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!**