



# CAUTION



## Hydra-Mechanical Press Brake

- Keep work area clean.
- Before beginning work:
  - Be sure foot pedal control is protected against accidental activation.
  - Adjust the stroke limit to set die opening to no more than  $\frac{1}{4}$  inch above thickness of material.
  - Use back gage to correctly align material to be processed.
- Never leave control mode selector keys in the machine.
- Use inch control mode for setup purposes only.
- Use die blocks during die setting.
- Use hand tools to hold workpiece.

Note: Immediately report all machinery malfunctions to the supervisor.