

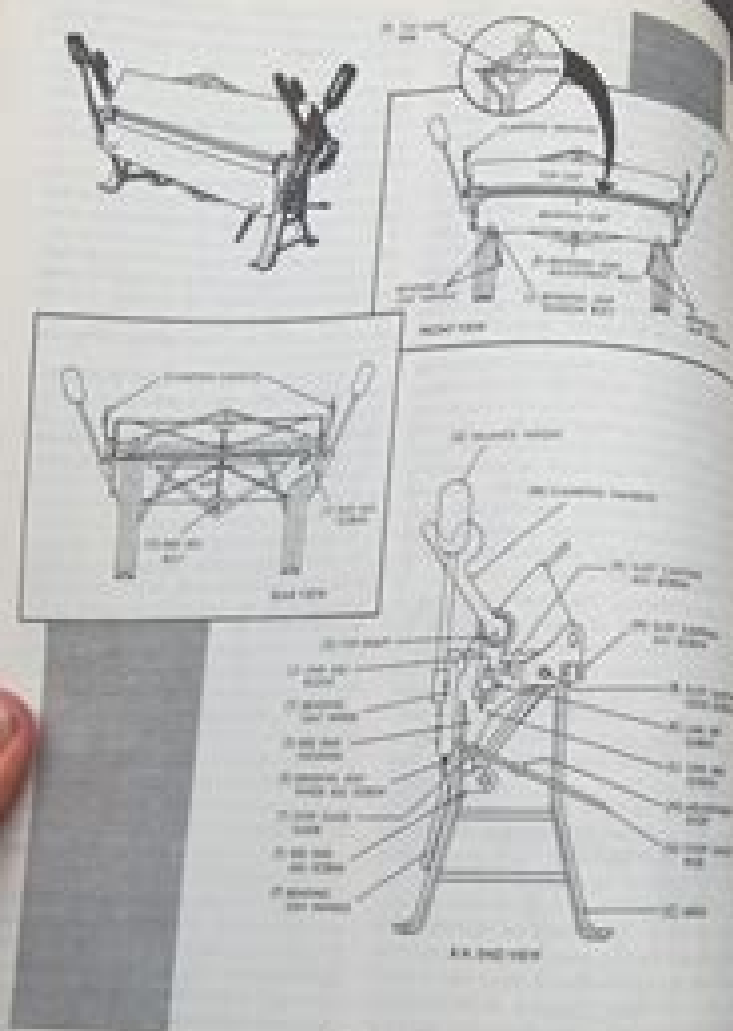


Figure 4-27. Cornice Brake

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The loading capacity of a cornice brake is determined by the manufacturer. Maximum capacities of this machine are from 10 to 15 pounds per foot, and loading lengths are from 8 to 12 feet. The loading capacity of the brake is determined by the loading edge thickness of the cornice-brake leaf.

Most cornice-brake is dimensioned down to 1/8 inch. It is formed in sections to make it more compact. If you use a cornice-brake for a 1/8 inch load, the cornice-brake will probably have an angle of about 45° to 60°. Therefore, if a load of 1/8 inch is desired, you should use your cornice-brake to bend an angle of about 45° to about the springback.

There will also be extension edges you find the material will bend uniformly or will bend by that one end side of the brake than on the other. To correct this condition, use the top leaf back on the end where the sheet is overbending.

If the loading leaf becomes bowed after repeated heavy use, tighten both bolts 2 until the spring is brought into line. The leaf should be a straight line, close to a straight edge.

Formers. Metal or former can be obtained in light-weight sizes such as 1/4, 1/2, 3/4, 1, 1 1/4, 2, 3, and 4 inches. They are used more often to make gutters. These formers are attached to the cornice-brake by means of clamps. When attaching the formers to the brake, there should be 12-inch clearance on the side of the formers against the loading leaf. Position the clamps vertically in the ground, and tap lightly with a mallet. This is the correct enough distance to hold the formers in place. When the need arises to remove the clamps, tap upward with a mallet.

Box and Box Brakes. The construction of the box and box brake is a great deal like that of a cornice-brake except that the clamping bar is divided into sections called fingers or shims. These fingers vary in width and are all interchangeable.

This machine is especially designed for making boxes of various sizes and shapes as it per-

mits the forming of all sizes without changing any of its machine parts. If the load varies, the blade can be used to do any work that can be done on a standard cornice-brake.

If the boxes should need adjustment, there is a great deal for the cornice-brake all when made from an angle and thickness can be accomplished by the same procedure. The steel fingers are moved to the upper flange by means of a screwdriver. The fingers must be evenly spaced and the thicknesses tapered below using the blade. To remove any of the fingers, simply remove the clamping bar, tap the clamping bar down by pushing the clamping bar backward, and then pull the fingers forward. When installing the fingers, reverse the procedure.

Before you start to work on the box and box brake, be sure all the adjustments are made for the gauge of metal you are to be using. The set head and wire, head line, or spring (depending on what the box and box brake is to be used for).

Box and Box Formers. The box and former (the box 4-1/2) is basically composed of three rolls, two bearings, a base, and a handle. The handle turns the two main rolls through a system of gears located in the bearing.

The three rolls work as loading or pressing rolls. The base roll is used to give the proper curvature to the work. The three rolls are placed by means of two front adjusting screws located at each end of the machine. The base roll is adjusted by means of two screws located at the end of each bearing. The front and rear rolls are ground to press loading or shaping with steel edges. The upper roll is equipped with a release which permits easy removal of the metal after it has been formed.

When using the slip roll former, the lower front roll must be raised or lowered on the shaft of

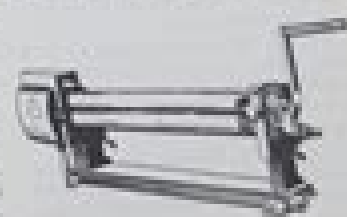


Figure 4-28. Slip Roll Former

Airframe Repair Manual

Puja Mehta



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Table of Contents Airframe Repair Manual

1. Understanding the eBook Airframe Repair Manual
 - The Rise of Digital Reading Airframe Repair Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Airframe Repair Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Airframe Repair Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Airframe Repair Manual
 - Personalized Recommendations
 - Airframe Repair Manual User Reviews and Ratings
 - Airframe Repair Manual and Bestseller Lists
5. Accessing Airframe Repair Manual Free and Paid eBooks
 - Airframe Repair Manual Public Domain eBooks
 - Airframe Repair Manual eBook Subscription Services
 - Airframe Repair Manual Budget-Friendly Options
6. Navigating Airframe Repair Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Airframe Repair Manual Compatibility with Devices
 - Airframe Repair Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Airframe Repair Manual
 - Highlighting and Note-Taking Airframe Repair Manual
 - Interactive Elements Airframe Repair Manual
8. Staying Engaged with Airframe Repair Manual

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Airframe Repair Manual
- 9. Balancing eBooks and Physical Books Airframe Repair Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Airframe Repair Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Airframe Repair Manual
 - Setting Reading Goals Airframe Repair Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Airframe Repair Manual
 - Fact-Checking eBook Content of Airframe Repair Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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