

Connecticut

MODEL U416 HEAVY DUTY BENCH BRAKE



SPECIFICATIONS

Length of bed	48 1/4"
Capacity on mild steel, 1" flange:	
With bending bar and angle in place	16 ga.
With bending angle removed	20 ga.
With bending bar and angle removed	23 ga.
Minimum reverse bend (bar and angle removed)	1/4"
Maximum lift of beam	1 1/4"
Finger widths	2", 3", 4"
Maximum depth of box	4"
Front to rear adjustment of beam	5/8"
Shipping weight (without bench)	495 lbs.
Packing	Heavy carton on skids
Bench (same used for light duty models)	Optional
Bench size	56" long, 18" wide, 26" High
Bench shipping weight (knocked down in carton)	100 lbs.



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MODEL U416 CONNECTICUT BENCH BRAKE

INSTRUCTIONS

Level the Brake and bench, and shim under the feet to avoid distortion. Fasten firmly in place. The front feet must be well fastened to avoid tipping when bending force is applied to the handles.

The Model U416 is rated for bending 48" of 16 gage mild steel, one inch flange, with bending angle and bending bar fastened securely in place. The beam (upper clamping member which carries the fingers), may be adjusted to the rear a maximum of 5/8". When adjusting to bend 16 gage material, swing the apron up to 90 degrees and set the beam adjustment to allow a clearance of 1/8" between the apron edge and the finger tips. For lighter material, a clearance of 1 1/2 to 2 times material thickness should be used. Soft aluminum may be formed with clearance equal to material thickness.

Rated capacity for stainless steel is 20 gage. Clearance should be at least twice material thickness.

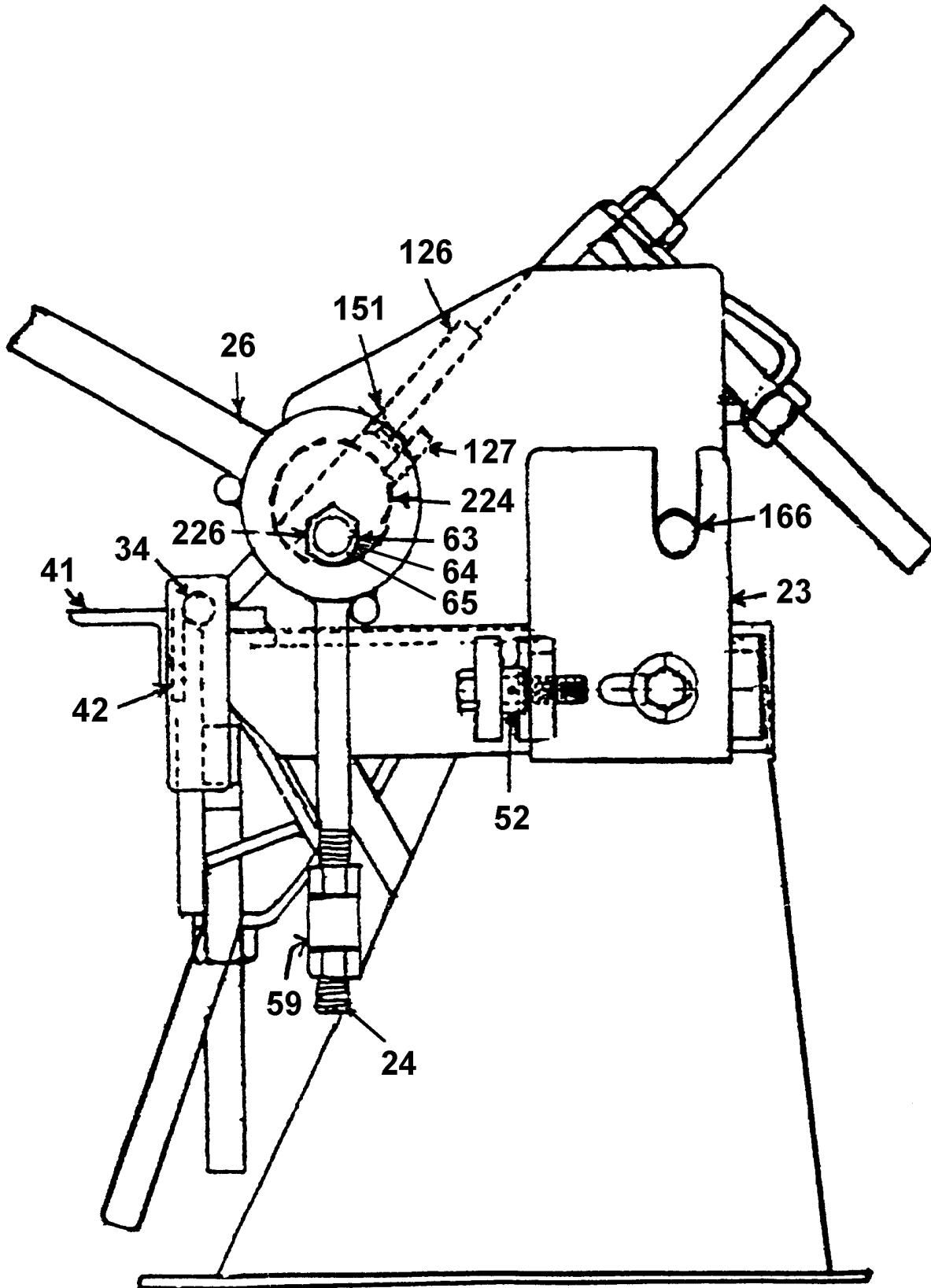
Removing the bending angle, for narrow or offset bends, reduces capacity to 20 gage mild steel. Removing both bending angle and bending bar reduces capacity to 22 gage. Avoid using the Brake without the bending bar as much as possible as the bar is made of a tough material to protect the apron edge from wear.

Clamping pressure is controlled by nuts on the lower end of the toggle bolt. This pressure should be adjusted with a small piece of material to be bent clamped in each end of the machine. Move the nuts so that the levers No. 26 pull against the stops with an equal effort. Excessive clamping pressure is not required. Use only enough to hold the material firmly in the Brake.

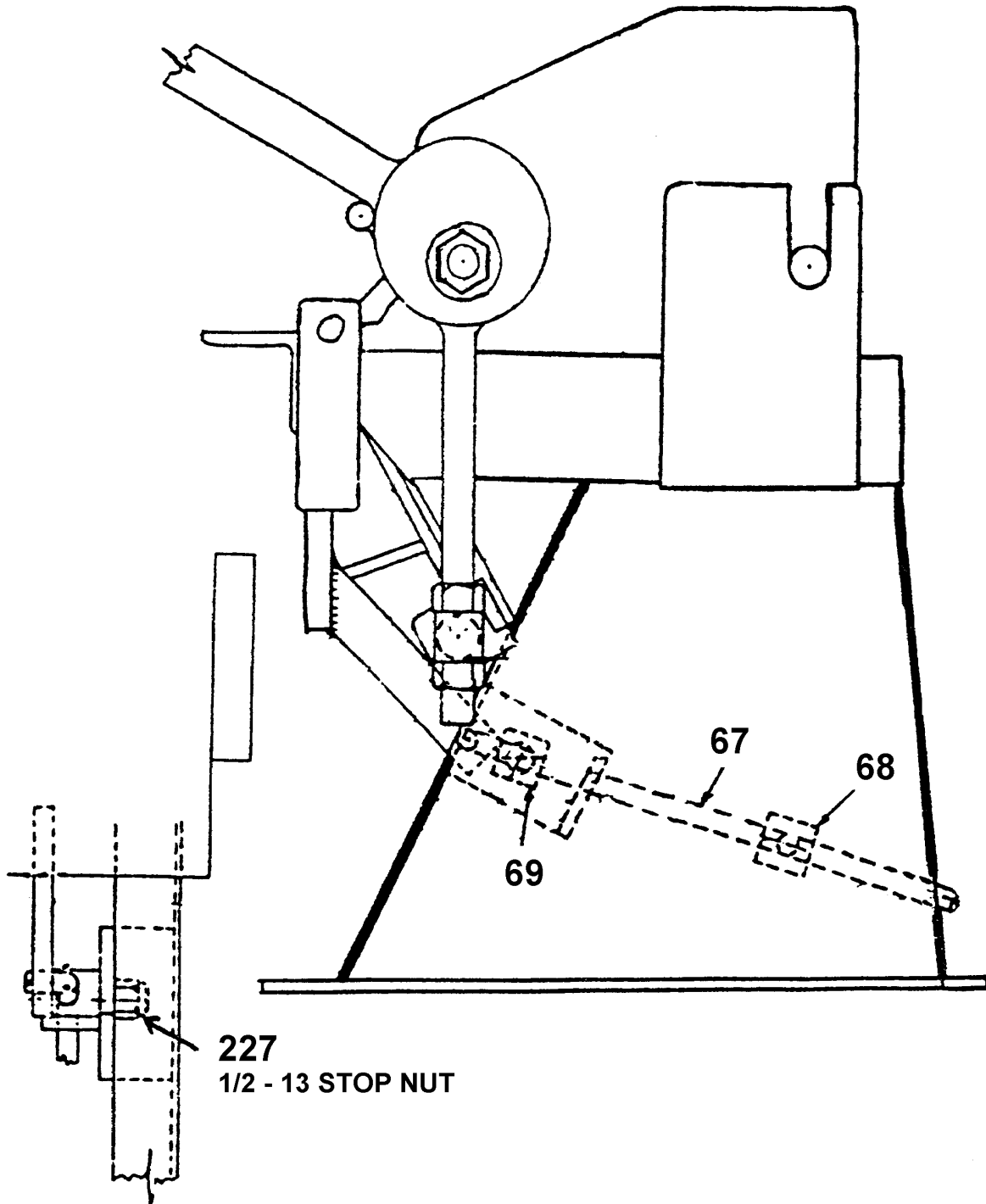
These Brakes are not intended for bending rod, wires, multiple thicknesses or across lock seams. Operations of this type will result in denting the edge of the apron and fingers and springing the machine out of line.

Lubricate the moving parts of the machine with light grease or heavy oil. Lasting accuracy depends on proper lubrication.

MODEL U416 CONNECTICUT BENCH BRAKE
PARTS IDENTIFICATION CHART



MODEL U416 CONNECTICUT BENCH BRAKE
APRON STOP ASSEMBLY
PARTS IDENTIFICATION CHART



**MODEL U416 CONNECTICUT BENCH BRAKE
PARTS IDENTIFICATION LIST**

ITEM NO.	PART NO.	PART NAME
23	757730045	R. H. Slide
23	757730046	L. H. Slide
24	757860048	R. H. Toggle Assembly
24	757860048	L. H. Toggle Assembly
26	757030054	R. H. Eccentric Assembly
26	757030055	L. H. Eccentric Assembly
26G	633356335	Handle Grip (not shown)
34	757160083	Hinge Pin
41	757180069	Bending Angle
42	757030070	Bending Bar
47	757460061	Extension Handle (not shown)
52	657000282	Adjusting Screw & Collar
59	757160071	Lower Toggle Pin
63	657000389	Clamping Collar
64	657245117	Thrust Bearing
65	679033110	Lock Washer
67	757130068	Apron Stop Rod
68	757260072	Apron Stop Collar
69	757160073	Apron Stop Stud
132	757280057	Counterweight (not shown)
151	613012135	Finger Screw
166	757080058	Slide Pin Bushing
224	757080049	Toggle Bushing
226	757080040	Eccentric Bushing
227	666023007	Elastic Stop Nut
126	255940014	2" Finger Assembly
	255940015	3" Finger Assembly
	255940016	4" Finger Assembly
127	757010137	1 1/2" Finger Clamp
	757010138	2 1/2" Finger Clamp
	757010139	3 1/2" Finger Clamp