Operating Instructions and Parts Manual
Box and Pan Brake
Model: BP-1248H



WALTER MEIER (Manufacturing) Inc.

427 New Sanford Road
LaVergne, Tennessee 37086
Ph.: 800-274-6848
www.waltermeier.com

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Warranty and Service

Walter Meier (Manufacturing) Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these Walter Meier Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

MORE INFORMATION
Walter Meier is consistently adding new products to the line. For complete, up-to-date product information, check with your local Walter Meier distributor, or visit waltermeier.com.

WARRANTY
JET products carry a limited warranty which varies in duration based upon the product (MW = Metalworking, WW = Woodworking).

90 DAY WARRANTY

- Lathe Accessories
- Machine Accessories
- Mobile Bases
- Safety Equipment
- Specialty Items
- Vise Accessories

1 YEAR WARRANTY

- Air Tools-Contractor
- Air Tools-Industrial
- Air Tools-Light Industrial
- Lubrication

2 YEAR WARRANTY

- Body Repair Kits
- Bottle Jacks
- Cable Pullers
- Cold Saws
- Hoists-Air
- Hoists-Electric
- Metal forming
- Mill/Drills
- Milling Machines
- MW Bandsaws
- MW Drill Presses
- MW Finishing Equipment
- MW Lathes
- MW Precision Vises
- Palet Trucks
- Rigging Equip.
- Service Jacks
- Stackers
- Surface Grinders
- Tapping
- Trolleys-Air
- Trolleys-Electric
- Web Slings
- Winches-Electric

3 YEAR WARRANTY

- WW Benchtop Tools

5 YEAR WARRANTY

- Beam Clamps
- Chain Hoist-Manual
- Lever Hoists
- Pullers-JCH Models
- Scissor Lift Tables
- Screw Jacks
- Trolleys-Geared
- Trolleys-Plain
- Winches-Manual
- WW Air Filtration
- WW Bandsaws
- WW Buffers
- WW Drill Presses
- WW Dust Collectors
- WW Dust Filters
- WW Dust Fittings
- WW Jointers
- WW Lathes
- WW Planers
- WW Sanders
- WW Shapers
- WW Tablesaws

LIFE LIFETIME WARRANTY

- Fastening Tools
- Mechanics Hand Tools
- Striking Tools
- Vises (no -precision)
- Clamps

Warranty reverts to 1 Year Warranty if woodworking (WW) products listed above are used for industrial or educational purposes.

WHAT IS COVERED?
This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

WHO IS COVERED?
This warranty covers only the initial purchaser of the product.

WHAT IS THE PERIOD OF COVERAGE?
The general JET warranty lasts for the time period specified in the product literature of each product.

WHAT IS NOT COVERED?
Five Year Warranties do not cover woodworking (WW) products used for commercial, industrial or educational purposes. Woodworking products with Five Year Warranties that are used for commercial, industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

HOW TO GET SERVICE
The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option. We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the shipping and handling costs of the return.

HOW STATE LAW APPLIES
This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

LIMITATIONS ON THIS WARRANTY
WALTER MEIER (MANUFACTURING) INC., LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

WALTER MEIER SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Walter Meier sells through distributors only. The specifications in Walter Meier catalogs are given as general information and are not binding. Members of Walter Meier reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by Walter Meier.

Warnings

1. Read and understand the entire owners manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This box & pan brake is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a box & pan brake, do not use until proper training and knowledge have been obtained.
5. Do not use this box & pan brake for other than its intended use. If used for other purposes, Walter Meier (Manufacturing) Inc., disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this box & pan brake. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this box & pan brake, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead based paint.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically treated lumber.

   Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.

10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Make sure the box & pan brake is firmly secured to the floor or bench before use.
17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. **Keep children away.**

Warnings

21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall or lean against the machine or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep machine sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Make sure the work piece is securely attached or clamped to the table. Never use your hand to hold the work piece.
28. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
31. Remove loose items and unnecessary work pieces from the area before starting the machine.

Familiarize yourself with the following safety notices used in this manual:

⚠CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

- - SAVE THESE INSTRUCTIONS - -

Introduction

This manual is provided by JET covering the safe operation and maintenance procedures for a Model BP-1248H Box & Pan Brake. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance to instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or Walter Meier (Manufacturing) Inc. Walter Meier can also be reached at our web site: www.waltermeier.com.

Specifications

Model Number:	BP-1248H
Stock Number:	754100
Capacity (mild steel)	12 gauge
Bending Length Capacity	48”
Maximum Box Depth	4”
Maximum Lift of Beam	1-1/2”
Beam Adjustment	7/8”
Number of Fingers and Width	5@3”, 2@4”, 5@5”
Finger Nose Angle	45
Finger Nose Radius	1/32”
Overall Dimensions (Width x Depth x Height)	72” x 52 x 33.5”
Weight (net/gross)	2230/2420 lbs.

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, Walter Meier reserves the right to change specifications at any time and without prior notice, without incurring obligations.

⚠WARNING **Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.**

Unpacking

1. Remove the crate from around the machine.
2. Carefully clean all rust protected surfaces with a mild solvent or kerosene and a soft rag. Do not use lacquer thinner, paint thinner, or gasoline. These will damage painted surfaces.
3. Coat all machined surfaces with a light coat of oil to inhibit rust.
4. Remove the bolts holding the machine to the skid.
5. Carefully move the machine to a well-lighted area on a solid, level workbench, and secure to the bench with lag screws or bolts.

   Machine location must allow access to all sides.

Assembly

The BP-1248H does not require assembly. However, it is important to make sure that the machine is level; otherwise the brake will not bend properly.

Use a machinist's level and shims if necessary.

Adjustments

The (#) in the text refers to the *Item Number* in the *Parts Breakdown* section.

The *apron* assembly has been adjusted at the factory for use with material having the capacity as listed in the Specifications section. During shipment of this unit the machine may have come out of alignment.

The forward edge of the *holddown fingers* (41-1, 41-2, 41-3) should be adjusted parallel to the pivot edge of the clamp block. Release clamping pressure on the *holddown assembly* (34) by pushing the clamp handles (31, 32) slightly to the rear. Turn the *hand knobs* (58) to adjust for parallel.

The center of the *apron* can be adjusted by tightening the *truss nut* on the apron assembly.

Finger alignment can be achieved by loosening all cap screws (38) and rotating the *apron* (1) to the 90-degree position. Push the *fingers* forward against the *bending leaf* for proper alignment. Tighten screws (38).

Operation

Adjusting for Metal Thickness

The *holddown assembly* (34) must be adjusted to allow for clearance when making bends according to the thickness of the material. Clearance for material within four gauges of the capacity should be twice the thickness of the material. For lighter gauges use 1-1/2" times the thickness. The forward edge of the holddown fingers should be adjusted parallel to the pivot edge of the clamp block. Release clamping pressure on the holddown assembly by pushing clamp handles (31, 32) slightly to the rear. Turn the hex cap screws (58) to adjust for parallel and proper clearance. The center of the holddown can be adjusted by tightening the *truss nut* on the *holddown assembly* (34).

Adjusting the Clamping Pressure

The clamping pressure should be adjusted according to the thickness of the material. The clamping pressure should be great enough to hold the material securely in place but not so much that it is difficult to lock the *clamping handles* (31, 32). Clamping pressure can be adjusted by turning the nuts (55) on the threaded rod portion of the *yoke assembly* (29, 30).

Flange Capacity

The recommended minimum flange capacity is one inch.

Repeat Bends

Adjust the *stop collar* (48) on the *stop rod* (21) to limit the swing of the *apron* assembly.

Counter Weight

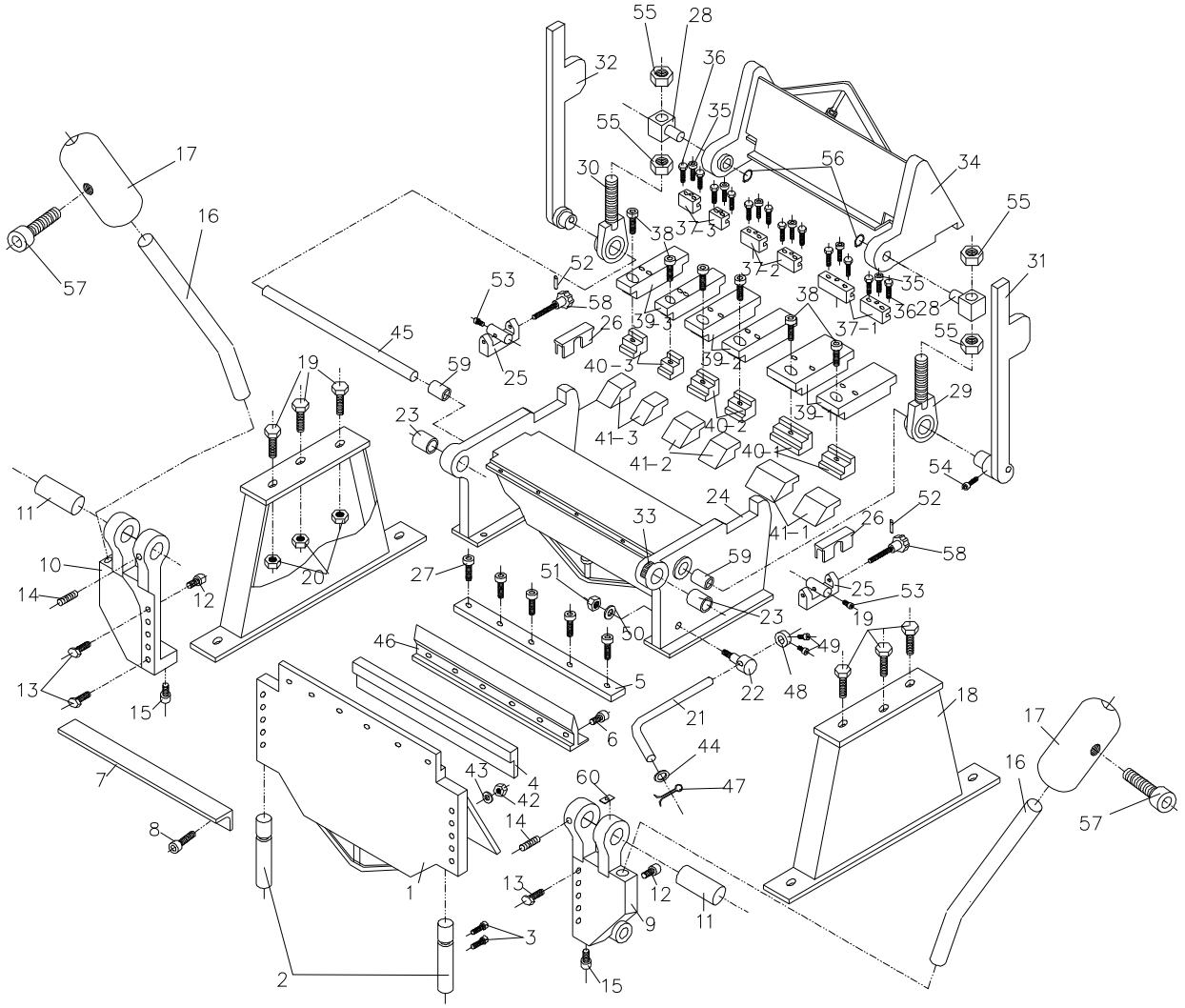
The *counter weight* (17) can be moved up or down to provide more or less leverage.

Lubrication

The machine must be lubricated every day of service with a few drops of oil. Oil pinholes are located at both yoke assemblies (29, 30) and the apron assembly (1) near the *hinge pin* (11). Lightly oil the machined parts when not in use to prevent rust.

Parts List for BP-1248H Box and Pan Brake

To order parts or reach our service department, call 1-800-274-6848, Monday through Friday (see our website for business hours, www.waltermeier.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.



Index No.	Part No.	Description	Size	Qty
1	BP1248N-1	Apron Assembly		1
2	BP1248F-02	Bend Handle		2
3	TS-1505011	Socket Head Cap Screw	M10x16	4
4	BP1248F-04	Insert Bar		1
5	BP1248F-05	Bottom Bar		1
6	TS-1505021	Socket Head Cap Screw	M10x20	9
7	BP1248F-07	Angle Bar		1
8	TS-1506021	Socket Head Cap Screw	M12x25	4
9	BP1248N-9	Hinge (R.H)		1
10	BP1248N-10	Hinge (L.H)		1
11	BP1248N-11	Hinge Pin		2
12	TS-1506041	Socket Head Cap Screw	M12x35	2
13	TS-1499141	Hex Cap Screw	M12x80	10
14	TS-1525051	Socket Set Screw	M10x25	2
15	TS-1506071	Socket Head Cap Screw	M12x50	2

16	BP1248F-16	Rod		2
17	BP1248N-17	Counter Weight Assembly		2
18	BP1248N-18	Stand Assy		2
19	TS-1492041	Hex Cap Screw	M12x40	6
20	TS-2311121	Hex Nut	Full M12	6
21	BP1248F-21	Rod Gauge Assembly		1
22	BP1248N-22	Box, Adj. Assembly		1
23	BP1248N-23	Bushing (2)		2
24	BP1248N-24	Base Assembly		1
25	BP1248N-25	Bolt Adj. Assembly		2
26	BP1248N-26	Holder		2
27	TS-1506021	Socket Head Cap Screw	M12x25	5
28	BP1248F-28	Swivel Pin Assembly		2
29	BP1248N-29	Yoke Assy (R.H)		1
30	BP1248N-30	Yoke Assy (L.H)		1
31	BP1248N-31	Clamp Handle (R.H)		1
32	BP1248N-32	Clamp Handle (L.H)		1
33	BP1248N-33	Scale		1
34	BP1248N-34	Hold Down Assembly		1
35	TS-1506021	Socket Head Cap Screw	M12x25	12
36	TS-1491081	Hex Cap Screw	M10x50	24
37-1	BP1248N-37-4	Joint Open	5"	5
37-2	BP1248N-37-3	Joint Open	4"	2
37-3	BP1248N-37-2	Joint Open	3”	5
38	TS-1491061	Hex Cap Screw	M10x40	12
39-1	BP1248N-39-4	Holder, Finger	5"	5
39-2	BP1248N-39-3	Holder, Finger	4"	2
39-3	BP1248N-39-2	Holder, Finger	3”	5
40-1	BP1248N-40-4	Washer, Finger	5"	5
40-2	BP1248N-40-3	Washer, Finger	4"	2
40-3	BP1248N-40-2	Washer, Finger	3”	5
41-1	BP1248N-41-1	Finger	5"	5
41-2	BP1248F-39	Finger	4"	2
41-3	BP1248F-38	Finger	3”	5
42	TS-2311121	Hex Nut	Full M12	10
43	TS-2361121	Lock Washer	M12	10
44	TS-2360121	Flat Washer	M12	1
45	BP1248N-45	Bracket Bar		1
46	BP1248N-46	Insert Clamp Bar		1
47	BP1248N-47	Cotter Pin	2.5x18	1
48	BP1248N-48	Stop Collar		1
49	TS-1505021	Socket Head Cap Screw	M10x20	2
50	TS-2360121	Flat Washer	M12	1
51	TS-2311121	Hex Nut	M12	1
52	BP1248N-52	Spring Pin	5x30	2
53	TS-1525041	Socket Set Screw	M10x20	2
54	TS-1506071	Socket Head Cap Screw	M12x50	2
55	TS-2311241	Hex Nut	Full M24	4
56	BP1248N-56	Clip Ring 38		2
57	TS-1506041	Socket Head Cap Screw	M12x35	2
58	BP1248N-58	Knob Lock		2
59	BP1248N-59	Bushing (1)		2
60	BP1248N-60	Angle Scale		1