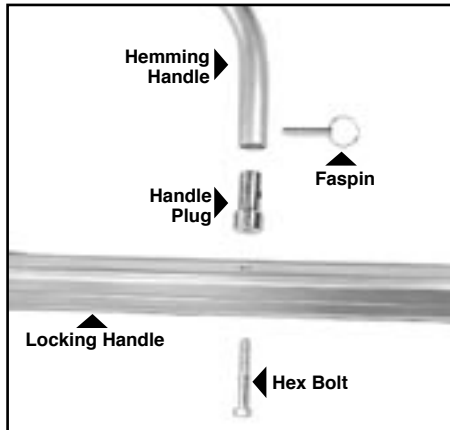# Setting Up Your PRO Brake

Hemming Handle Installation

The Hemming Handle Assembly includes: (1) Hemming Han-dle, (2) Handle Plugs, (2) Faspins, (2) Hex Bolts.

Insert Hex Bolt through Locking Handle of your Port-O-Bender and into base of Hemming Handle as indicated using the 3/8″ Hex Bolts provided. HAND TIGHTEN ONLY. Repeat for other side.
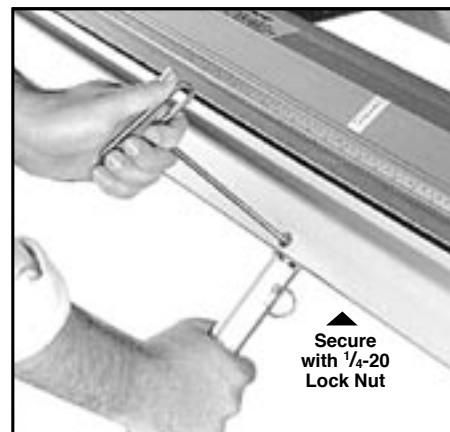
Attach the Hemming Handle over the Han-dle Plugs and secure them with Faspins. Now tighten the 3/8″ Hex Bolts with a 9/16″ wrench. Handle can be detached from now on by simply removing the Faspins.

Lifting/Bending Handle Installation
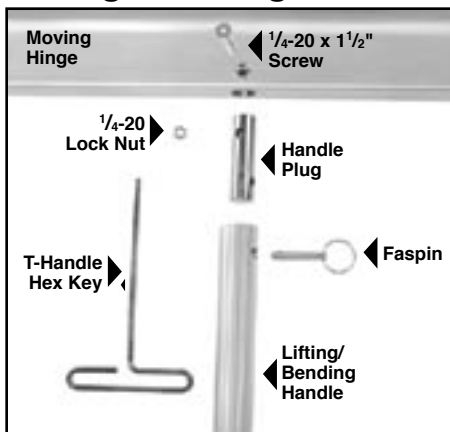
Remove the combination Lifting/Bend-ing Handles from each end of the Port-O-Bender by removing the Faspins as shown.

Insert Handle Assembly into hole in bot-tom of Moving Hinge. Align hole in hinge with Handle Plug and insert screw using T-Handle Hex Key as shown. Secure with 1/4-20 Lock Nut.

Repeat for other handle(s). To remove handles, simply release Faspins. Always use more than one handle when bending.

Hinge Clip Installation

The Hinge Clip keeps the Moving Hinge in position for ease of aligning material. It can also prevent rippling of the coil during cut off operations.

To install Hinge Clip, locate predrilled hole on bottom center of Moving Hinge. Align holes in Clip and Hinge as shown and insert Phillips head screw provided.
Note: You must use hinge clip when using Pro Cut-Off.

Using Your PRO Brake

Basic Hemming and Folding

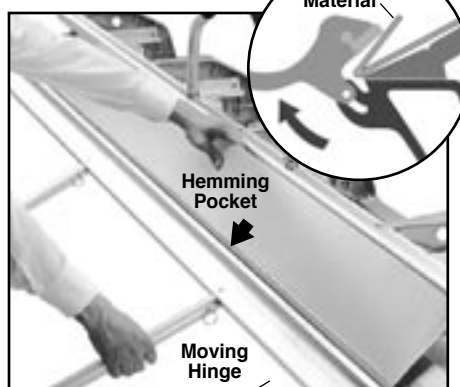**1** Insert the material you wish to hem into your Port-O-Bender.

2 Close and lock Bender on the material.

3 Bend as far as you can go.

HEMMING POCKET

Material

Hemming Pocket

Moving Hinge

4 Remove the material from the Port-O-Bender.

5 Position the bent edge of the material in the Hemming Pocket on top of the Anvil.

6 Lift the Bending Handles and compress the bend for a completed hem.

Care and Maintenance of your Port-O-Bender®

Your Tapco Port-O-Bender® is virtually maintenance free and will provide you with years of reliable and trouble-free performance, however, there are a few basic necessities required to keep your Port-O-Bender® like new.

1. Clean the clamping surfaces each day before using. Use only clean shop towels that are free of dirt, oil and metal chips.

2. Do not use your bender around your saw table as the cuttings may get in between clamping surfaces and cause excessive wear or material scratching. Brush away any cuttings or filings that accumulate.

3. Transport your Port-O-Bender® in the unlocked position. You may transport it in the locked position if you clamp a piece of cardboard or vinyl siding between the clamping surfaces.

4. If your material is getting scratched, examine the Stainless Bending Edge, Base Hinge and Moving Hinge for roughness or burrs. Remove burrs with emery cloth or replace excessively worn parts. Optional Pro Cut-Off will help eliminate excessive wear to costly bending edge.

5. Use a lightweight spray oil along the moving pivot hinge after every 40 hours of use.

Capacities

PRO 14/19 Bending Capacities

- Up to .030 soft aluminum
- Up to 28 ga. galvanized steel
- Up to 16 oz. copper sheet & coil

PRO 14 HD Bending Capacities

- Up to .040 soft aluminum
- Up to 26 ga.* galvanized steel
- Up to 20 oz. copper sheet & coil

* MAX-I-MUM II commercial model Port-O-Benders are available to bend up to 20 ga. galvanized steel.
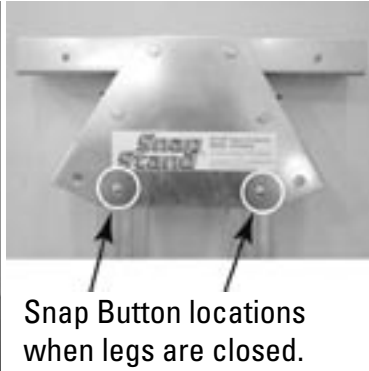
Snap Stand Set-Up

STEP 1

To open each Leg Set, push in the snap button and move each leg outward to the working position. Figure 1A below shows the leg set as shipped while Figure 1B shows the leg set open (working position). Make sure that the snap button pops up to lock each leg.
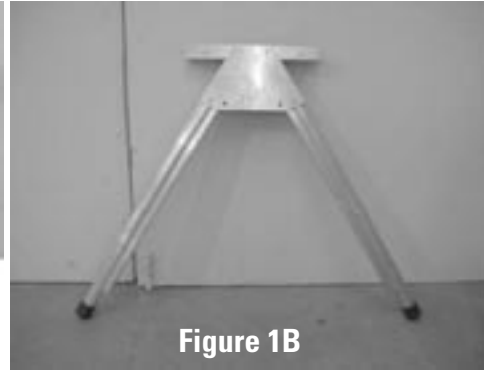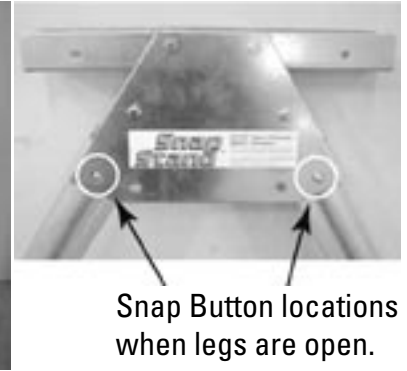
Figure 1A

Snap Button locations when legs are closed.

Figure 1B

Snap Button locations when legs are open.

STEP 2

Attach the Cross Braces to the Leg Sets. With the snap button of the Leg Set pointing to the outside, snap the Cross Braces into position. See Figures 2A and 2B below.

Note: Be sure the C-shape of the Cross Brace is mating the leg as shown in Figure 2C below.
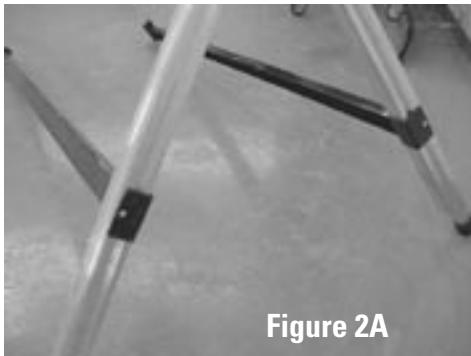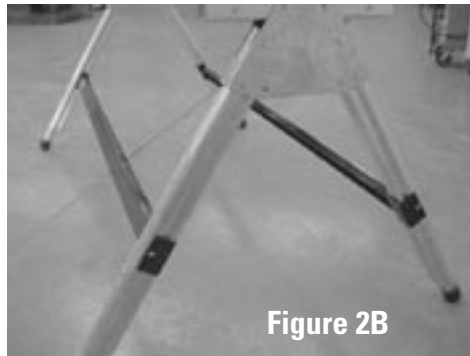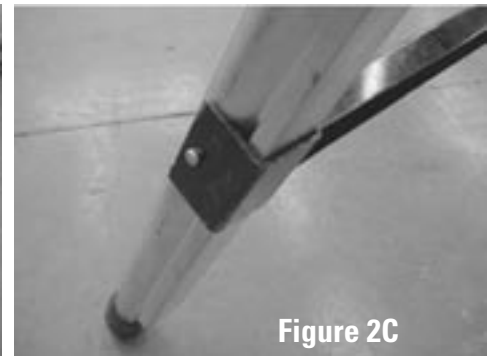
Figure 2A

Figure 2B

Figure 2C

Attaching Optional Wheel Kit

Use one of these positions to stop the stand from rolling.

STEP 3

To remove the wheel assembly, tap the bracket downward with a hammer to disengage.

STEP 1

Insert the wheel assembly into the leg of the Snap Stand as shown in the figure above. Tap the bracket with a hammer to wedge it tightly into the leg. Repeat this process for the other leg.

STEP 2

To prohibit the stand from rolling on the wheels, lock the leg extensions into one of the bottom two locking positions. See figure above. If the leg extensions are in one of the other 3 positions, the wheels are in contact with the ground and are free to roll.
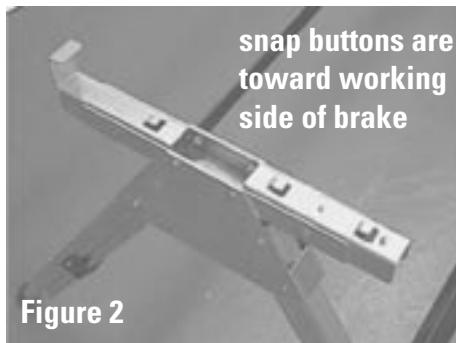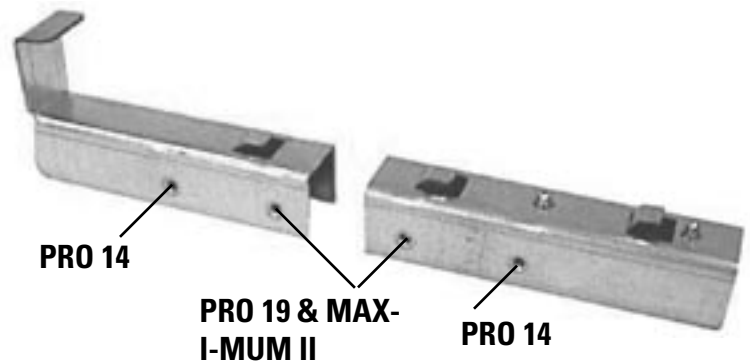
Installing Brake on Snap Stand

STEP 1
Using the 1/4-20 bolts and lock washers provided, fasten the brake mounts to the Leg Set. Depending on which brake you're using, choose the correct holes as shown in the figure at right.

PRO 14

PRO 19 & MAX-I-MUM II

PRO 14

snap buttons are toward working side of brake

Figure 2

Back Rail clearing adaptor hook

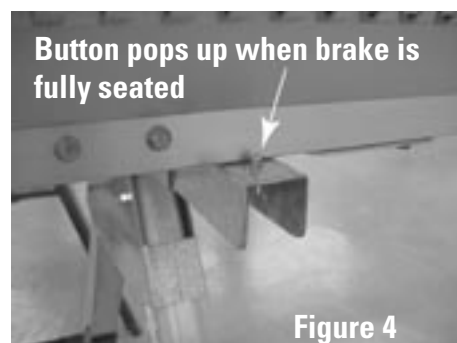**Figure 3A**

Figure 3B

STEP 2
The snap buttons will be towards the working side of the brake. Repeat Step 1 for the other Leg Set. Be sure both ends of the Snap Stand are going the same direction (with the snap buttons on the same side). See Figure 2 above.

STEP 3
Place the brake on the assembled Snap Stand with the Back Rail of the brake clearing the adaptor hook as shown in Figures 3A and 3B above.

Figure 3C

Button pops up when brake is fully seated

Figure 4

Removing the Brake:

1. Removing the brake from the Snap Stand is essentially the opposite of attaching it to the stand.
2. Lifting the Moving Hinge, depress the snap button and pull the brake forward far enough to hold each snap button down.
3. Be sure the box rail is out of the Rear Clip. The brake can now be removed from the stand.
4. Reverse Steps 2 and 1 to disassemble the stand for transport.

The snap button will be covered by the fixed hinge of the brake as in Figure 3C above.

STEP 4
Push the brake firmly rearward into the adaptor hooks. The snap buttons by the front clips will pop up and secure the brake on the Snap Stand. See Figure 4 above. The brake is now ready for use.