.
5. NEVER place your hands between the dies and bending fingers.
6. Always wear leather gloves and approved safety glasses when using this machine.
7. Inspect the bench hand brake for any cracked components or loose fasteners. Correct any problems before use. Loose hardware or cracks could result in sudden, unexpected movements during use.
8. If at any time you are experiencing difficulties performing the intended operation, STOP using the tool and contact our Technical Support at (570) 546-9663, or ask a qualified expert how the operation should be performed.



Figure 1. Model T10052.

Specifications

Maximum Bending Width	14"
Maximum Workpiece Thickness	22 Ga.
Maximum Bending Angle	180°
Weight	49 lbs.

!WARNING

Damage to your eyes and hands could result from using this machine without proper protective gear. Always wear safety glasses and heavy gloves when operating this machine.



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

Inventory (Figure 2)

- A. Benchtop Brake..... 1
- B. Handle 1

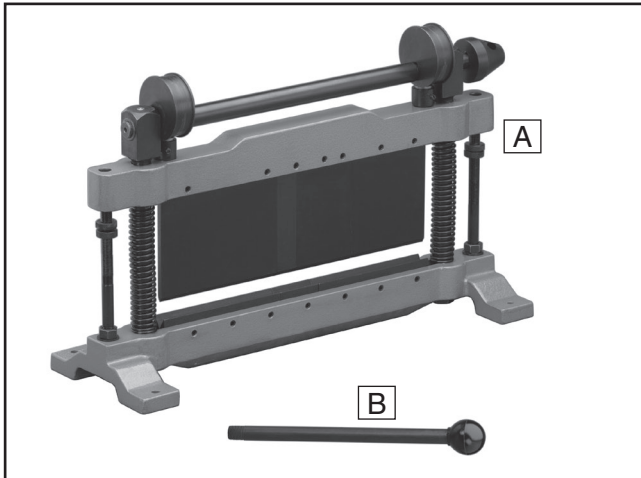


Figure 2. Inventory.

Assembly

1. Attach the handle to the machine by threading it into the hole at the end of the spindle (see Figure 1).

NOTICE

If you have never used this type of machine or equipment before, we strongly recommend that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Mounting

Once you have assembled your machine, you must mount it to a stable working surface through the holes in the base.

CAUTION

Personal injury and property damage could occur as a result of this brake tipping during use. Mount the machine to a suitable surface before use to prevent tipping.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the bench hand brake to the workbench.

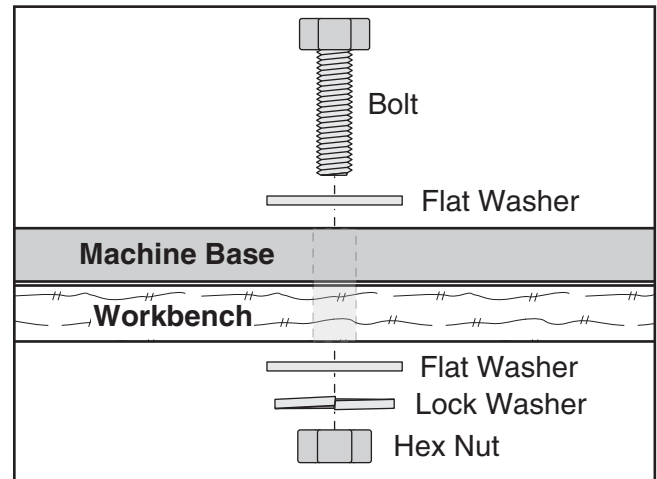


Figure 3. Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw.

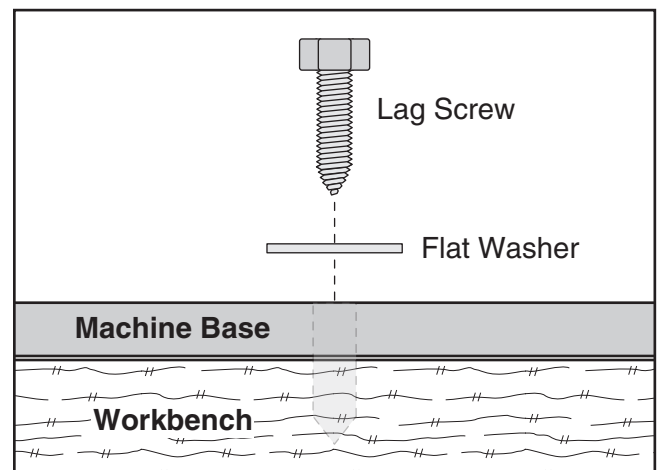


Figure 4. Example of a direct mount setup.



Basic Operations

1. Mark your workpiece along the line that you want to bend.
2. Place the workpiece between the fingers and dies and pull the handle down until the fingers just contact the workpiece. Align the mark you made in **Step 1** with the tip of the fingers (**Figure 5**).

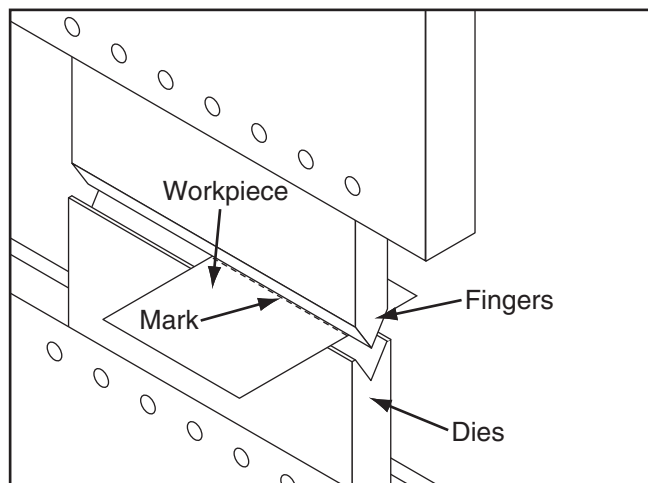


Figure 5. Aligning workpiece.

3. Pull the handle down until the desired bend is created (**Figure 6**).

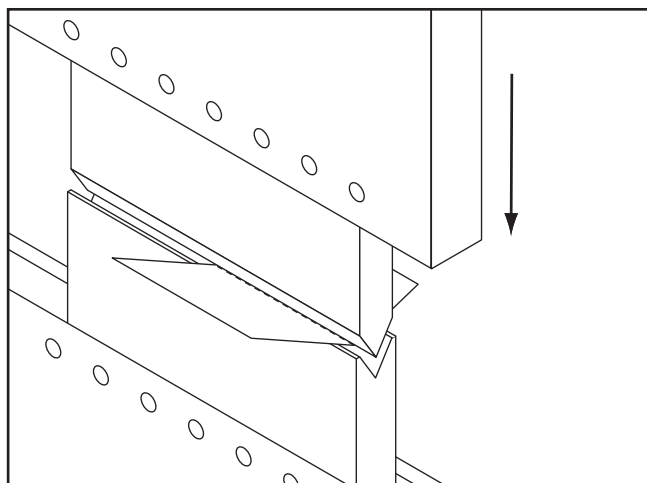


Figure 6. Creating the bend.

4. Use a protractor or similar device to check that the bend meets your requirements.
5. Repeat **Steps 2–4** as necessary until the bend is satisfactory.

Work Stops

The Model T10052 is equipped with work stops that allow you to create identical bends in multiple workpieces.

To use the work stops:

1. Follow the **Basic Operations** on **this page** to create the desired bend. Before releasing the handle, turn the work stops until they are against the sliding body of the machine. Make sure the work stops on each side of the machine are adjusted equally (**Figure 7**).

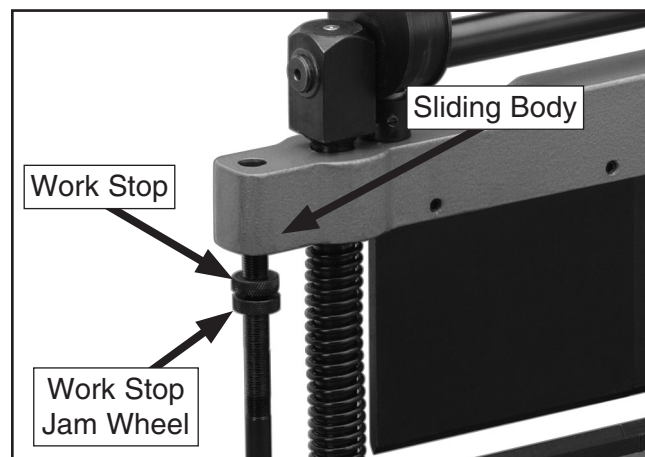


Figure 7. Work stops (left side shown).

2. Release the handle and remove the workpiece.
3. With a scrap piece the same material and dimensions as your workpiece loaded into the brake, lower the handle until the sliding body contacts the work stops.
4. Remove the workpiece and check the measurement of the angle.

—If the angle is satisfactory, no further adjustments are needed.

—If the angle is not satisfactory, continue to **Step 5**.
5. Fine-tune the position of the work stops, then repeat **Steps 3–4**.
6. When you are content with the positioning of the work stops, hand-tighten the work stop jam wheels against the work stops to lock them in position.



Creating Bends Greater than 135°

The greatest angle that the Model T10052 can produce in a single bend is approximately 135°. To create angles greater than this, a second step must be performed.

To create an angle greater than 135°:

1. Follow **Steps 1–2** from **Basic Operations** on **Page 3** to align the workpiece in the brake.
2. Pull the handle all the way down to create the maximum bend, then return the handle and remove the workpiece.
3. Place the workpiece as shown in **Figure 8**.

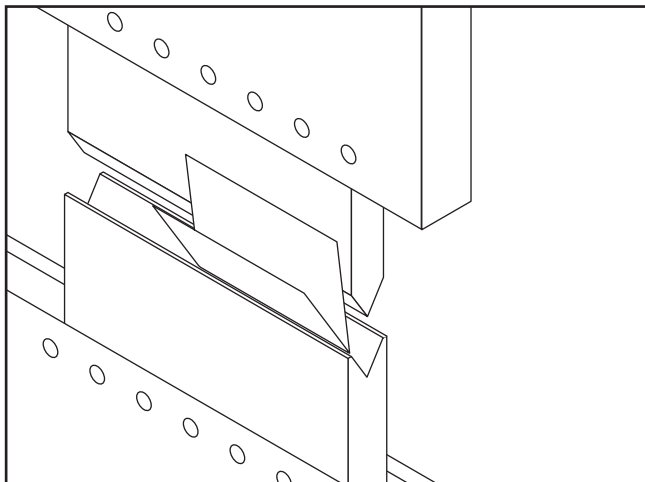


Figure 8. Positioning for bends over 135°.

4. Pull the handle down until the desired bend is created
5. Use a protractor or similar device to check that the bend meets your requirements.
6. Repeat **Steps 3–5** as necessary.

Finger & Die Removal

For pan & box style bends, you will need to remove one or more of the fingers or dies to avoid bending certain areas of the workpiece.

To remove the fingers and dies:

1. Remove any workpieces from the brake.
2. Determine which fingers and dies must be removed to accomplish the desired bend. See **Figure 9** for an overview of how to create pan & box style bends to help you determine which fingers and dies must be removed for your particular operation.

Note: Any areas to be bent must be fully supported by the dies and the fingers must press into the entire crease. Failure to properly position the fingers and dies will produce poor results.

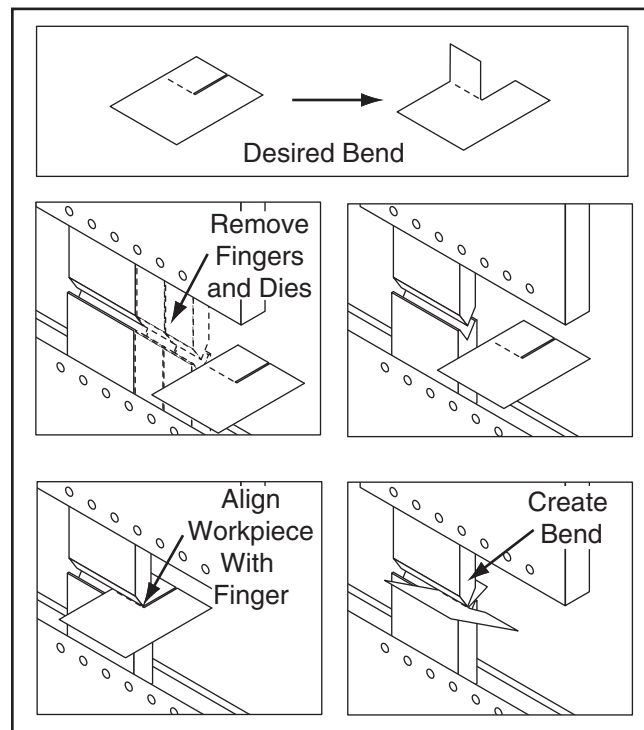


Figure 9. Pan & box bending.



3. Loosen the set screw(s) that hold the fingers and dies you wish to remove (**Figure 10**).

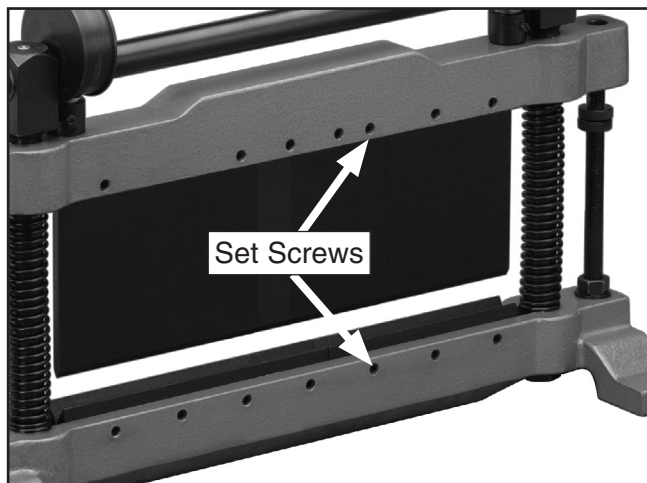


Figure 10. Set screw locations.

4. Remove the appropriate fingers and dies.
5. Refer to **Basic Operations** on **Page 3** and **Figure 9** to perform the pan & box style bend.

Cleaning

Cleaning the Model T10052 is relatively easy. Periodically wipe down the machine to remove dust and oil. Treat all unpainted surfaces with a non-staining lubricant after cleaning.

Lubrication (Figure 11)

Lubricating the Model T10052 consists of applying lubricant to the columns, cams, and ball oilers.

To lubricate the model T10052:

1. Pull the handle down to expose the top portion of the columns, then apply several drops of SAE 30 or equivalent oil to the column. Raise and lower the handle several times to disperse the oil.
2. Wipe any grime from the cam lobes, then brush on a very thin coat of multipurpose grease. Again, raise and lower the handle several times to disperse the grease.
3. Wipe down the top of the ball oilers, then use the tip of an oil can to depress the ball and apply 3-4 drops of SAE 30 or equivalent oil. Raise and lower the handle several times to disperse the oil.

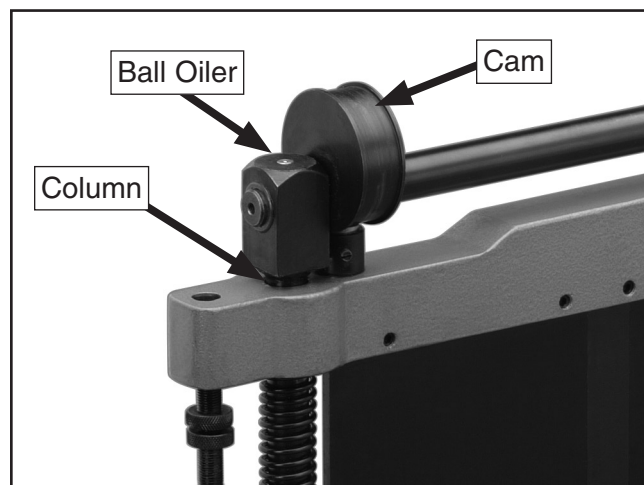
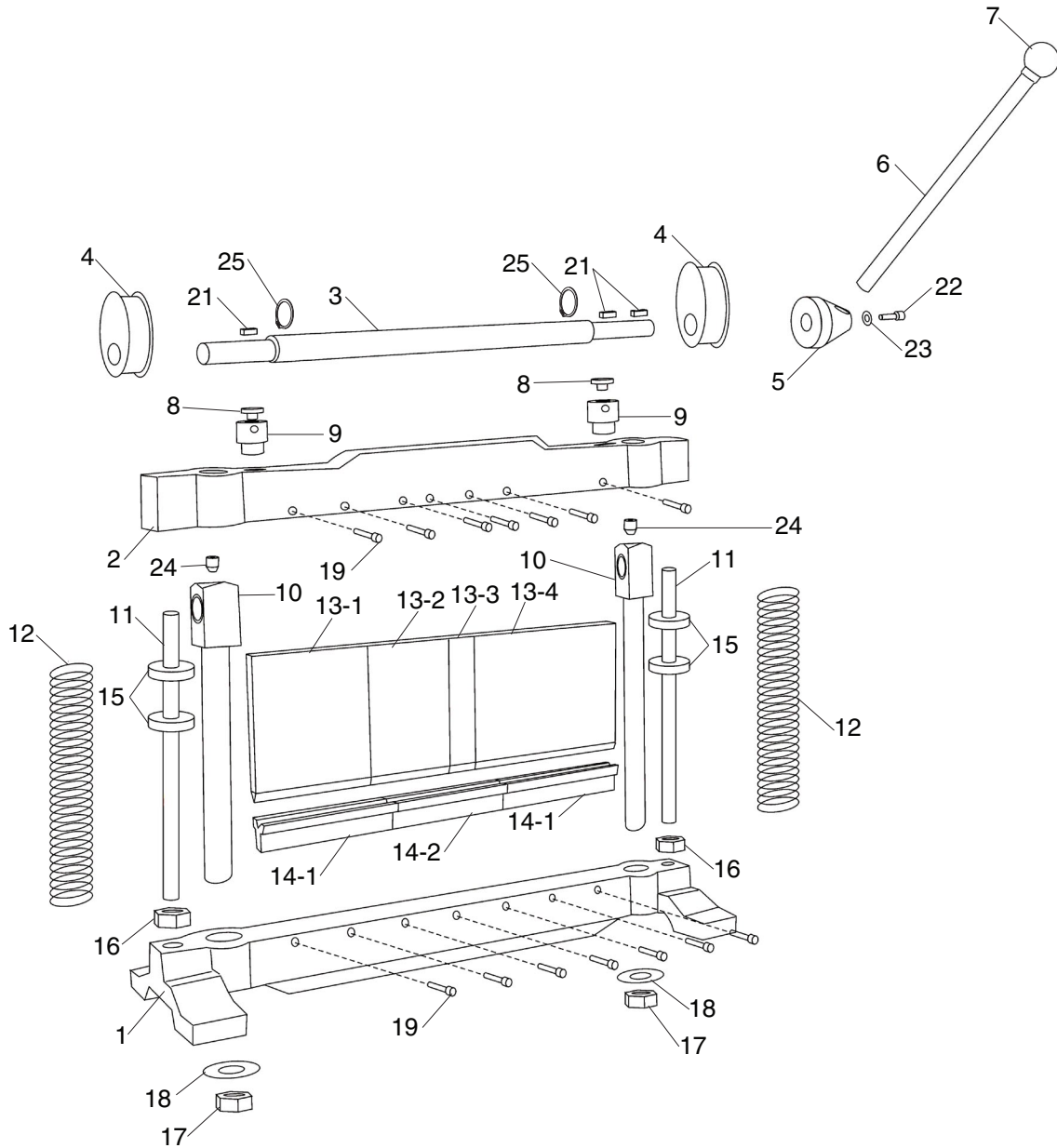


Figure 11. Lubrication locations (left side shown).



T10052 Parts Breakdown and List

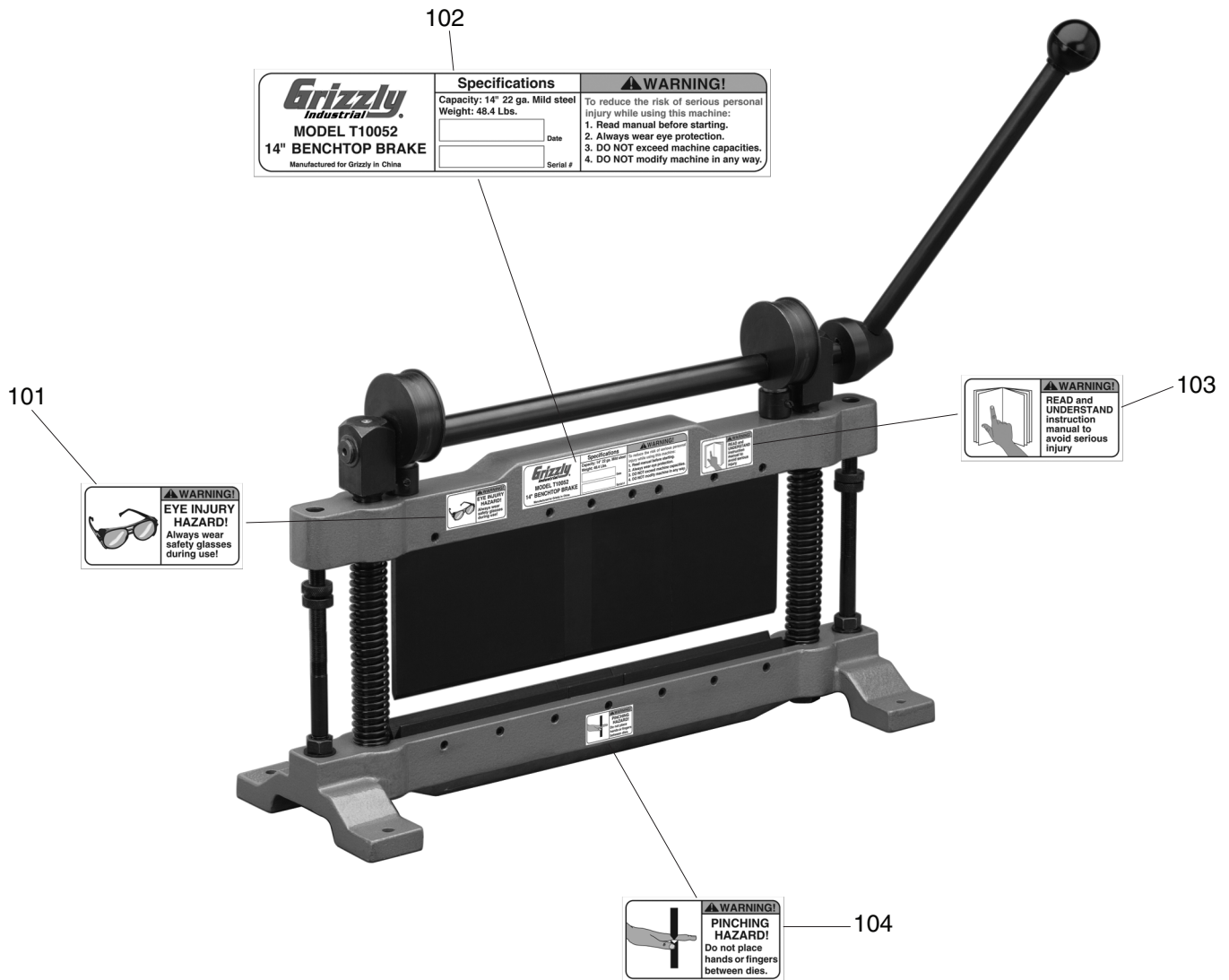


REF	PART #	DESCRIPTION
1	PT10052001	BASE
2	PT10052002	TOP BRACKET
3	PT10052003	SPINDLE
4	PT10052004	CAM
5	PT10052005	HANDLE BASE
6	PT10052006	HANDLE
7	PT10052007	KNOB
8	PT10052008	BUSHING
9	PT10052009	BUSHING HOLDER
10	PT10052010	COLUMN
11	PT10052011	STOP BOLT
12	PT10052012	COMPRESSION SPRING
13-1	PT10052013-1	FINGER 4"
13-2	PT10052013-2	FINGER 3"

REF	PART #	DESCRIPTION
13-3	PT10052013-3	FINGER 1"
13-4	PT10052013-4	FINGER 6"
14-1	PT10052014-1	DIE 6"
14-2	PT10052014-2	DIE 2"
15	PT10052015	KNURLED STOP NUT
16	PN09M	HEX NUT M12-1.75
17	PN13M	HEX NUT M16-2
18	PW08M	FLAT WASHER 16MM
19	PSS14M	SET SCREW M8-1.25 X 12
21	PK139M	KEY 6 X 6 X 22
22	PSB04M	CAP SCREW M6-1 X 10
23	PT10052023	SPACER
24	PT10052024	BALL OILER
25	PR07M	EXT RETAINING RING 18MM



T10052 Labels Breakdown and List



REF	PART #	DESCRIPTION
101	PT10052101	EYE INJURY LABEL
102	PT10052102	MACHINE ID LABEL

REF	PART #	DESCRIPTION
103	PT10052103	READ MANUAL LABEL
104	PT10052104	PINCHING HAZARD LABEL

WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.



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