Clarke®

STRONG-ARM



PRESS BRAKE ATTACHMENT

MODEL NO: CPBA1

PART NO: 7614059

OPERATION & MAINTENANCE INSTRUCTIONS

ORIGINAL INSTRUCTIONS DL0926

INTRODUCTION

Thank you for purchasing this CLARKE Press Brake Attachment.

Before attempting to operate the machine, it is essential that you read this manual thoroughly and carefully follow all instructions given. In doing so you will ensure the safety of yourself and that of others around you, and you can also look forward to the press giving you long and satisfactory service.

GUARANTEE

This CLARKE product is guaranteed against faulty manufacture for a period of 12 months from the date of purchase. Please keep your receipt as proof of purchase. This guarantee is invalid if the product is found to have been abused or tampered with in any way, or not used for the purpose for which it was intended.Faulty goods should be returned to their place of purchase, no product can be returned to us without prior permission.

This guarantee does not affect your statutory rights.

SAFETY SYMBOLS

	Hazard: shattered workpiece		Hazard: crushed hands
	Wear Safety Shoes		Wear safety glasses
	Read instruction manual before use		Wear protective gloves

The above safety symbols appear on the product.

SAFETY PRECAUTIONS

- **ALWAYS** adhere to the press's safety precautions.
- **NEVER** exceed the maximum permissible pressing force of 20 tonne.
- **NEVER** reach into the pressing dies during pressing operations.
- **ALWAYS** make a test bend with a residual piece to familiarise yourself with the properties of the material to be processed.
- **ALWAYS** use suitable protective gloves to avoid injuries caused by sharp edges of the workpiece.
- Before starting work, check for cracked welds, loose or missing bolts, or any structural damage. **DO NOT** operate if any of these conditions exist. Have repairs made only by the CLARKE service centre.
- Before work, always ensure that hydraulic hoses and couplings are completely sound.
- **NEVER** tamper with the press components or modify them.
- The components of this press brake are designed to withstand the rated load. **DO NOT** substitute any other components or exceed the rated load of the press.
- Before applying pressure, ensure the workpiece is firmly secure and stable.
- **DO NOT** let any person who is unfamiliar with hydraulic presses use the press unless they are under direct supervision.
- Keep children and unauthorised personnel away from the work area.
- **ALWAYS** apply the load under the centre of the ram. Offset loads can damage the ram and may cause the workpiece to be ejected.
- **ALWAYS** ensure the workpiece is properly supported by the press bed.
- Parts being pressed may shatter or be ejected from the press. **ALWAYS** use adequate guards, and wear eye protection and protective clothing when using this press brake.
- Keep hands and fingers away from parts that may pinch or shift.
- Wear approved impact safety goggles and heavy duty work gloves.
- Failure to heed these warnings may result in damage to the equipment, or serious personal injury.

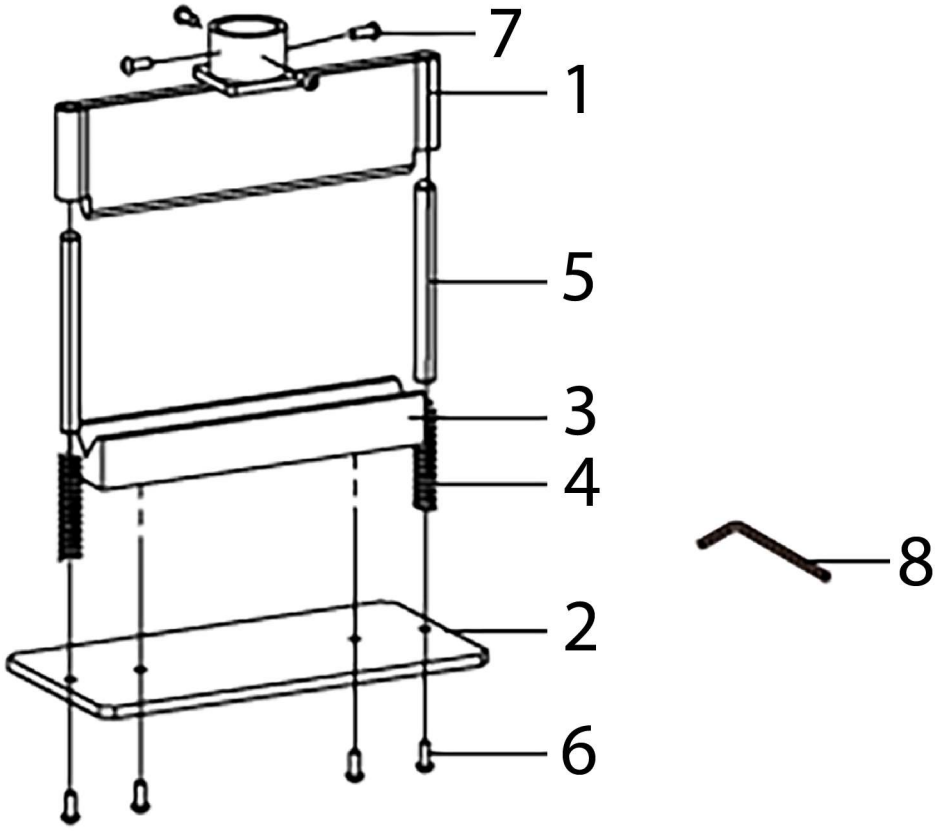
TECHNICAL SPECIFICATIONS

Compatible CLARKE Press's	CSA10BC, CSA10EP, CSA12F, CSA12FB, CSA20EP, CSA20F, CSA20FB, CSA20FBT, CSA20FBTB
Maximum Rated Load	20 Tonne
Bending Angle	0-90°
Maximum Bending Width	305 mm
Maximum Bending Thickness (Mild Steel & Aluminium	5 mm x 305 mm 8 mm x 152 mm 10 mm x 76 mm
Product Dimensions (H x W x D)	230 mm x 373 mm x 185 mm
Weight	15.65 kg

UNPACKING

Ensure the press brake and its components suffered no damage during transit and that all components are present. Should any loss or damage become apparent, please contact your CLARKE dealer immediately.

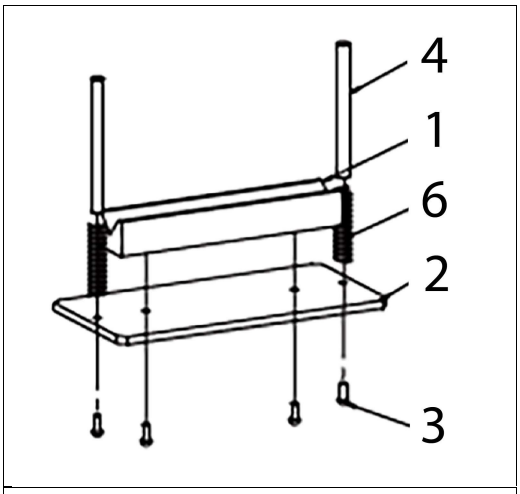
COMPONENT IDENTIFICATION



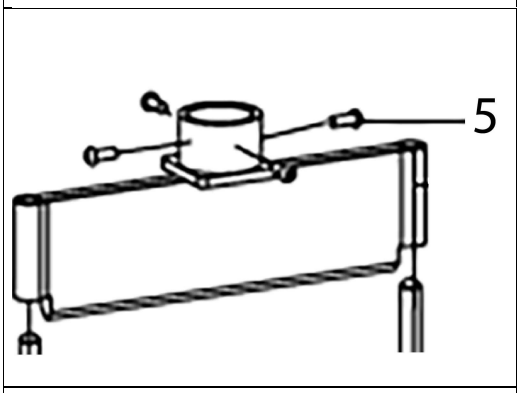
1	Upper Die	5	Slide Post x 2
2	Base Plate	6	M8 x 16 Screw x 4
3	Lower Die	7	M8 x 25 Screw x 4
4	Spring x 2	8	5 mm Hex Key

ASSEMBLY

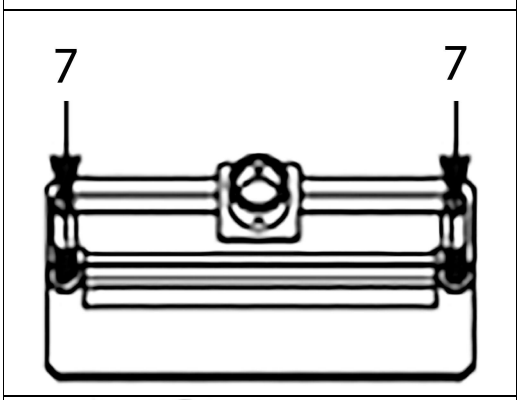
1. Fix the lower die (1) on to the base plate (2) with 2 of the M8 x 16 screws(3).
2. Fix the slide post (4) on to the base plate (2) with 2 of the M8 x 16 screws (3).
3. Push the two springs onto the slide posts (6).



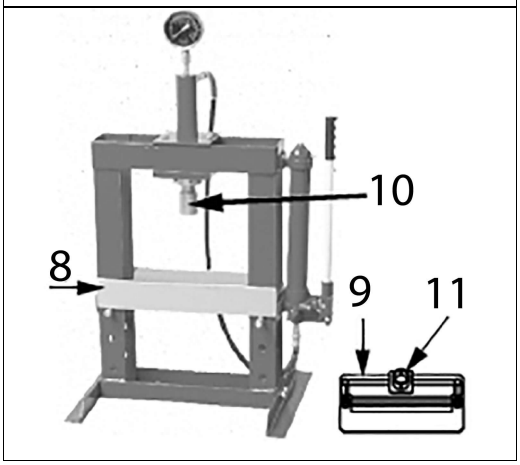
4. Fix the 4 M8 x 25 screws (5) to the press ram socket on top of the upper die.



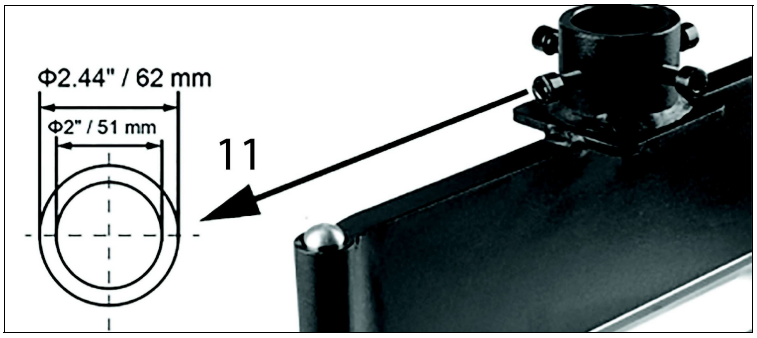
5. Place the upper die on to the two slide posts (7).
6. Position the work bed in the height position to enable to use the attachment (8).When doing so, observe the travel path of the pressure die in combination with the attachment. For positioning the work bed, refer to the operating instructions of the press used.



7. Position the press brake attachment (9) on the work bed. Make sure that the ram (10) is located directly above the holder of the press brake attachment (11).

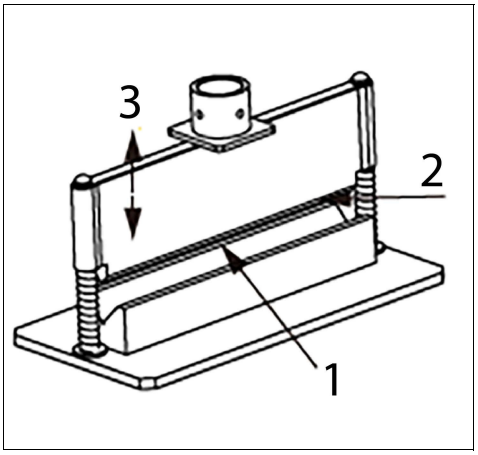


8. Slowly lower the ram (10) until it touches the press brake attachment (11), and tighten the 4 attachment bolts to the ram (10).



PREPARATION FOR USE

HANDLING



1. Measure and mark the desired bending line on the workpiece.
2. Slide the workpiece between the upper and lower dies (1).
3. Centre the workpiece and align the marked bend line with the sharp, beveled edge of the upper die (2).
4. Slowly lower the ram of the press to create the desired bend (3).
5. Once the pressing/bending operation is complete, lift the upper die and remove the workpiece.

NOTE: The use of an angle gauge is recommended.

AFTER HANDLING

CAUTION: MANIPULATING THE PRESS BRAKE OR WORKPIECE WHILE THE PRESS IS SUPPLIED WITH PRESSURE CAN LEAD TO SERIOUS INJURY.

1. Remove any chips and dirt particles from the press brake after each use, especially the surfaces, that come into contact with sheet metal workpieces.
2. Prepare the surfaces and lubricate the bare parts of the press brake with an acid-free lubricating oil to protect the product from rust.
3. Store the press brake in a dry, frost-proof and lockable place when not in use. Make sure that unauthorised persons and especially children DO NOT have access to the product.

A SELECTION FROM THE VAST RANGE OF

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Parts Enquiries
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Clarke® INTERNATIONAL Hemnall Street, Epping, Essex CM16 4LG
www.clarkeinternational.com