

OPERATOR'S MANUAL & INSTRUCTIONS

[®]
Di-Acro

NUMBER 24 & 36 Di-Acro Finger Brakes



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CAUTION

TO PREVENT SERIOUS BODILY INJURY
AND DAMAGE TO THE MACHINE

BOLT THE MACHINE TO THE STAND
AND THE STAND TO THE FLOOR

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OPERATING

Operating characteristics of the Model 24, and 36 Di-Acro leaf type brakes are identical, the only difference being the additional forming width. Before brake is set up for operation, mount on work bench or stand* with brake base flush with the edge, and bolt in place. Position handle arms to one of three locations provided on the handle holders for most convenient operation. Insert back gauge rods in holes in rear of casting and secure in position with screws in front of casting behind the folding blade (see Micrometer Back Gauge instructions on inside page).

*IF BRAKE IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR.

ANGLE ADJUST

To adjust Brake for bending clearance, raise folding blade 90 degrees, insert material between edges of folding blade and leading edge of fingers (for heavy material, clearance should be twice the thickness, less for lighter gauge or if sharper bend is desired). Adjust finger mount bar by turning finger mount bar adjustment screws. To adjust clamping pressure,

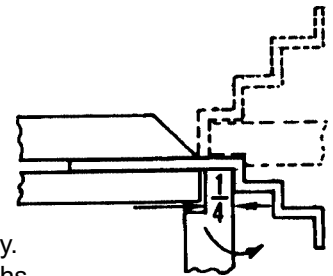
insert material under fingers and turn material adjustment screws until material is held securely when fingers are lowered. To adjust degree of bend, set angle stops located on both ends of folding blade for desired degree of bend.

REVERSE BENDS

Remove five angle support bar bolts and support bar and adjust Brake as above.

NOTE: 16 GAUGE CAPACITY (with support bar in place)

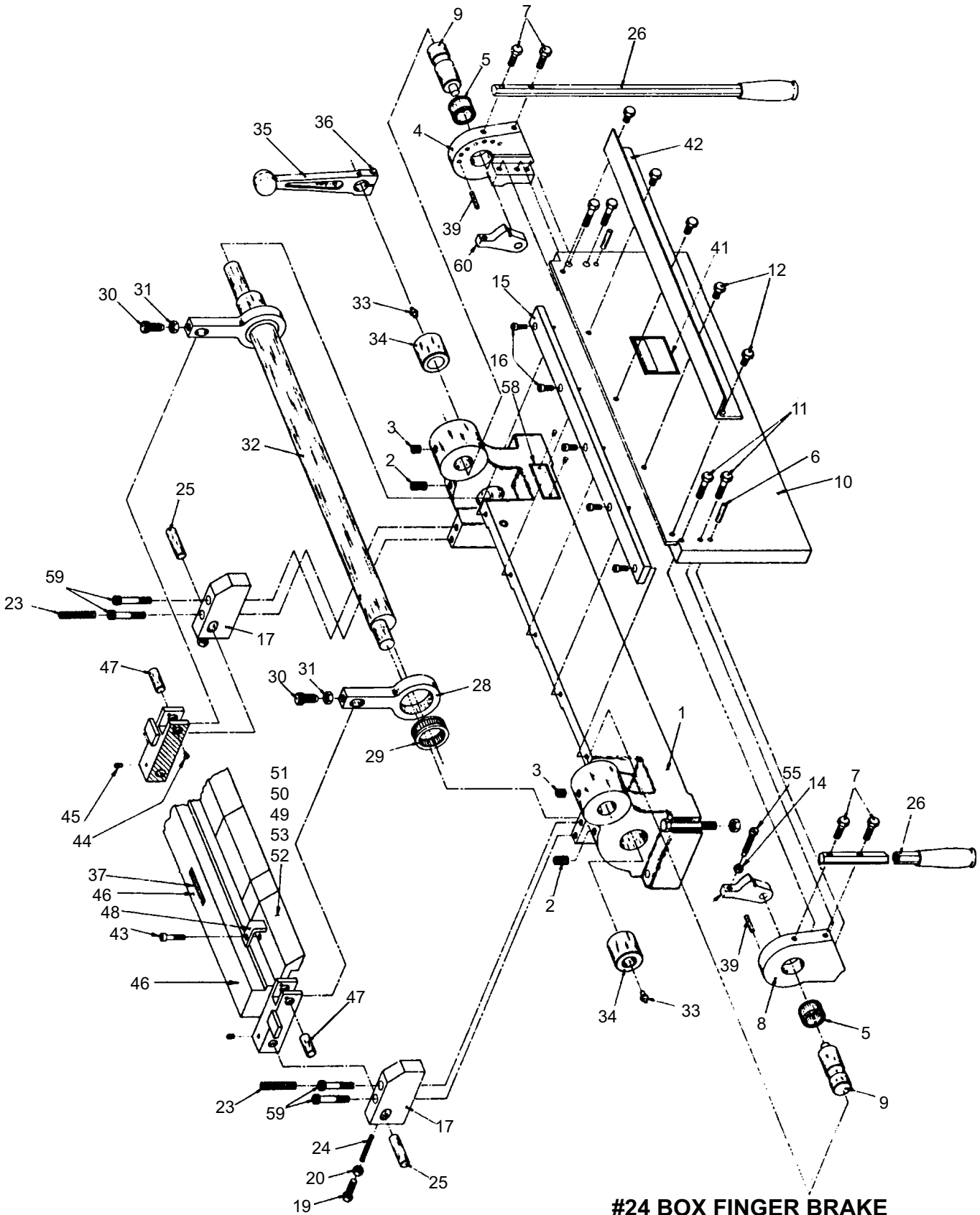
MINIMUM LENGTH OF BEND WHEN FORMING A REVERSE BEND = 1/4"



NOTE: Di-Acro Brakes are rated for 1" minimum flange when bending full capacity. Caution should be used if necessary to bend heavier gauge material in short widths.

SPECIFICATIONS -- FINGER BRAKES

Model	No. 24		No. 36	
	in.	mm	in.	mm
Max. Capacity, Mild Steel	16 ga.	1.5	16 ga.	1.5
Max. Forming Width	24	609.6	34	914.4
Clearance thru Top Opening	1	25.4	1	25.4
Max. Depth of Box or Pan	3	76.2	3	76.2
Min. Reverse Bend	1/4	6.4	1/4	6.4
Max. Angle Bend (one operation)	135°		135°	
Max. Back Gauge Adjustment	24	609.6	24	609.6
Shipping Weight	325 lbs.	147 kg.	470 lbs.	123 kg
Stand, Shipping Weight	100 lbs.	45 kg.	140 lbs.	63 kg

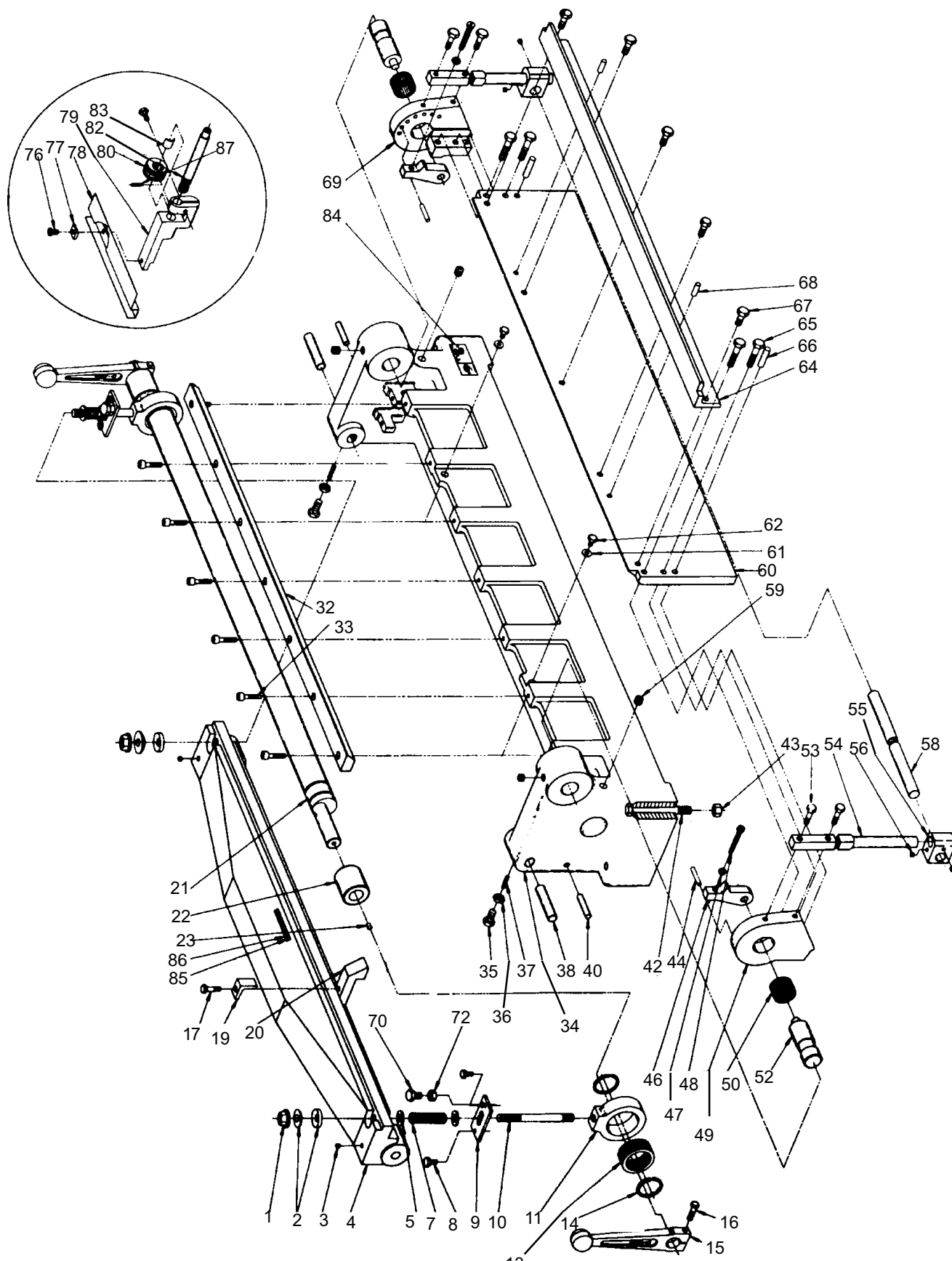


**#24 BOX FINGER BRAKE
ASSEMBLY - 8247820-080**



#24 Finger Brake

ITEM	DESCRIPTION	PART NUMBER	QTY
1	BASE	100	1
2	SCREW	23A0102C1000	2
3	SCREW	23A0102C0102	2
4	ARM R	8346122-000	1
5	NEEDLE BEARING	8310300-600	2
6	PIN	19A0308X1102	2
7	SCREW	21A0308C1104	4
8	ARM L	8400122-000	1
9	TRUNNION	8346120-300	2
10	FOLDING BAR	8064122-000	1
11	SCREW	21A0308C1102	4
12	SCREW	8211030-830	5
15	BOTTOM PLATE	8346110-400	1
16	SCREW	20A0516C1000	5
17	SIDE	8346110-311	2
19	SCREW	21A0308C1000	2
20	NUT	31X0102C	2
23	SPRING	8510211-600	2
24	SPRING	8060510-205	2
25	PIN	19A0508X2102	2
26	HANDLE ARM ASSEMBLY	8346120-871	2
28	CONNECTING ARM	8347120-101	2
29	NEEDLE BEARING	8310300-900	2
30	ADJUSTING SCREW	8346470-101	2
31	NUT	31X0102C	2
32	SHAFT	8346120-200	1
33	DRIVE FITTING	8690100-200	2
34	BEARING HOUSING	8346110-302	2
35	CLAMP HANDLE	8346120-812	1
36	SCREW	21A0516C1104	1
37	INSTRUCTION PLATE	8030650-310	1
39	PIN	19A0104X1104	2
41	CAUTION SIGN	8030650-300	1
42	FOLDING BAR SUPPORT	8146122-000	1
43	SCREW	21A0516C1102	12
44	SCREW	22D0104C0102	4
45	SCREW	23A0104C0308	2
46	FINGER MOUNT WELDMENT	8046110-204	1
47	CLAMP PIN	8346120-302	2
48	FINGER CLAMPS	8347110-203	12
49	FINGER STD 3/4"	8000122-203	2
50	FINGER STD 1"	8100122-203	2
51	FINGER STD 3"	8200122-203	2
52	FINGER STD 6"	8347122-204	2
53	FINGER STD 1-1/4"	8000122-204	2
55	ARM ADJUSTMENT BOLT	8251470-101	2
58	NAME PLATE	8150650-110	1
59	SCREW	20A0516C1104	4
60	FOLDING BAR STOP	8500122-000	2
8346110-			



**#36 BOX FINGER BRAKE
ASSEMBLY - 8347820-080**



#36 Finger Brake

ITEM	DESCRIPTION	PART NUMBER	QTY
1	NUT	30X0102C	2
2	WASHER SET	849050-100	2
3	SCREW	23A0104C0308	2
4	FINGER MOUNT	8348111-000	1
5	THRUST BEARING	8348310-700	4
7	SPRING	8348510-200	2
8	SCREW	22B0104C0102	4
9	SPRING BRACKET	8348140-700	2
10	STUD	8348121-100	2
11	CONNECTING ARM	8348121-200	2
13	NEEDLE BEARING	8310300-900	2
14	RETAINING RING	8470510-500	4
15	CLAMP HANDLE (2 OPTIONAL)	8346120-812	1
16	SCREW	21A0516C1304	1
17	SCREW	21A0516C1308	22
19	FINGER CLAMP	8347110-203	22
20	FINGER STD 3/4"	8000122-203	2
20	FINGER STD 1"	8100122-203	2
20	FINGER STD 1-1/4"	8000122-204	2
20	FINGER STD 3"	8200122-203	2
20	FINGER STD 6"	8347122-204	4
21	BRAKE SHAFT	8700122-000	1
22	BEARING HOUSING	8346110-302	2
23	DRIVE FITTING	8690100-200	2
32	BRAKE BOTTOM PLATE	8348110-400	1
33	SCREW	0010821-000	7
34	BASE	8348110-100	1
35	SCREW	21A0308C1304	2
36	NUT	31X0102C	2
37	SPRING	8060510-205	2
38	PIN	19A0508X3102	2
40	PIN	1203216	2
41	SOCKET HEAD CAP SCREW	0010804-000	8
42	HEX HEAD CAP SCREW	21A0102C4104	4
43	FULL NUT	30X0102C	4
44	DOWEL PIN	8203145-000	2



#36 Finger Brake

ITEM	DESCRIPTION	PART NUMBER	QTY
46	FOLDING BAR STOP	8500122-000	2
47	NUT	31X0516C	2
48	ARM ADJUSTING BOLT	8251470-101	2
49	ARM L	8400122-000	1
50	NEEDLE BEARING	8310300-600	2
52	TRUNNION	8346120-300	2
53	SCREW	21A0308C1304	4
54	HANDLE ARM	8346120-801	2
55	HANDLE BLOCK	8348131-000	2
56	SCREW	23XX10C0308	4
58	HANDLE CROSS BAR	8348131-200	1
59	SCREW	23A0102C0102	4
60	FOLDING BAR	8348122-000	1
61	WASHER	61X0104	2
62	SCREW	21A0104C0308	2
64	FOLDING BAR SUPPORT	8600122-600	1
65	SCREW	21A0308C1304	4
66	PIN	19A0308X1102	2
67	SCREW	21A0308C1000	5
68	PIN	19A0516X1000	2
69	ARM R	8346122-000	1
70	SCREW	21A0308F0304	2
72	NUT	30X0308F	2
76	SCREW	21A0104F0304	2
77	BLOCK	8346144-106	2
78	GAUGE	8348144-100	1
79	QUICK-SET BRACKET	8346144-103	2
80	QUICK-SET DIAL NUT	8210143-104	2
82	QUICK-SET ROD	8046144-103	2
83	QUICK-SET DIAL SHOE	8000143-104	2
84	NAME PLATE	8000140-104	1
86	INSTRUCTION PLATE	8030650-310	1
87	SPRING	8210510-204	2

MICROMETER BACK GAUGE

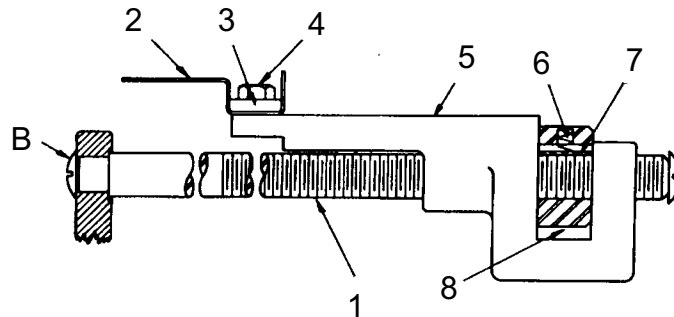
Micrometer back gauge should be zeroed when first installed. To install and zero gauge:

- A. Install gauge rods in holes located in rear of base casting.
- B. Hold micrometer dial on zero and screw rods in until material stop lines up with folding blade. Rods can be locked in place by tightening screws located behind folding blade.

To position micrometer back gauge rapidly, turn micrometer dials to zero, depress dial and slide complete back gauge assembly to desired position. For fine adjustment turn micrometer dials in regular manner.

Box Finger Brake Micrometer Back Gauge

Number 24 Assembly - 8346144-171
Number 36 Assembly - 8348144-170



Item No.	Part No. #24	Part No. #36	Description	Qty.
1	8046144-103	8046144-103	Quik-Set Rod	2
2	8346144-105	8348144-100	Gauge	1
3	8346144-106	8346144-106	Block	2
4	21A0104C0304	21A0104C0304	Screw	2
5	8346144-103	8346144-103	Quik-Set Bracket	2
6	8210510-204	8210510-204	Spring	2
7	8000143-104	8000143-104	Quik-Set Dial Shoe	2
8	8210143-104	8210143-104	Quik-Set Dial Nut	2