

# Sheet metal Bending Brake Plans



# 24" Sheet Metal Bending Break

## Materials List

### Hinges

3" x 1 1/4" x 3/16" Strap (2)

1 1/4" x 1 1/4" x 3/16" Strap (2)

2 5/8" x 1 1/4" x 3/16" Strap (2)

1" x 5/8" Round (2)

### Platen's

25" x 2" x 3/16" Angle (2)

### Bracing

23" x 1" x 1/4" Angle (2)

24" x 1 3/4" x 1 3/4" x 1/8" Angle (1)

### Base

3 1/2" x 2" x 3/16" Angle (2)

### Handles

5" x 3/4" x 1/2" Loga Tubing (2)

10" x 3/4" x 1/2" Loga Tubing (2)

3/4" x 2" Bolt (2)

3/4" x 1" Bolt (2)

3/4" Nuts (4)

3/4" flat Washers (2)

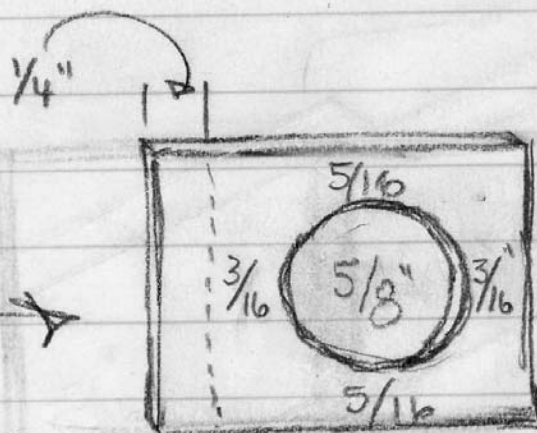
1 1/4" Unpainted Drill bits (4)

Brass threaded inserts (4)

Note: Materials and sizes can be altered for your application

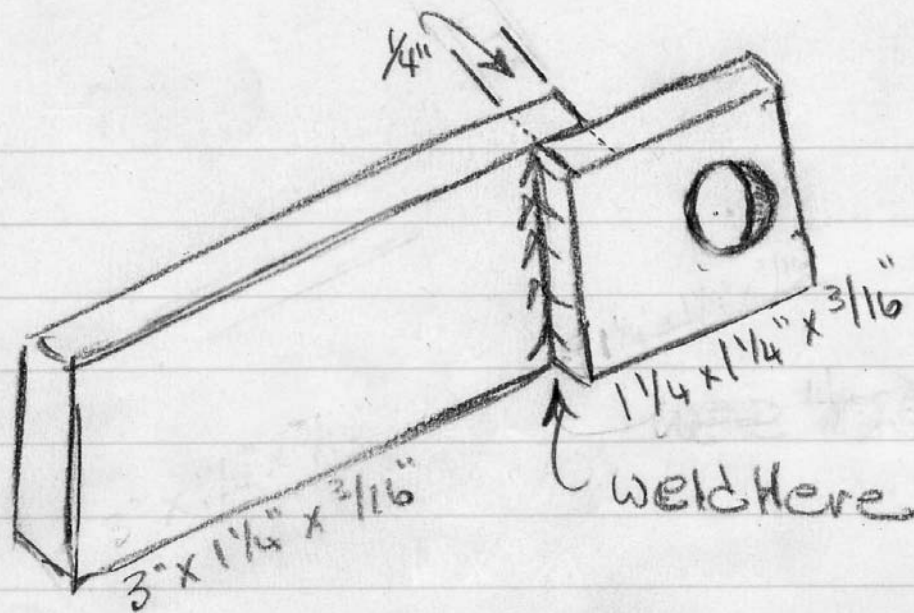
## Step 1

Drill hole →

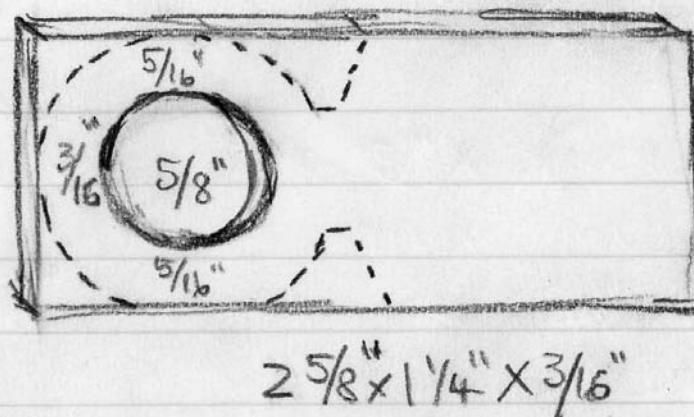


1 1/4 x 1 1/4 x 3/16"

Step 2

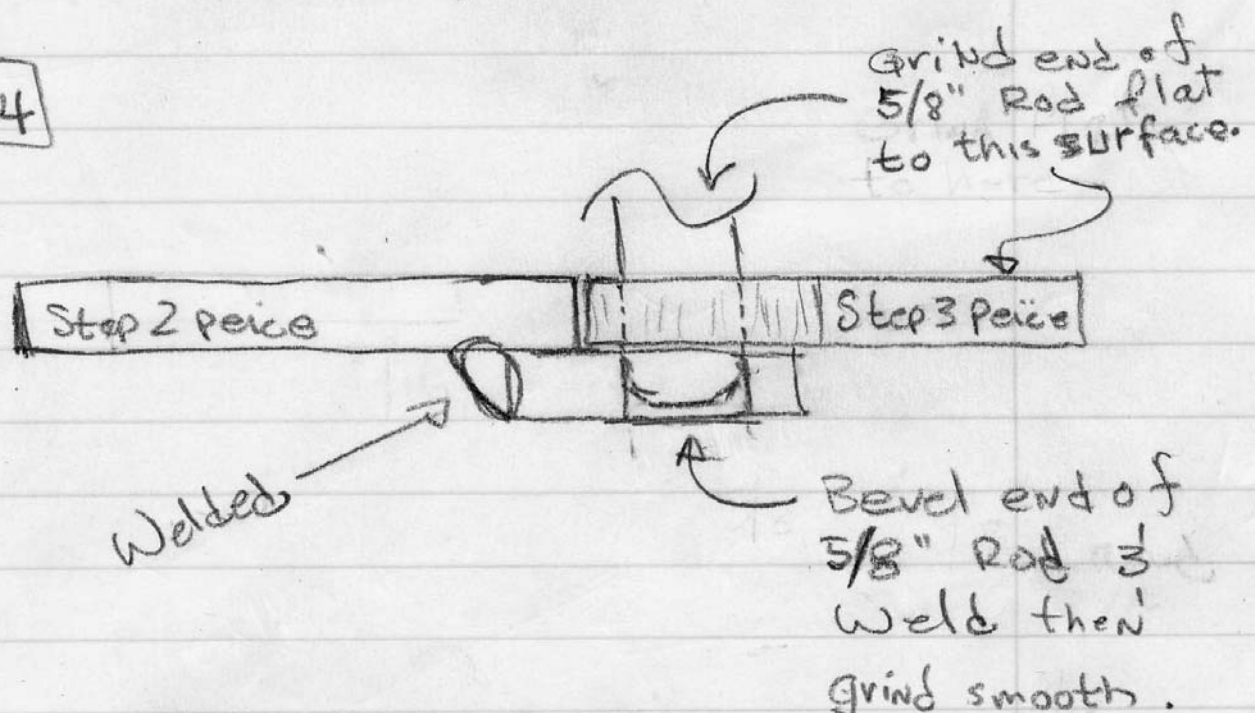


Step 3



Drill hole and grind to shape

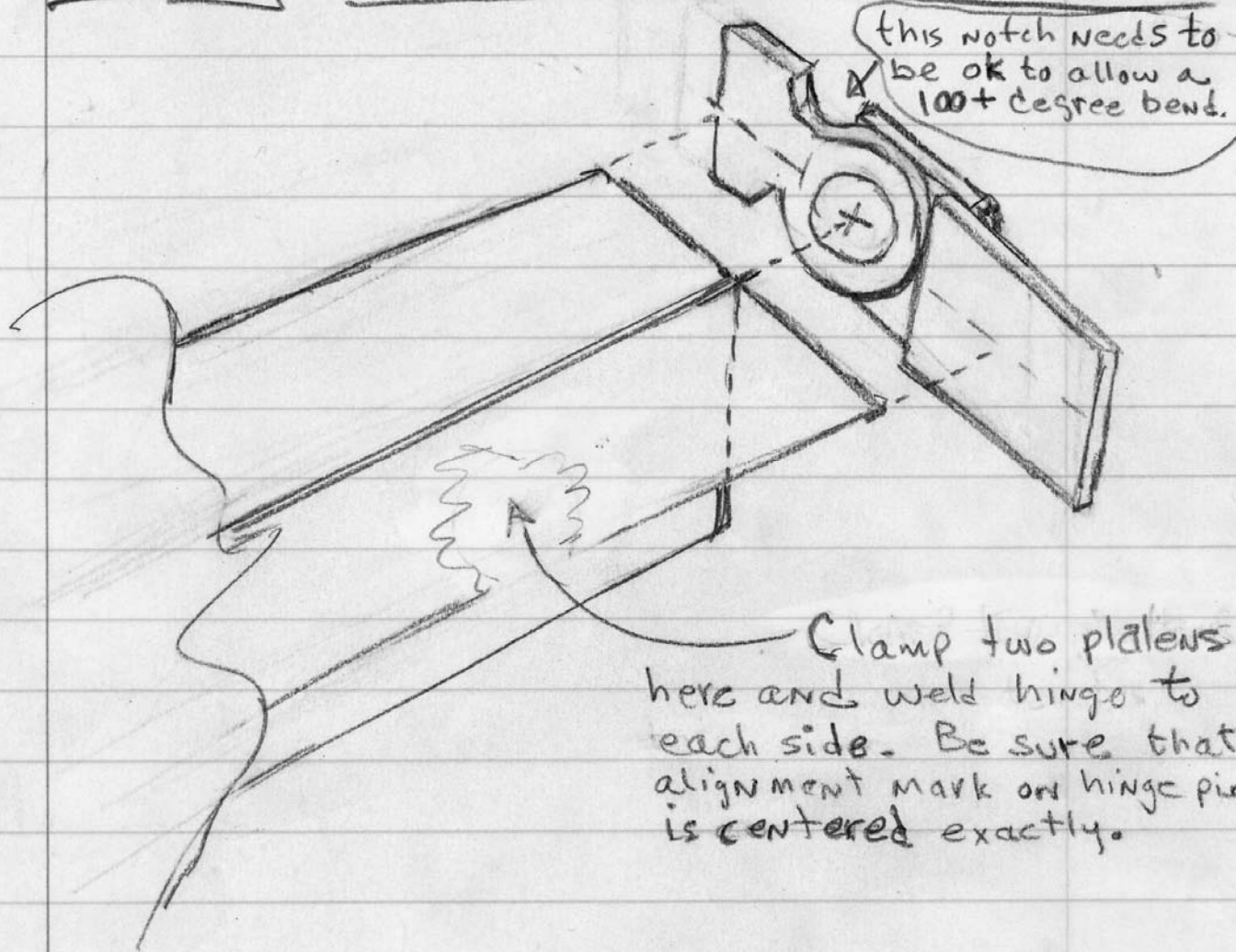
Step 4



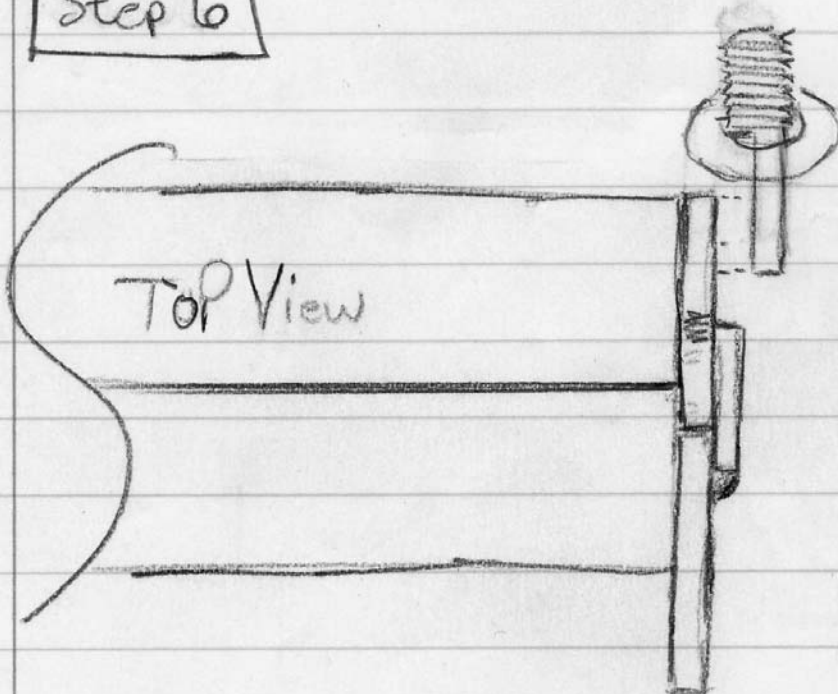


### Step 5

Note: Make sure hinge works before welding

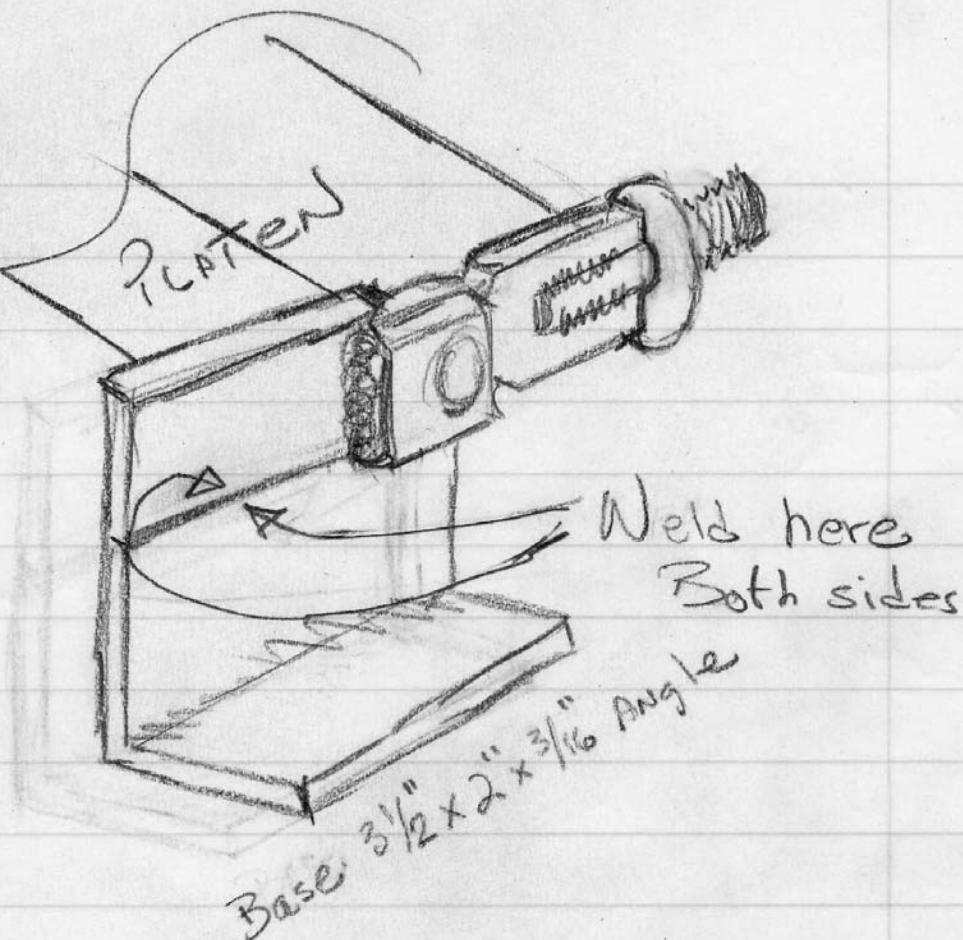


### Step 6



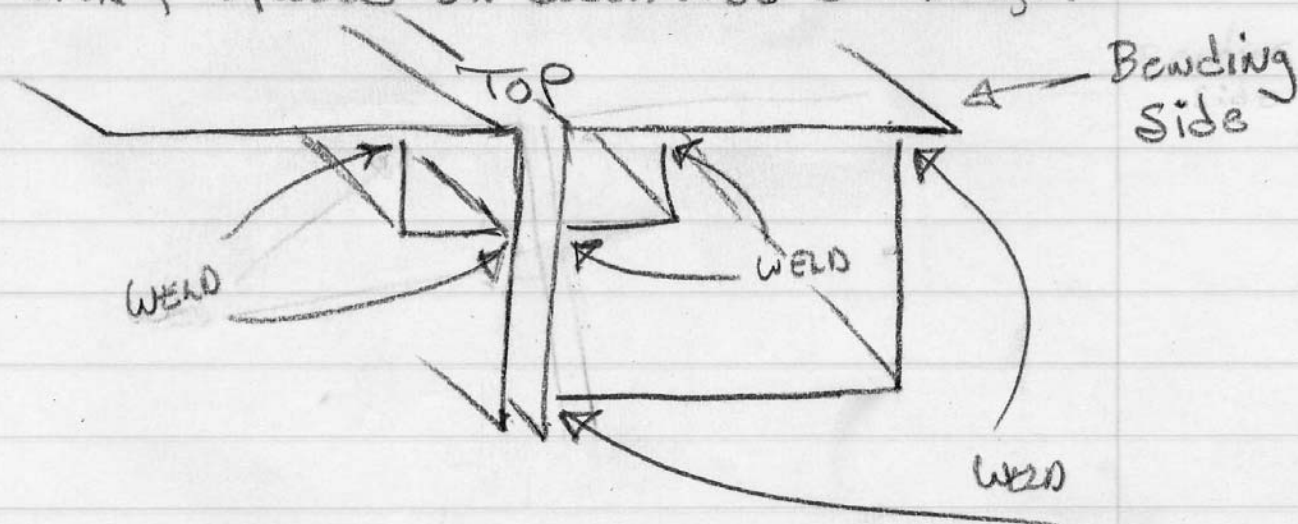
cut head from 2" bolt, grind flat as shown and weld to bending platen. Slip washer over threads and tac weld.

Step 7



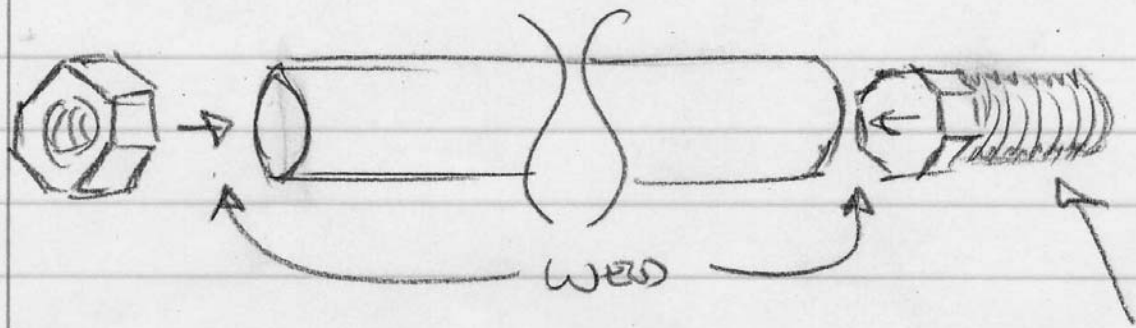
Step 8

Weld bracing under platens, the  $1'' \times \frac{1}{4}''$  angle goes under both sides & the  $1\frac{3}{4}'' \times \frac{1}{8}''$  angle under the bending platen on top of the  $1'' \times \frac{1}{4}''$  angle. Use lots of champs and 5 1" beads evenly spaced on each side is enough.



## Step 9

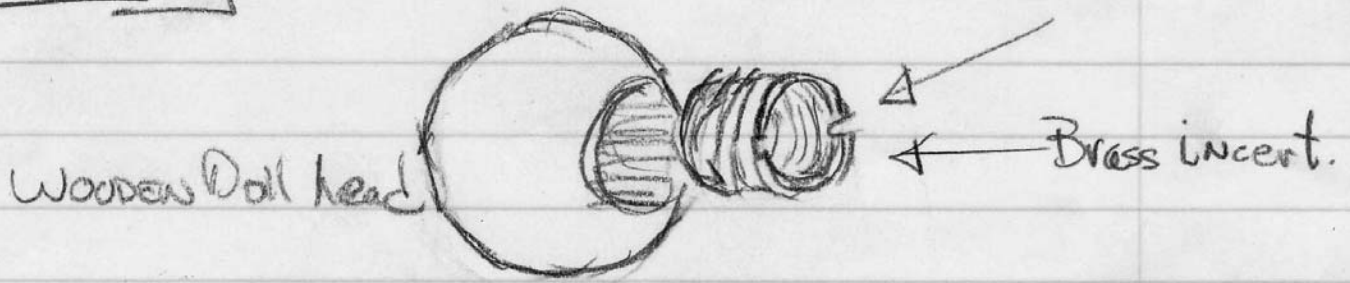
### Handles



make sure these  
threads are the  
same

## Step 10

### Knobs



Disclaimer: Even though I drew these plans I am not responsible for any errors contained herein. Use them at your own risk. The last pieces you will need will be dies to place on what you are bending. I made one that is 24" x 2" x 1/4" and will make more lengths as necessary. I will assume that if you have these plans, you will know how to contact me. This break will do 20 ga x 24" for sure, and I have bent a piece of 1 1/2" x 3/16" strap in the center with no problem. Anything else is your guess. Approx wt. is 20 lbs.