Bill of Material for JRW Sheet Metal Brake

All dimensions in inches.

Plates are finished size.

¼ in. Mild Steel Plate
2 – 4 x 10 ½
½ in. Mild Steel Plate
2 – 1 ¼ x 10
1 – 4 ½ x 26 3/8
1 – 2 ¼ x 24 ¼
1 – 4 ½ x 24 1/8
2 – 2 3/8 x 5 3/8
1 – 2 x 23 1/8
2 – 2 3/8 x 5 11/32
2 – 2 x 10 ½
1 – 6 ½ x 24 3/8
2 – 4 ¼ x 7
2 – ¾ x 2

Round SS or Drill Rod
4 – 3/8 DIA. 1 1/16
2 - ½ dia. x 5 ½
2 - ¾ dia. x 1 1/16
2 – 2 3/8 dia. x 1 ¼
1 – 5/8 dia. x 27 7/8
2 – 5/8 dia. x 1 1/8

Bronze Bearings
4 - 3/8 ID ½ OD ½ long, flanged
2 – 5/8 ID ¾ OD ½ long

Plastic Ball Knobs
2 – 1 3/8 dia.3/8 -16 thread

Square key
2 – 1/8 x 7/8 long

Socket Head Cap Screws
2 – 8-32 x ¾
6 – ¼-20 x ½
33 – ¼-20 x ¾
6 – ¼ - 20 x 7/8
4 – ¼-20 x 1 ¼
2 – 3/8-16 x 1

Set Screw
4 – 10-32 X ¼ in long

Eye Bolt
2 - 1 in. eye 5/16 – 18 x 1 in. thread

Rubber Hose
2 – 5/8 ID x 4 long

by R. J. Kostelnicek 05/05/04
1 - Handle    JRW Sheet Metal Brake

Note: Material mild steel. Make Two

Tap 1/4 - 20 2 - places

Round 4 Corners of the last 4 in. of handle to 3/16 in. R for Pull Over 5/8 ID Rubber Hose Cushining

Ream 1/2 in. for 3/8 in. ID flanged bronze bushing

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2 - Bend Over Platen    JRW Sheet Metal Brake

Drill and Counterbore
1/4 in. Socket Head Cap Screw
4 - places

Material: Mild Steel

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3 - Bottom Support    JRW Sheet Metal Brake

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4 - Cam Adjuster  JRW Sheet Metal Brake

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Material: SS or Drill Rod
Make 2

Eccentric
0.625 in. D
0.031 in. off center

Hex for 5/8 in. Wrench

Tap 3/8 - 16

0.125in
0.500in
0.625in
1.062in

0.625in
0.750in

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5 - Lever  JRW Sheet Metal Brake

Thread 3/8 - 16
Both Ends
Plastic Ball Knob this End

4 - Flats
for 7/16 in.
Wrench

Material: SS or Drill Rod
Make 4

Designed by J. R. Williams - Drawn & Modified by R. J. Kostelnicek - 04/24/04
6 - Cam
JRW Sheet Metal Brake

Material: Mild Steel
Make Right and Left Hand

Ream 5/8 in. D
1/8 in. Square Keyway

Spot Face 9/16 in. D
Tap 3/8 - 16 5/8 in. Deep
Tap #8 - 32 Set Screw Over Key

0.187 in
2.375 in 2.000 in
1.250 in
0.750 in
0.375 in

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Material: Mild Steel

7 - Clamp Plate     JRW Sheet Metal Brake

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8 - Clamp Rocker    JRW Sheet Metal Brake

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9 - Clamp Support

JRW Sheet Metal Brake

Material: Mild Steel

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10 - Clamp Cam Follower     JRW Sheet Metal Brake

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12 - Reach Shaft     JRW Sheet Metal Brake

Fit 1/8 in. Square
7/8 in. Long Key
2 places

Material: Drill Rod

Chamfer 1/32 in.

27.875 in.
26.875 in.
1.000 in.
0.125 in.

0.625 in.
0.069 in.
13 - Side Plate  JRW Sheet Metal Brake

Material: Mild Steel
Make: Two, Right and Left Hand

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14 - Thickness Adjustor  JRW Sheet Metal Brake

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15 - Top Plate  JRW Sheet Metal Brake

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16 - Dowel

JRW Sheet Metal Brake

Material: SS or Drill Rod
Make 4

Chamfer 1/32 in.

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17 - Cam Stop    JRW Sheet Metal Brake

Material: SS or Drill Rod
Make 2

Drill and
Counterbore
1/4 in. Socket
Head Cap Screw

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