

Using the Brake Stop

The brake stop is an accessory to extend the utility of inexpensive shear / brake machines.

Features:

1. provides a square
2. provides a back stop or front stop which can be changed to right or left configuration.
3. provides a down stop to limit the down stroke thereby limiting the bend angle.

Installation on your brake.



The manual press brakes available at grizzly and many other vendors incorporate a die with a female v shape and punches with a male v shape. The Brake Stop works with units that have removable punch sections. The picture shows a large section removed to illustrate the back stop and basic installation. Normally a smaller section would be removed and it would be located close to the section on where the bending is to be done. The Brake Stop will accommodate up to .787 (20mm) die width. My die happens to measure .750.

The blocks on the bottom take up about .562 inches of travel, so it may need to be removed to use the shear.



The back stop can be adjusted when the bar is in place, but it is frequently more convenient to do that while the Brake Stop is removed from the die. Measure the from the front face of the back block to the stop block. Be sure to account for $\frac{1}{2}$ of the die width in your measurements. The stop block can be set right to the edge of the die. The front bottom block is the same width as the bar, and the back bottom block is extended .187" to facilitate using a caliper or scale. Using a .750" die, $\frac{1}{2}$ of .75 is .375, so in the illustration the center of the bend would be set at 1.375. When the back stop is set, tighten the 6mm screw on the opposite side with a 5mm hex key.

Fit the Brake stop over the die. Push down so that the bottom of the bar rests evenly on the front and the back of the die.

Snug up the attachment screw on the front bottom.

Check the squareness of the bar to die and tighten the attach screw with a 5mm hex key.

Set the down stop as desired to limit the angle of the bend. If a different length of bolt is required, replace it with a $\frac{3}{8}$ x 16tpi thread bolt.