



BRAKE ACCESSORY For 45 Ton Iron Worker

NOTICE

The Coper Notcher and Pipe Notcher accessories can not be installed or used when the Brake accessory is installed.

Removing Existing Shear Assembly

Refer to Figures 1 - 6:

1. Lower the Center Arm Assembly so the shear blade is at the lowest position.



Figure 1

2. Remove material chute from Shear Assembly by removing two screws as shown in Figure 2. This will uncover the two base mounting bolts underneath the chute (see Figure 3).



Figure 2



Figure 3

3. Remove bolt and nut that attaches shear blade to Center Arm Assembly (see Figure 4).



Figure 4

4. Remove four Shear Base mounting bolts that attach the Shear Assembly to the Ironworker Frame (see Figure 5).



Figure 5

NOTICE

The Coper Notcher and Pipe Notcher accessories can not be installed or used when the Brake accessory is installed.

5. Raise Center Arm Assembly to provide clearance to remove Shear Assembly. Slide Shear Assembly to the edge of the Ironworker Frame and lift it away.



Figure 6

Installing Brake Assembly

Refer to Figures 7 - 10:

1. Slide Brake Assembly onto the Ironworker Frame. Orient the Brake Assembly as shown in Figure 7.

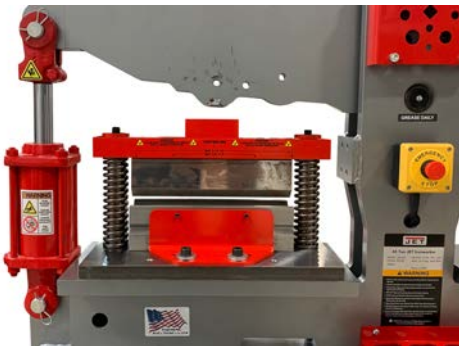


Figure 7

2. Align the four threaded mounting holes on the Brake Assembly with the mounting holes on the Ironworker Frame.
3. Assemble four mounting screws with lock washers, thick flat washers, and thin flat washers. Insert mounting screws from underside of Ironworker Frame and up into the threaded mounting holes of the Brake Assembly base (see Figure 8). Tighten mounting screws firmly.

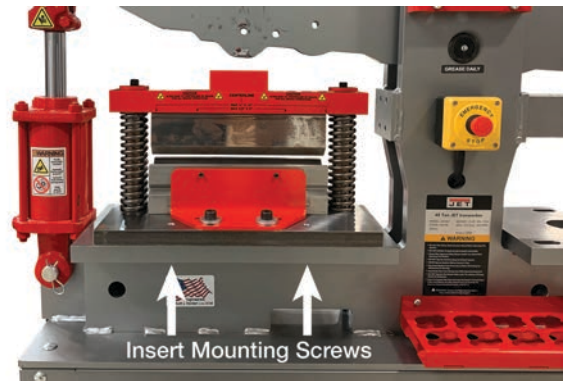


Figure 8

4. The Brake Assembly has a four-way die to accommodate different sizes of materials. The four-way die must be adjusted to be straight with the brake blade. Use the large Brake Die Bracket screws and the small set screws on each side of the four-way die to align the die correctly. See Figure 9.

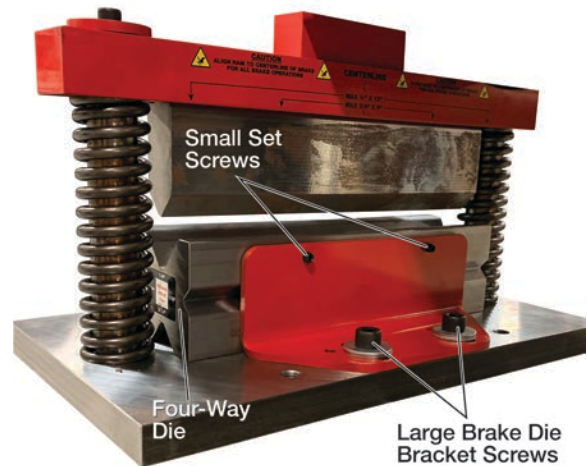


Figure 9

5. Lower the Center Arm Assembly so that the radiused punch contact rests against the Brake Punch Block.

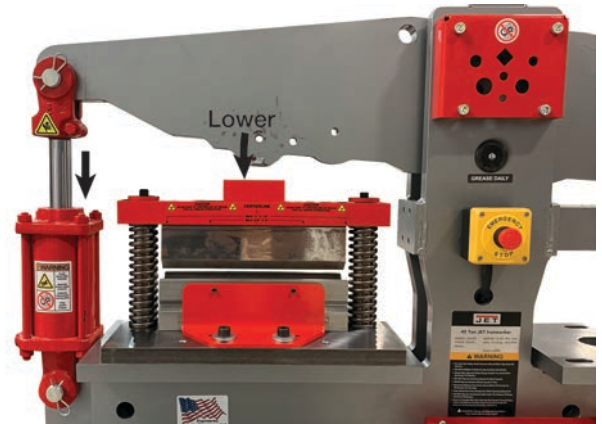
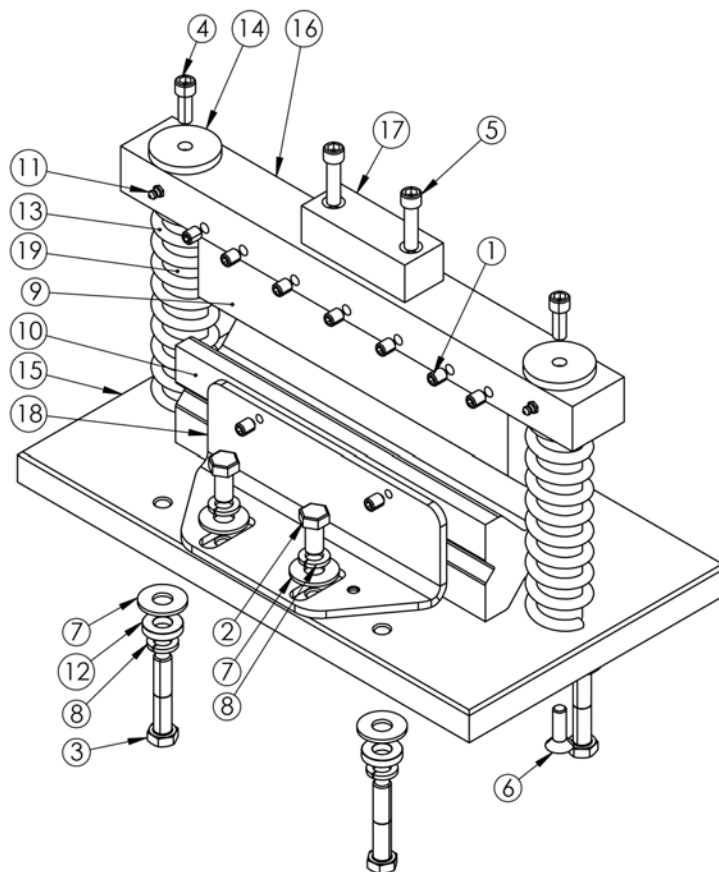


Figure 10

Parts List and Exploded View – Pipe Notcher Accessory



Index No	Part No	Description	Size	Qty
1	1125539	Set Screw	3/8-16 x 1/2"	11
2	13205	Hex Cap Screw	1/2-13 x 1	4
3	13213	Hex Cap Screw	1/2-13 x 2-1/2	4
4	23305	SHCS	3/8-16 x 1	2
5	23309	SHCS	3/8-16 x 1-1/2	2
6	24287	Flat Head Socket Cap Screw		2
7	33012	Flat Washer, USS Z	1/2"	8
8	33626	Split Lock Washer	1/2"	8
9	BD1040	Brake – 12" Top Punch		1
10	BD1041	Brake – 12" Bottom Die		1
11	BS-0070	Grease Zerk	1/4-28	2
12	HD2434	Flat HD Washer	1/2"	4
13	HM-DWC-312-20	Press Brake – 7" Die Spring		2
14	HM138	Press Brake – Washer Retainer		2
15	JT1-254	Table – Base 12" JIW-Brake		1
16	JT1-255	Punch Holder 12" – JIW Brake		1
17	JT1-256	Push Block – JIW 12" Brake		1
18	JT1-257	Brake-Btm die Bracket JIW-45T		2
19	PH125	Pin – Guide Shop Press 12"		2



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