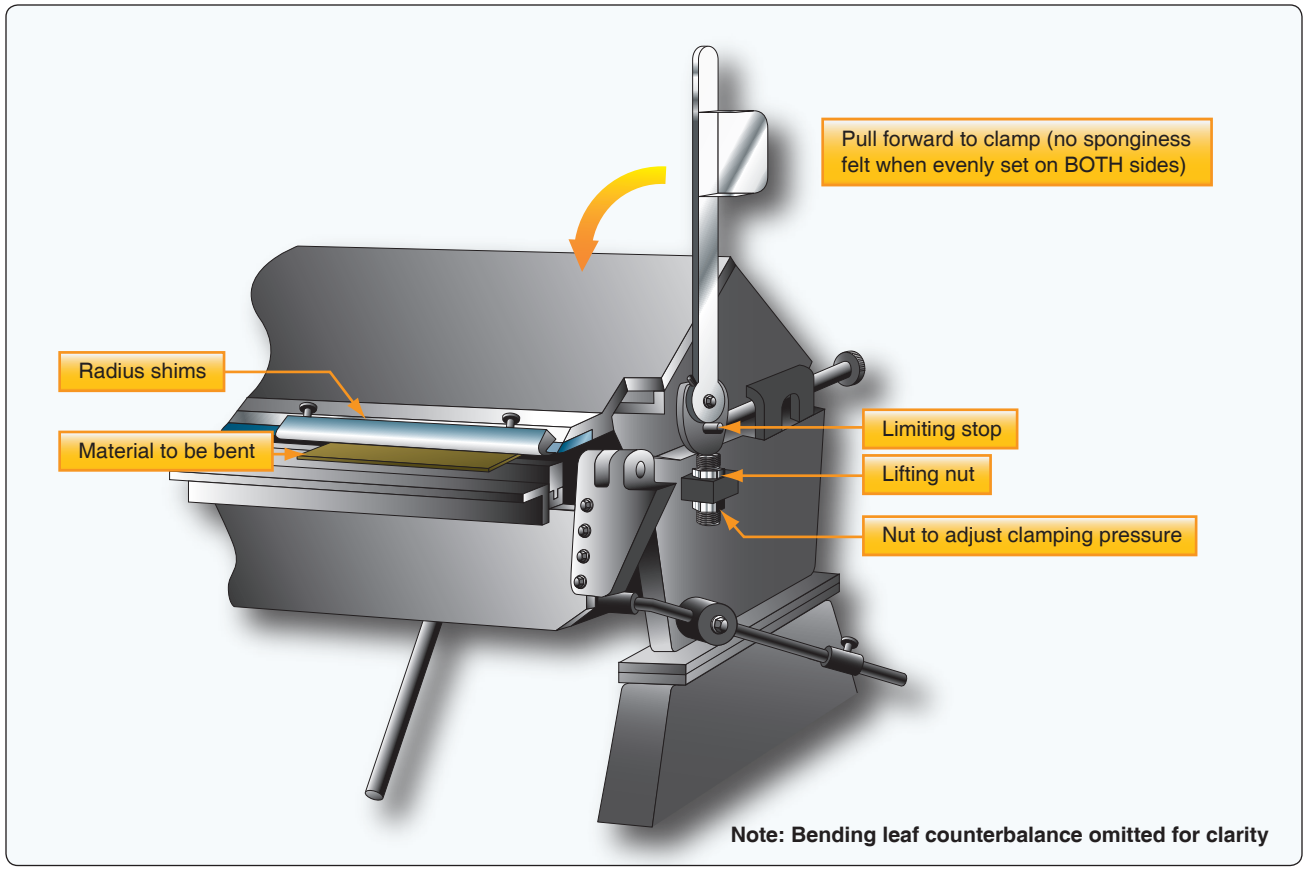

Figure 4-138. *General brake overview including radius shims.*

Step 3: Adjusting the Nose Gap

Adjust the nose gap by turning the large brake nose gap adjustment knobs at the rear of the upper jaw to achieve its proper alignment. *[Figure 4-140]* The perfect setting is obtained when the bending leaf is held up to the angle of the finished bend and there is one material thickness between the bending leaf and the nose radius piece. Using a piece of material the thickness of the part to be bent as a feeler gauge can help achieve a high degree of accuracy. *[Figures 4-140* and *4-141]* It is essential this nose gap be perfect, even across the length of the part to be bent. Check by clamping two test strips between the bed and the clamp 3 inches from each end of the brake. *[Figure 4-142]* Bend 90° *[Figure 4-143]*, remove test strips, and place one on top of

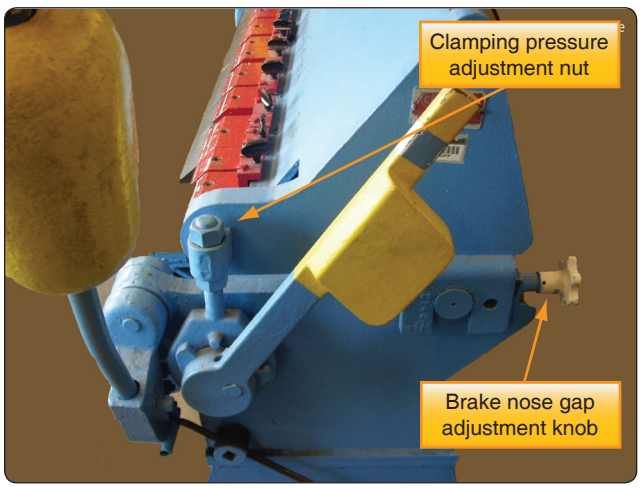

Figure 4-139. *Adjust clamping pressure with the clamping pressure nut.*

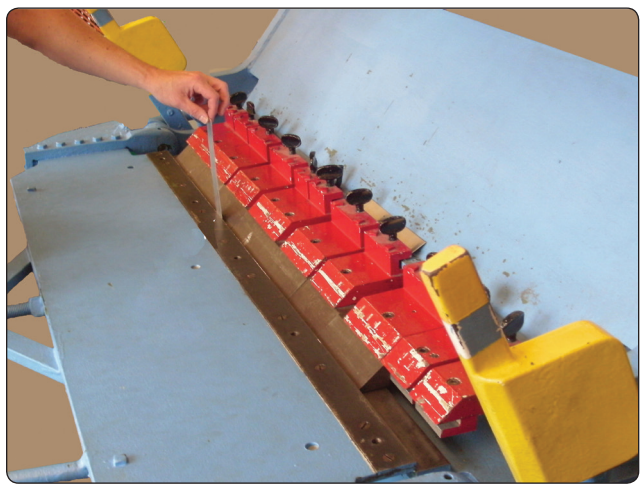

Figure 4-140. *Brake nose gap adjustment with piece of material same thickness as part to be formed.*