

Capacities (mild steel):

4' Machine: 48" 16 ga, 24" 14 ga,
4" of 3/16"

6' Machine: 72" 16 ga, 48" 14 ga,
12" 12 ga, 4" of 3/16"

8' Machine: 96" 18 ga, 48" 16 ga,
24" 14 ga, 4" of 3/16"

Radius Brake Instructions

Basic Use

There are two common methods of positioning the material in the brake. Start by marking a line on your material that would be the midway mark of a 90 degree bend. Using this line, place the material under the top radius roller and align the mark with the "shadow line" of the top roller (straight down from the leading edge). Or, mark a line on a piece of sample material at the back edge of the machine's bed and make a bend. Measure the distance from your mark to the start of the bend. Using this measurement, you can mark your actual piece and align that mark to the back edge of the bed. The swinging motion of the lower apron roller will contact the material and lock it down against the rear bed of the machine. A typical gap of 1/4" should be set between the two rollers, but different spacing can be used to accommodate various material thicknesses. The counterweight(s) can be rotated to provide more or less assistance.



Changing the radius rollers

The upper radius bar/rollers are held on by one bolt on each end. When switching to a larger radius roller make sure to increase the gap between the upper and lower rollers first to ensure enough room for the roller to be installed without interference. Using the four adjusting bolts (2 on each side), raise upper roller so that the bottom is just above the bed of the brake but still allows the material to slide in. Then raise the lower roller to approximately 1/4" below the upper. If the radius head has a tab on one end, place that tab under the stud welded on the side frame of the machine, this locks the roller from turning during operation.

Contact Van Sant Distributing or your dealer for additional assistance on the use of your radius brake, or see instructional videos on our website or YouTube. 