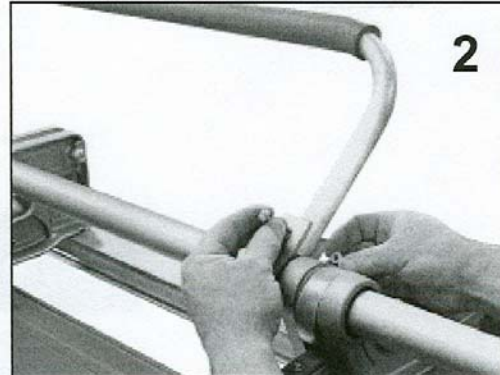


ALUMINUM BRAKE

Brake Setup

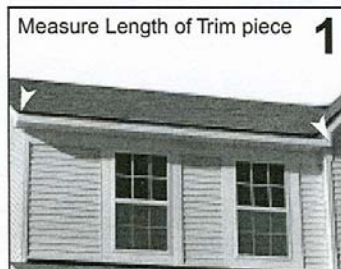


1
The bending handle assembly shown above comes with handle brackets which are pre-installed. Back off thumb screws far enough to clear front hinge flange and slide assembly onto front hinge. Tighten thumb screws firmly once handle is in desired position. To adjust handle position, loosen both thumb screws, move handle to new location and tighten thumb screws.

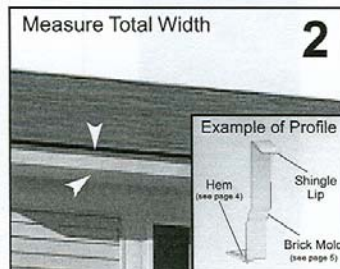


2
Place handle ends into bracket openings and align holes in brackets with holes in handle. Insert screws through holes and tighten snugly with hex nuts. Once you have both handles in place, the brake is ready for use.

Material Setup and Bending Basic Shapes



1
Measure Length of Trim piece
Measure the length of the trim piece. Be sure to add for corner or end laps. If trim piece length exceeds the length of the brake, measure for two pieces and determine best point for overlap.



2
Measure Total Width
Measure the width of the trim piece and where each bend will be made. Tech tip: Use a small strip of the material and hand bend it into a profile of the area your trimming off. You can also use the "profile" to check the rest of the job where the same trim piece is to be used.



3
Score Material
Lay out material from coil and score along desired trim length*. Next, score along desired width. Transfer the bending information to the scored material ("blank"). With the finish side of the material as your reference, remember to indicate bends up and bends down

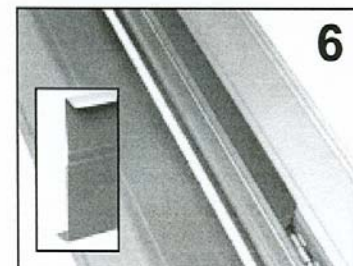
Optional Trim Enhancement Step



4
Note: For forming standard fascia, proceed to step 6. For enhanced fascia, first determine orientation of brick mold or rib placement in blank. Lock blank evenly in brake and run TrimFormer along piece.



5
As described on page 4, make hem in material. Next, with finish side down, bend the hemmed lower leg of fascia profile to 90°. Note: Use the Profile strip to check each step for accuracy.



6
Complete fascia profile by removing piece from brake and reinserting with the finish side down and the top edge extending outward from the brake. Bend top leg until it matches roof pitch.

Trim Cutter

GETTING STARTED

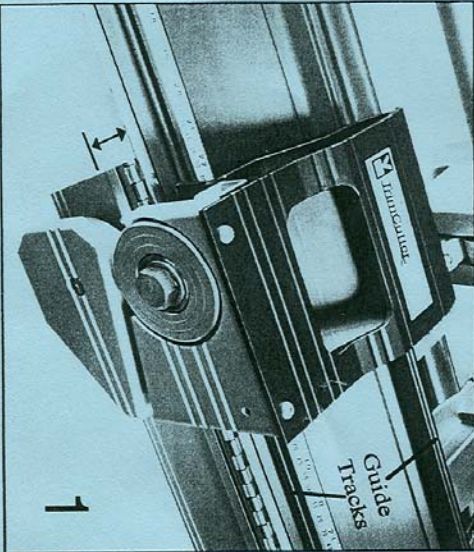
Your new Van Mark TrimCutter™ is designed for use on Mark Series Contractor, Commercial and Industrial model brakes. Read all instructions and safety information prior to using this tool.

IMPORTANT SAFETY NOTE:

- A. Always keep hands and fingers clear of the knives during all phases of use.
- B. If using both hands to push tool through material, ensure hands are not in the path of the exiting material as it leaves the rear area of the tool.
- C. Remove tool prior to bending material. Failure to do so can cause the tool to fall from brake resulting in tool damage or personal injury to user.
- D. Never use tool to cut material not firmly clamped in brake

OPERATION

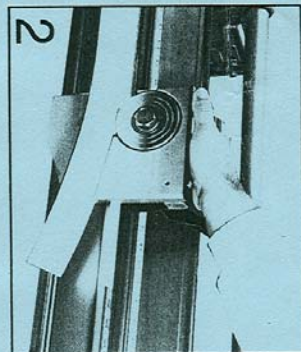
1. Measure material and place marks at opposite ends where cut is to be made. TrimCutter™ cuts 1 1/2 inches out from the stainless steel edge therefore align cut marks 1 1/2 inches away from stainless steel edge. With cut marks now aligned with tool knives, clamp material firmly in place sufficient enough to prevent shifting during cut.



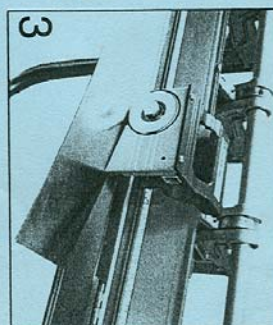
Measure cut line 1 1/2 inches from stainless steel edge.

OPERATION (cont.)

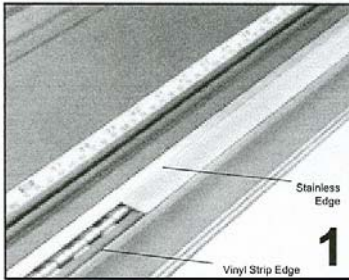
2. While facing the brake, place tool onto guide tracks and to the right of clamped material. Ensure all 4 guide bearings are properly seated onto tracks and that tool rolls freely. Insert fingers into opening to grip tool and extend along entire piece.



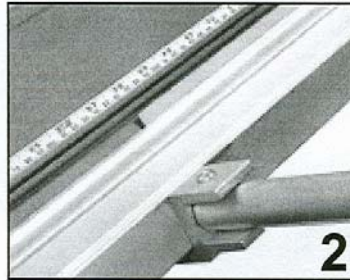
3. As tool is extended along brake, cut material lowers to ground. Prior to making cuts, ensure ground contact will not mar or damage material. Remove tool from brake after cut and prior to bending. Store tool in safe dry area when not in use.



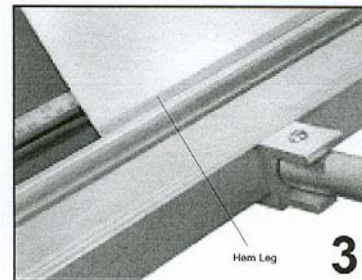
Bending Standard 3/4" Hem



Align edge of material even with edge of vinyl strip (approximately 3/4" from stainless edge). Lock in place. Note: When making odd-sized hems, place marks in material and align with stainless edge.



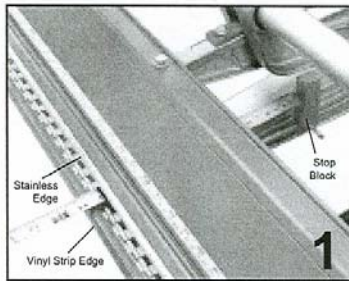
Bend material around the stainless edge as far as possible. When bending stiffer materials, release pressure and bend again to account for "spring-back". Note: If hemming heavier material, flatten hem between clamping surfaces using the locking handle before going to step 3.



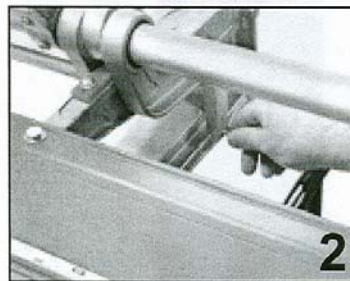
Remove material from brake and re-lock clamping surfaces. Place hem edge between vinyl strip and stainless edge. With one hand maintaining piece in position, Bend hem leg snug to material.

Using the Material Back Stops

Using the material back stops can save a considerable amount of time when either making numerous bends from the same measurement, or when scoring all your blanks at once before actually bending trim.



Open mouth of brake and insert tape against each stop block. Align desired measurement on tape with stainless edge. If using QuickScore™ scoring tool, align measurement to outer edge of vinyl strip.



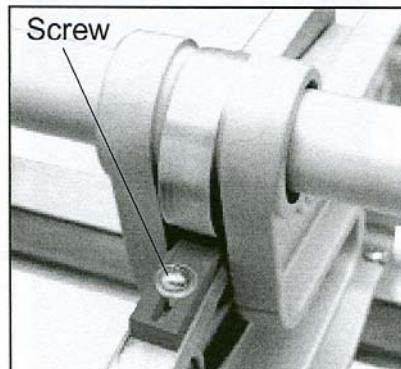
Tighten thumb screw to lock the stop block in place. Repeat tightening of opposite stop block and recheck measurements using the tape rule.



With the mouth of the brake still open, insert material up to both stop blocks and lock in place. Periodically check measurements to ensure stop block hasn't moved.

Adjusting

Capacities		
Material	Contractor	Commercial
Aluminum	0.040	0.050
Clad Metal	24 ga.	22 ga.
Copper	16 oz.	32 oz.
Galvalume	0.032	0.040
Galv. Steel	24 ga.	22 ga.
Vinyl (PVC)	all	all
Zinc	Call	Call



Adjusting Cam Wedges

Van Mark Brakes are designed to lock onto the thickness of the material and seldom require adjustment. If material is slipping while bending, or not bending evenly, follow these steps to correct:

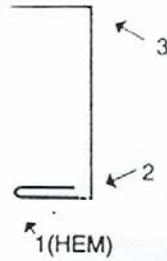
1. Lock 6"x6" test piece of material under each casting starting at one end of brake. Move piece side to side along each casting to determine if castings are providing equal resistance.

2. After determining adjustments are needed, loosen wedge screw and move wedge forward in 1/8" increments until you have equal pressure at all castings. Also bend full piece to ensure material is not slipping or warping during bend.

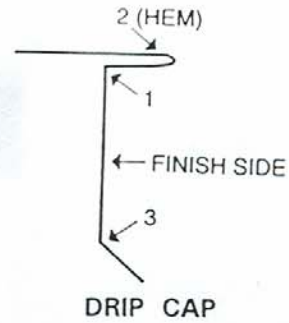
MARK 1 BENDING INSTRUCTIONS

TO MAKE A 180 DEGREE BEADED BEND

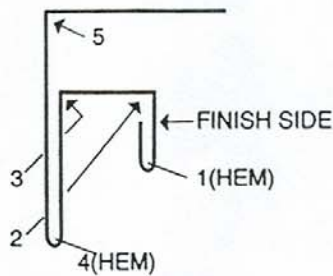
1. INSERT MATERIAL. ALIGN LAYOUT MARKS ON THE MATERIAL WITH STAINLESS BENDING EDGE OF TOP BAR
2. LOCK BRAKE AND BEND MATERIAL TO MAXIMUM OVERBEND
3. REMOVE MATERIAL AND RELOCK BRAKE
4. PLACE MATERIAL AGAINST FACE OF THE TOP BAR WITH ANGLE JUST BENT RESTING BETWEEN STAINLESS EDGE AND THE YELLOW VINYL ON FRONT HINGE
5. PULL UP ON THE FRONT HINGE TO COMPLETE THE HEM BEND



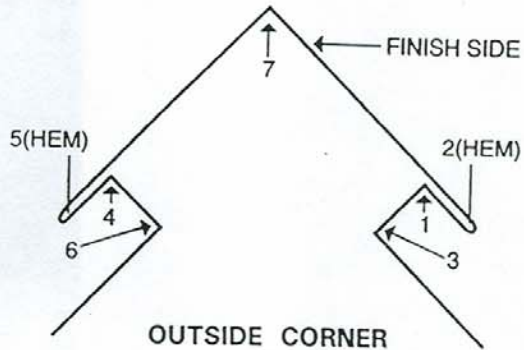
FASCIA



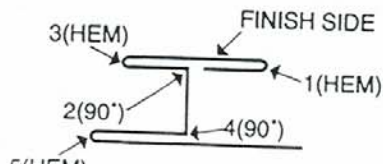
DRIP CAP



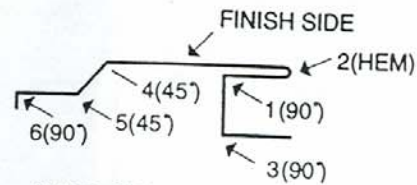
INSIDE CORNER



OUTSIDE CORNER



SOFFIT MITRE



WINDOW CASING WITH BUILT IN J-CHANNEL

Dimensions are for demonstration purposes only.
Actual dimensions will vary by job.



VAN MARK PRODUCTS CORPORATION

24145 Industrial Park Drive (248) 478-1200
Farmington Hills, MI 48335 Fax: (248) 478-1226

Call Free 1-800-VAN-MARK
E-mail vanmark@att.net

Fax Free 1-888-VAN-MARK
Website <http://www.van-mark.com>

F519 0234