

Squaring Shears

The squaring shears are used for cutting full width cuts across **SHEET METAL STOCK**. Always cut on the left side of the shears, being sure to cut **SHEET STOCK ONLY**. Keep your fingers away from the clamp and blade at all times. Keep the foot not being used to operate the treadle, clear of the treadle. Be sure to return the foot treadle slowly after finishing a cut. Capacity of this machine is 16 gauge Mild Steel (M.S.). This is equal to about 1/16" thick. As the gauge number **INCREASES** the metal thickness **DECREASES**. Thus 18 gauge is thinner than 16 gauge, and 14 gauge would be thicker. Only one person can be in the operator's safety zone at a time. As the operator of the machine, you are responsible for others in the safety zone. Watch out for all moving parts. Allow small pieces of metal being cut to drop to the floor or into a container. **NEVER** reach around behind the shear to try and catch these pieces as they are cut off.

Box and Pan Brake

The Box and Pan brake is used to bend deep bends (bends that are a long way from the edge of sheet metal). Use this machine for **SHEET STOCK ONLY**. Keep your fingers clear of the clamping fingers of the machine. Be sure you and all other classmates are clear of the machine before operating. Be particularly careful around the counterbalance and the bending leaf. **ONLY ONE PERSON** can be in the operator's safety zone at a time. Capacity of this machine is 18 gauge M.S. Adjustments are to be made by the instructor only.