

CAED Support Shop
Sheet Metal Brakes

•Review dress code

- Safety Glasses must be worn at ALL times in the Shop.
- Remind students that long hair must be tied back, loose clothing and/or jewelry must be removed
- Remind students that the EDGES of sheet metal may be VERY sharp.

•Intro/Strengths

- Good for bending angles between 0 and approx. 80 degrees max.
- 12 gauge max. material thickness
- Straight Brake (new Baileigh) and Box and Pan Brake (old blue)
 - Difference is the removable/adjustable fingers that allow for the forming of boxes and pans

•Operation

- Do not stack multiple sheets on top of one another.
- Demonstrate opening clamping area by pushing back vertical levers on sides of tool
 - One or both, depending on material size
 - Demonstrate material thickness adjustment on Finger break.
- Raise back up the levers to tighten down on your bend line
- Demonstrate pushing on upright lever/counterweight arm to make your bend
- Take into account for the elastic properties of metal ie: slight material "spring back"
- Show stop beneath machine to make repeatable bends
- Remind and demonstrate: consider geometry when designing.
 - Take into account that work piece may hit or exceed physical limitations of tool.

-Field any questions and students make one simple bend.

•Remind students to clean up after themselves.

- Clean up ALL materials and scraps from tables and floor.
- Show them where the metal recycling, brooms, etc. are located and what our expectations for clean-up are.

REMEMBER- We are here to help. If you have any questions, ask!