

Operation Manual & Parts List  
**TIN KNOCKER LETTER BRAKE**



**TAAG INDUSTRIES CORP.**

**"The Tin Knocker People"**

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# **TIN KNOCKER --SAFETY RULES**

## **TK Letter Brake**

1. Never use a machine or tool for anything other than its intended purpose. Use the proper tool and equipment for the task.
2. Do not operate the machine in excess of its rated capacity.

## **WARRANTY**

All new machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. TAAG Machinery Co. at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. TAAG Machinery Co. will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to TAAG Machinery Co., at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to TAAG Machinery Co. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

**NOTE:** This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Following the procedures described within can easily do readjustment. These are procedures with which you, as a user, should be familiar, as you will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you. Call us at: (800) 640-0746.

**3. RECEIVING THE MACHINE.** Inspect before signing Bill of Lading. Upon receipt closely examine the machine for damage during shipment. Any loss or damage should be noted in detail on the delivery receipt and photos taken. Report this damage and send photos to your distributor immediately. Free replacement from TAAG is dependent upon the notation and the Bill of Lading on delivery slip.

## **4. INSTALLING THE MACHINE**

Locate the machine in a well-lighted area on a solid, level floor. The machine must be securely bolted to the floor.

## **5. PRECAUTIONS**

DO NOT use this machine to bend rods, nails or wires. This will cause damage to the edge of the top blade. DO NOT exceed the capacity of the machine, which is 20 gauge (0.036 inches) mild steel.

## **SPECIFICATIONS:**

Capacity: 20 Ga. Mild steel

Dimensions: Approx. 48"x48"x46" high

Footprint: Approx 25"x22"x42" high

Weight: 190 lbs

# OPERATOR INSTRUCTIONS

## Instructions and Parts List for Letter Forming Brake

**CARE:** An occasional oiling with light machine oil of moving parts is sufficient care of this machine.

**OPERATION:** Always make sure the Apron is level and even with the Lower Beam. If the Apron is not even, adjust up or down by loosening Apron Hinge Adjusting Screw Nuts and adjust Apron by turning the Apron Hinge Adjusting Screw. Be sure to retighten Lock Nuts when adjustment is complete. To adjust the Upper Beam, loosen Upper Beam Pivot Bracket Screws and move Upper Beam to desired position by the Upper Beam Adjusting Screws. Retighten the Pivot Bracket Screws. For a sharp bend in most metals the Upper Beam Jaw should line up with the front edge of the Lower Beam Jaw. If bending 26 or 28-gauge material the Upper Beam Jaw may have to be moved forward of the Lower Beam Jaw about 1/64". If a slight radius is desired in heavier metals the Upper Beam Jaw should be moved to the rear. Do not move the Upper Beam Jaw forward more than 1/64" or backward more than 3/32" from the edge of the Lower Beam Jaw.

Fine No.	Part No.	Description	No. REQ'D.
1	LB99-1	Upper Beam	1
2	LB99-1-3	Upper Beam Jaw	1
3	LBWS539	3/8-16 x 1-1/4 Socket Head Cap Screw	4
4	LBWS49	7/16-14 x 1-1/4 Hex Head Cap Screw	2
5	LBWS1704	3/8 Flat Washer	14
6	LB99-10	Clamping Arm Spacer	4
7	LBWS1729	3/8 Clock Washer	9
8	LBWS1333	3/8-16 Hex Jam Nut	11
9	LBNS420-40	Upper Beam Arm Bracket	2
10	LBWS535	3/8-16 x 5/8 Socket Head Cap Screw	4
11	WS1748	3/8 Internal Shackproof Washer	4
12	LB99-11	Upper Beam Pivot Pin	2
13	LBWS896B	5/16-18 x 3/8 Socket Set (Dog Point Screw)	2
14	LBWS829	5/16-18 x 3/8 Socket Set Screw	2
15	LBWS632	3/8-16 x 1-1/2 Square (Head Set Screw)	2
16	LBWS631	3/8-16 x 1-1/2 Square (Head Set Screw)	2
17	LB99-2	Lower Beam	1
18	LBWS318	3/8-16 x 1-1/4 Flat Head (Cap Screw)	3
19	LB99-6	Lower Beam Jaw	1
20	LBWS34	3/8-16 x 1-1/4 Hex Head (Cap Screw)	4
21	LB99-3	Apron	1
22	LB99-8	Apron Handles	2
23	LB99-14	Apron Hinges	2
24	LBWS64	1/2-13 x 1-1/4 Hex Head (Cap Screw)	4
25	LBWS1706	1/2 Flat Washer	4
26	LB99-15	Apron Shims as req.	
27	LB99-13	Apron Hinge Pins	2
28	LBWS813	1/4-20 x 1/4 Socket Set Screw	2
29	LBWS618	5/16-18 x 1-1/4 Square (Head Set Screw)	2
30	LBWS1332	5/16-18 Hex Jam Nut	2
31	LB99-4	Stand	1
32	LB99-9	Clamping Arms	2
33	LB99-5	Foot Treadle	1
34	LB129-68	Foot Treadle Bushings	2
35	LB247-62	Foot Treadle Spring	1
36	LB99-12	Foot Treadle Spring Rod	1

