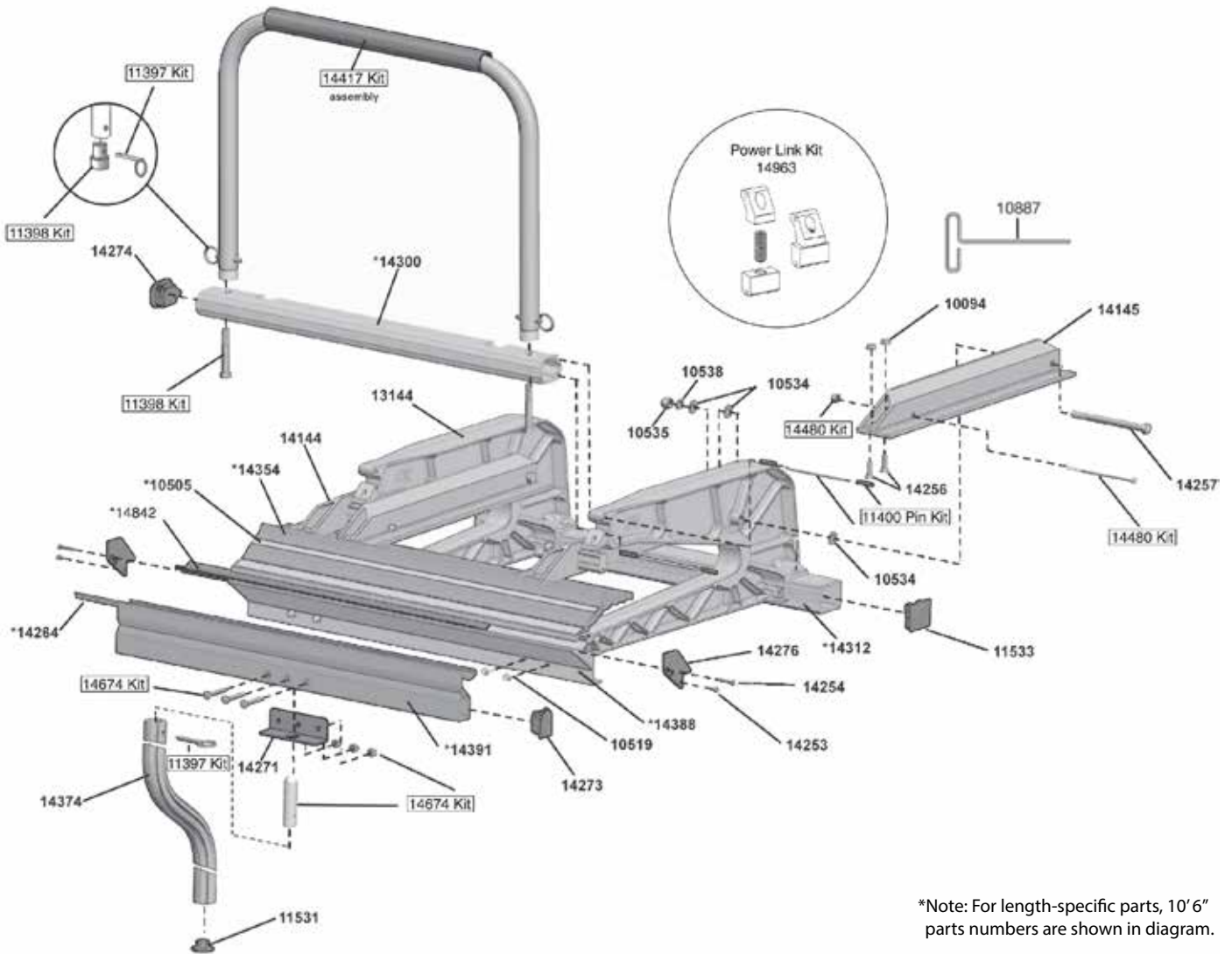


SUPERMAX[®]
OPERATIONS MANUAL
MAX STAND™ • MAX CUT-OFF™



SUPERMAX® Brake Parts List



*Note: For length-specific parts, 10'6" parts numbers are shown in diagram.

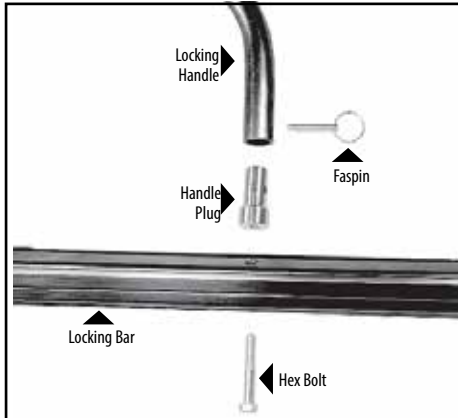
Item #	Description
10491	8'6" Stainless Edge
10492	10'6" Stainless Edge
10493	12'6" Stainless Edge
10504	12'6" Tape Measure
10505	10'6" Tape Measure
10506	8'6" Tape Measure
10519	¼ -20 x ¾" Hex Wash HD Sc
10534	3/8" Flat Washer
10535	3/8-16 Nylock Hex Nut
10538	Washer Lock 3/8
10887	T-Handle Hex Key
11397	¼" x 1¼" Faspin Kit (4)
11398	Locking Handle Plug Kit
11400	Locking bar Pin Kit
11531	Lifting Handle Cap
11533	Back Rail Cap
13144	C Casting SUPERMAX
14144	Pivot Arm - Left
14145	Pivot Arm - Right
14253	8-32 x 5/16" Phil Pan HD SC

Item #	Description
14254	8-32 x 1" Phil Pan HD Sc .
14256	¼ -20 x 1" FL HD Sc
14257	3/8-16 x 5" Hex Cap Bolt 2
14263	8'6" Rubber Strip
14264	10'6" Rubber Strip
14265	12'6" Rubber Strip
14841	Wear Strip 99" SUPERMAX 2 pcs.
14842	Wear Strip 123" SUPERMAX 2 pcs.
14843	Wear Strip 147" SUPERMAX 2 pcs.
14271	Lifting Handle Support Bracket (2)
14273	Moving Hinge Cap
14274	Locking bar Cap
14276	Fixed Hinge Endcap
14299	8'6" Locking bar
14300	10'6" Locking bar
14301	12'6" Locking bar
14311	8'6" Back Rail

Item #	Description
14312	10'6" Back Rail
14313	12'6" Back Rail
14353	8'6" Locking Anvil
14354	10'6" Locking Anvil
14355	12'6" Locking Anvil
14374	Lifting Handle Assembly
14387	8'6" Fixed Hinge
14388	10'6" Fixed Hinge
14389	12'6" Fixed Hinge
14390	8'6" Moving Hinge
14391	10'6" Moving Hinge
14392	12'6" Moving Hinge
14417	MAX Hemming Handle Assembly
14456	SUPERMAX™ Brake Parts Bag 8'
14457	SUPERMAX™ Brake Parts Bag
14480	Bolt and Nut Kit
14674	Lifting Handle Plug Kit (2)
14963	Power Link Kit 6

Setting up the SUPERMAX® Brake

Locking Bar Installation

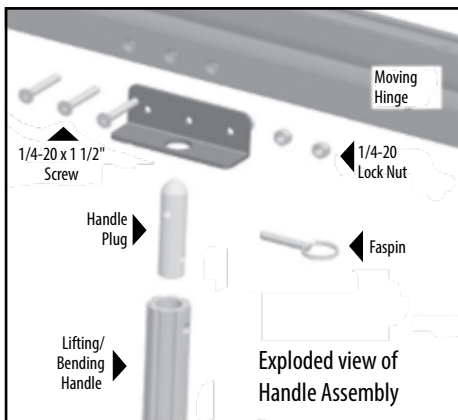


MAX Locking Bar Assembly includes:
(2) Locking bars, (4) Handle Plugs,
(4) Faspins, (4) Hex Bolts



1. Insert Hex Bolt through Locking bar of your SUPERMAX™ Brake and into the base of Locking bar(s) as indicated using the 3/8" Hex Bolts provided. **HAND TIGHTEN ONLY.** Repeat for other side.
2. Attach the Locking bar over the Handle Plugs and secure them with Faspins. Now tighten the 3/8" Hex Bolts with a 9/16" Wrench. Handle can be detached from now on by simply removing the Faspins.

Lifting/Bending Handle Installation



1. First insert one end of the Handle Plug into Lifting / Bending Handle and install Faspin through holes.
2. Next, insert Handle Assembly into hole in bottom of Moving Hinge. Align hole in hinge with Handle Plug and insert screw using Phillips Screw Driver as shown. Secure with 1/4-20 Lock Nut

Repeat for other handles. To remove handles, simply remove Faspins. Always use more than one handle when bending.

Power Link Adjustment

IMPORTANT: The Power Links on your Tapco Brake have been pre-set at the factory for average holding capacity and ease of operation. However, the Power Link Stud allows you to adjust the brake to your specific bending needs. It is important that you follow these steps when you adjust your Brake to ensure proper gripping tension and maximum performance. **CAUTION:** overtightening the Link Stud can result in damage to brake components.

First check the uniformity of the clamping pressure along the entire length of your Tapco Brake by using the following method.

TO TEST

Cut some narrow strips, approximately 2" x 4", of aluminum or use strips from stock you will be using and lock one under each shoe casting as indicated in **Figure 1**. Lightly pull the material in a side to side and outward motion to determine the tightness and uniformity of each Power Link. Refer again to **Figure 1**. If the material can be moved when the handle is locked or if it requires excessive pressure to lock the handle down on the material then the Power Link may need adjustment.

NOTE: All adjustments are made with the Tapco Brake in the "open" position. All adjustments are tested with strips of material placed in the Brake in the "locked" position.

TO ADJUST

1. Insert the 3/16" hex wrench into the Power Link Stud (Fig. 2).
2. Turn a 1/4 to 1/3 turn either **CLOCKWISE** to **INCREASE** locking tension or **COUNTER-CLOCKWISE** to **DECREASE** locking tension.
3. Adjust each shoe casting until all are uniform.

Repeat test step above to check tension.

Power Link Stud

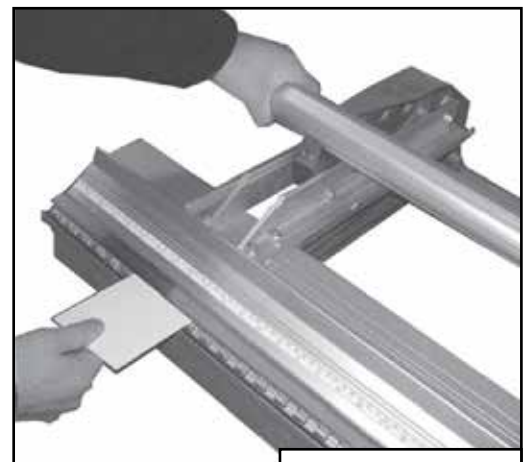


Figure 1

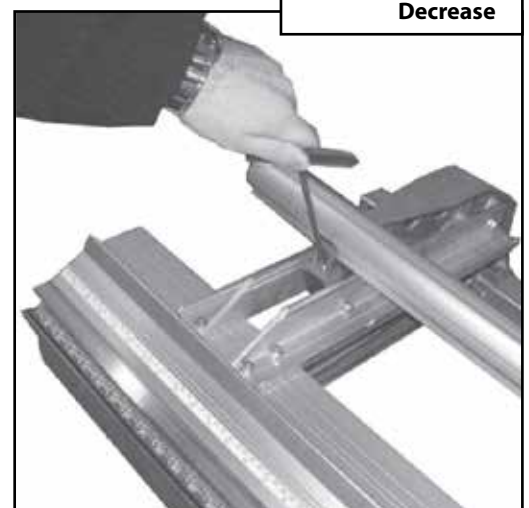
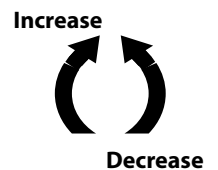
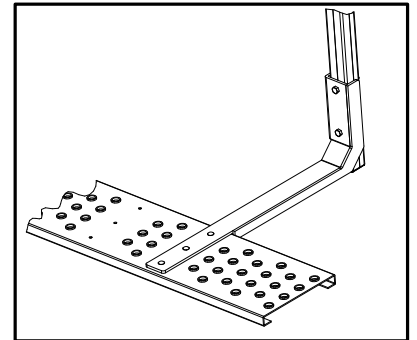
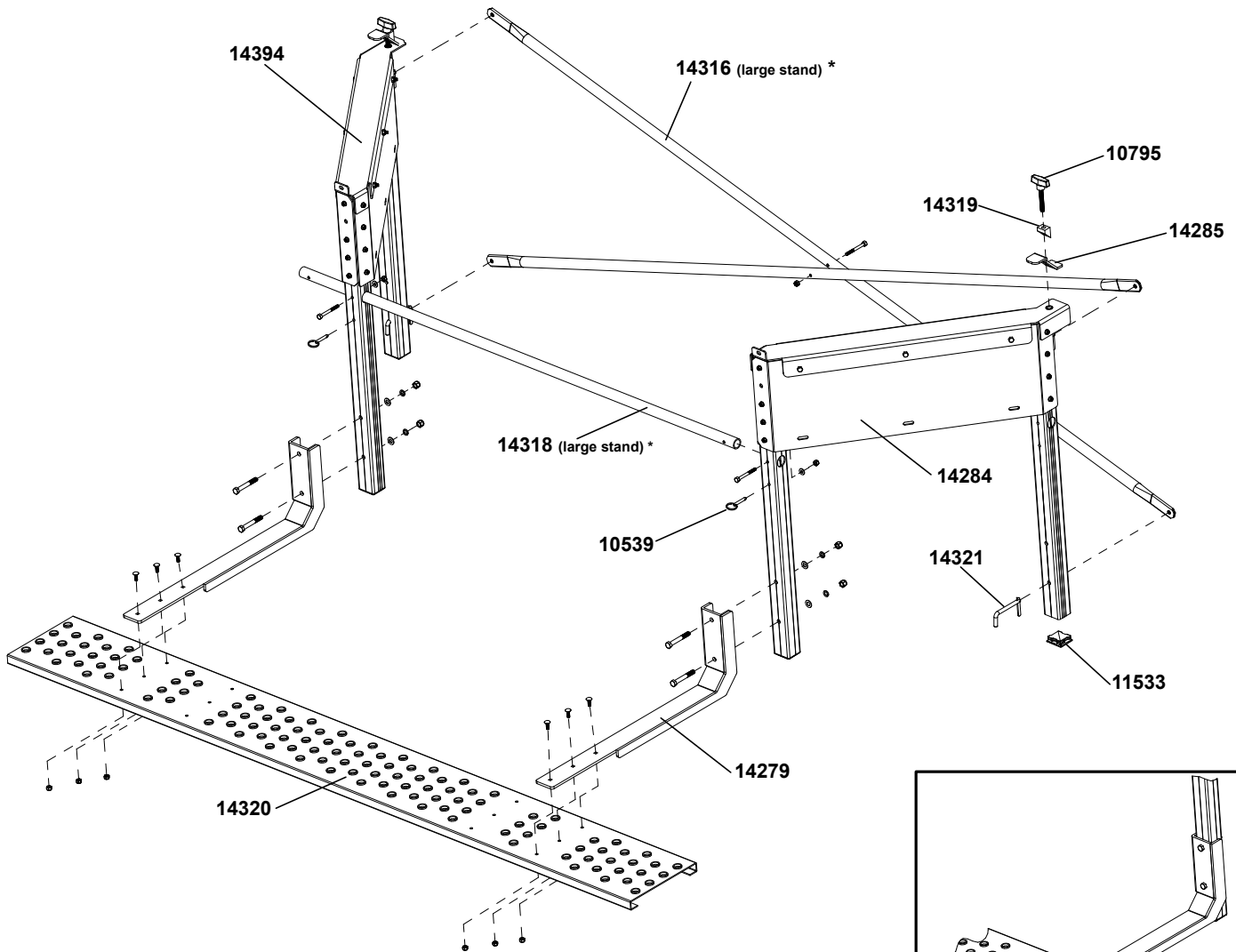


Figure 2

MAX Stand® Parts List



Item#	Description
10539	1/4" x 1 1/4" Faspin
10795	3/8-16 x 2 1/2 T-Knob
11533	Back Rail Endcap
14279	Stand Counter Balance Bracket
14284	Right Stand Leg Assembly
14285	Back Rail Clamp
14316	Rear Cross Tube (large stand)
14318	Front Support Tube (large stand)
14319	Back Rail Clamp Wedge
14320	Stand Counter Balance Plank
14321	Toggle Pin
14394	Left Stand Leg Assembly
14402	Front Support Tube (small stand)
14403	Rear Cross Tube (small stand)

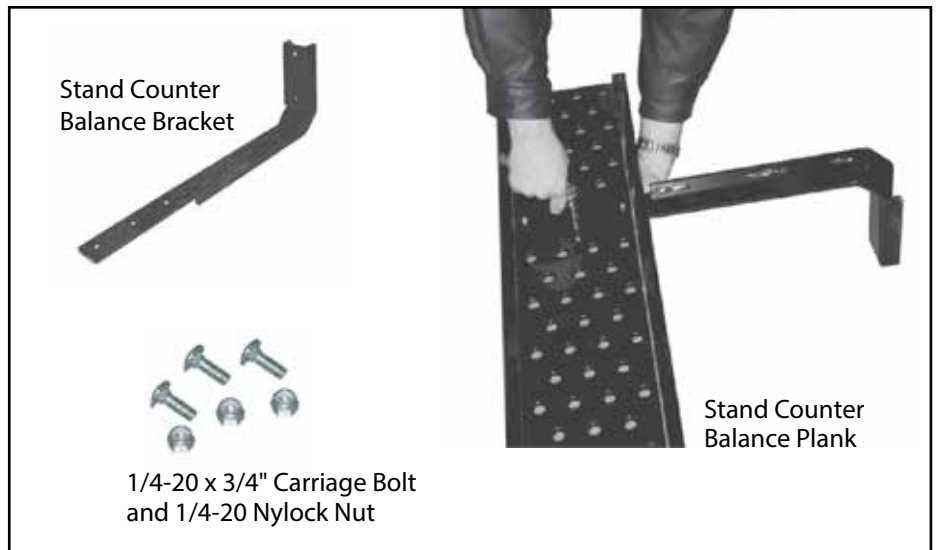
MAX Stand® Set-up

Hardware Requirements: (2) 7/16" and (2) 9/16" Open End Wrench.

STEP 1

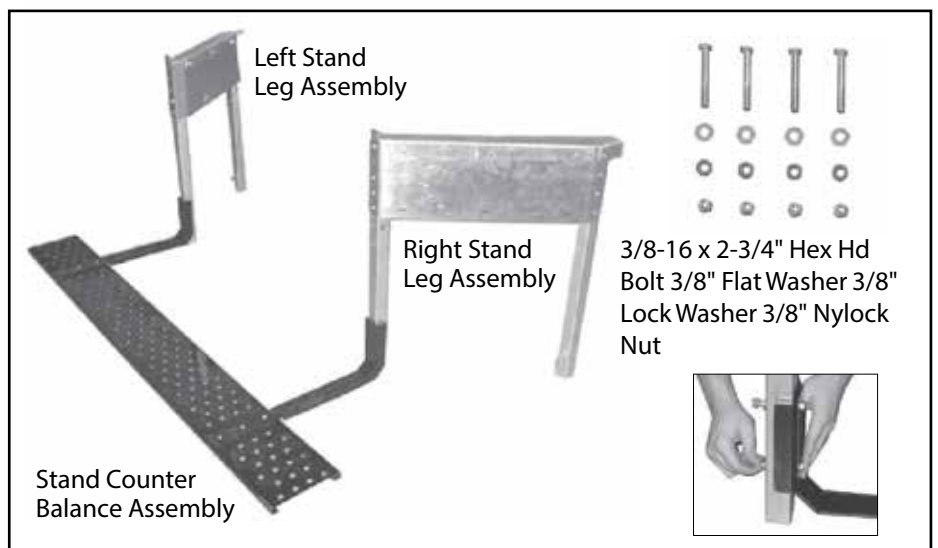
Attach Stand Counter Balance Brackets to Plank with Carriage Bolts and Nylock Nuts using a 7/16" Socket or Open end Wrench.

Counter Balance is required for operation.



STEP 2

Slide Stand Counter Balance Assembly up to the Stand Legs. Insert the 3/8-16 x 2-3/4" Hex Bolts through the Stand Counter Balance Bracket and Leg as shown in Figure 2. Use a 9/16" wrench to tighten down 3/8-16 Nylock Nut.



STEP 3

Insert Front Support Tube through both Right and Left Legs as shown in Figure 3. Next slide the 1/4-20 x 2-1/2" bolt through the Stand Leg and Support tube. Use the 7/16" wrench to secure the Support Tube in place with 1/4-20 Nylock Nuts.

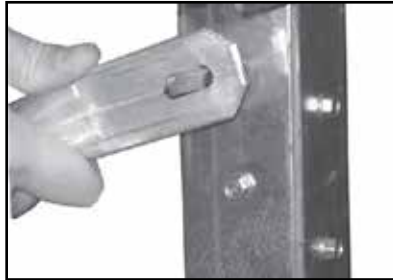


MAX Stand® Set-up

STEP 4

Rotate the Toggle Pin 90 degrees and slide the Rear Cross Tube onto the Pin. To secure the Tube in place allow the arm on the Toggle Pin to drop down. Repeat steps in all locations.

Rotate arm on Toggle Pin to insert Rear Support Tube.



Toggle Pin in Locked position.



Toggle Pin (locked)



Toggle Pin (unlocked)



Rear Cross
Tube Assembly

Installing the Stand

STEP 5

Align the hole in the Fixed Hinge with the Slot on the Stand Top Bracket (see 5a).

Insert Faspin through the Stand Top Bracket and into the Fixed Hinge to secure Brake in place (see 5b).

The Brake must be secured with Faspins on the Left and Right Stand Leg Assemblies.

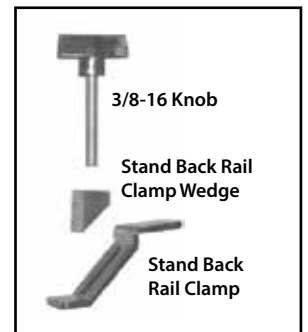
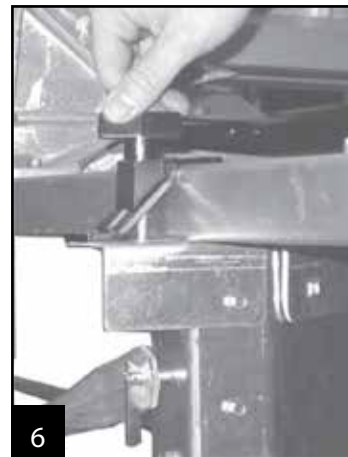
Using two people, set Brake on Stand with the hinges above the Front Support Tube.



STEP 6

Place Back Rail Clamp on the Back Rail. Slide Knob through the Wedge and turn clockwise into the Threaded Insert (see 6).

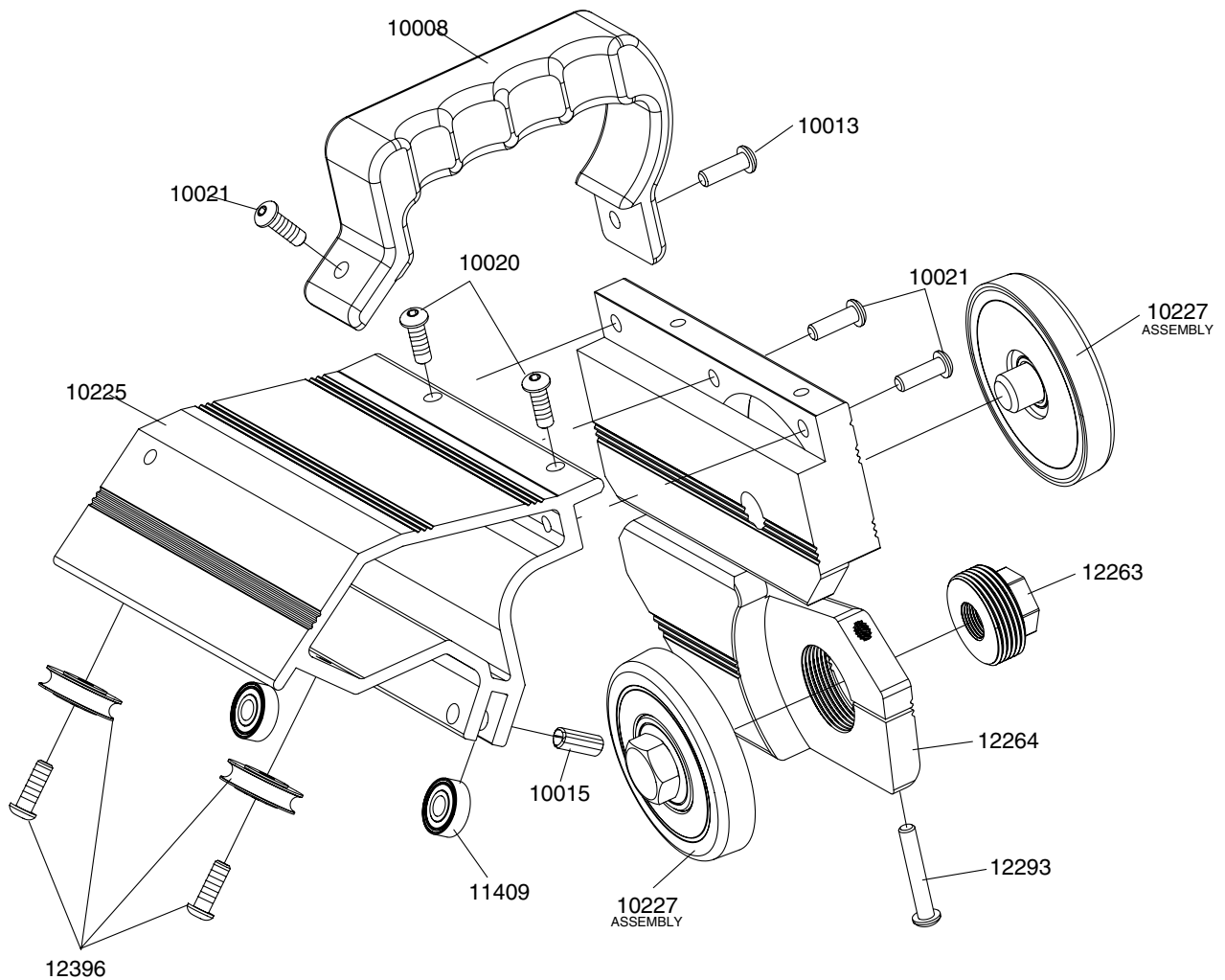
Back Rail Clamp Assembly must be attached on Left and Right Stand Leg Assemblies.



Removing a SUPERMAX[®] Brake from MAX Stand[®]

- Removing the brake from the MAX Stand is essentially the opposite of attaching it to the stand.
- Remove the Back Rail Clamp Assembly from the Stand.
- Lift the Moving Hinge and remove the Faspins and place in the Stand Leg Faspin storage hole

Adjustable MAX Cut-Off Parts



Item #	Description
10225	Bridge
10008	Handle
12264	Adjustable MAX Cut-Off Body
11409	Cut-Off Guide Bearing Kit (2) Guide Bearing (10016) (2) 5/16" Roll Pin (10015)
12396	(2) Flange Track Bearing Kit* Wide Flange Track Bearing (12334) (2) 1/4-20 x 5/8" Hex Button Hd Screw (12364)
11393	Track Bearing Kit (not shown) (2) Track Bearing (10012)
10021	1/4-20 x 1" Hex Button Hd Screw
10020	1/4-20 x 5/8" Hex Button HD Screw
10013	1/4-20 x 1-1/4" Button Hd Screw
10227	MAX Knife Assembly** Knife (10226), Bearing (10231) Nut (10232), .125 Shim
10349	Coupling Nut (hook, not shown)
10519	1/4-20 X 3/4" Hex Wash Hd Screw (not shown)
11404	Material Stop Kit (not shown) (2) Material Stop (10740) (2) 1/4-20 Knurled Knob (10776) (2) Cut-Off Tape Measure (10023)
12263	Adjusting Nut
12293	1/4-20 x 1-1/2" Socket Head Cap Screws

* This kit replaces the Track Bearing Kit 11393. Both are still available for purchase.

** Please contact Customer Service if these parts need to be replaced.

Setup for Adjustable MAX Cut-Off

LIST OF PARTS:

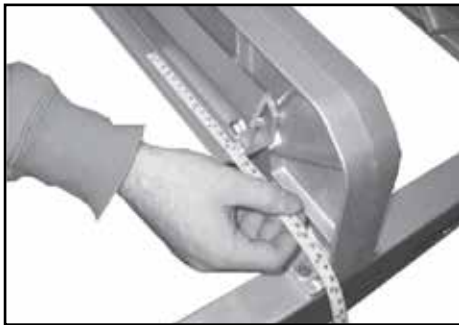
- (1) Adjustable MAX Cut-Off
- (2) SUPERMAX Material Stop Kit #14485

Tools Needed for Initial Set Up:

- hammer, punch or nail set, 9/16" wrench, Phillips screw driver.

IMPORTANT! Read this safety information before using product.

1. Always keep hands and fingers clear of the knives during all phases of use.
2. 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.
3. Remove cut-off from anvil 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.
4. Never use tool to cut material not firmly clamped in brake.



1. Slide measuring tapes into Pivot Arm slots from rear of Pivot Arm till they stop. Tape measures take into account 1 1/2" difference between the bending edge and the shear point of Cut-Off for accurate cuts.



2. Slide material stop onto Pivot Arms from rear as shown. Note: Recommended locations are on the second castings in from each end of your brake.



3. Secure the tape measures in place by "punching" down the edge of the pivot arm onto the tape measure. Use a standard nail set or punch.

Care and Maintenance

Items Needed

- Clean Cloth
- WD-40® or equivalent
- Phillips Head Screw Driver

Wear Strip and Rubber Strip

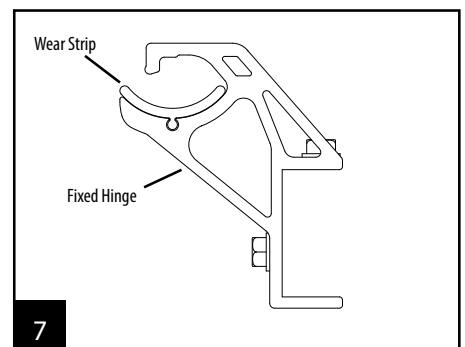
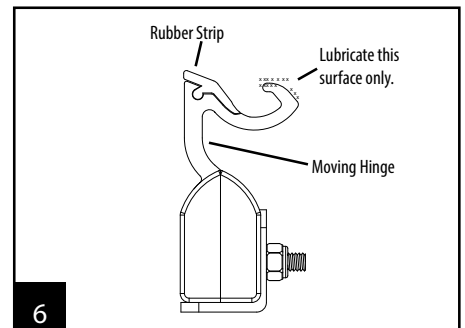
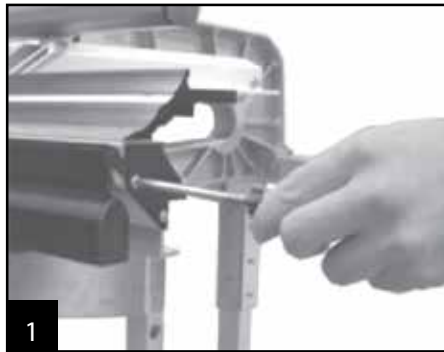
- Use a Phillips head screw driver to loosen the screw enough to allow the Endcap to be removed by sliding it off of the screw (see Figure 1 & Figure 2).
- With the Endcap removed, slide the Moving Hinge half way down the length of the Fixed Hinge exposing the Wear Strip and Rubber Strip on the Fixed and Moving Hinges (see Figure 3).
- Use a clean cloth to wipe the portions of the Wear Strip and Rubber Strip that are exposed (see Figures 4-7).
- At this time WD-40® or equivalent should be used on cleaned Moving Hinge surfaces to reduce wear and friction. (see Figure 6)
- Return the Moving Hinge to the working position and repeat steps 1 thru 4, sliding the fixed hinge in the opposite direction.
- Slide Moving Hinge back into working position.
- Reattach Endcaps

Clamping Surfaces

- Clean Clamping Surface each day before using. Use only clean shop towels that are free of dirt, oil and metal chips.
- Do not use your SUPERMAX™ Brake around saw tables as the cuttings may get in between clamping surfaces or hinges and cause excessive wear or material scratching.
- If material is getting scratched, examine the Stainless Bending Edge, Fixed Hinge, or Moving Hinge for roughness or burrs. Remove burrs with emery cloth or replace excessively worn parts.

Transportation

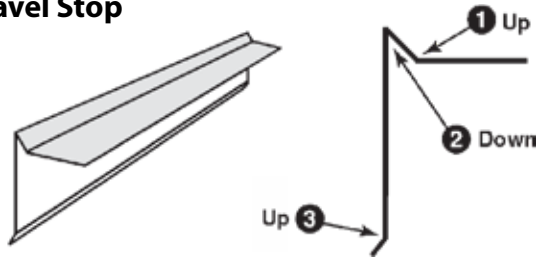
- The SUPERMAX™ Brake should be transported in the unlocked position unless a piece of cardboard or vinyl siding is clamped between the clamping surfaces.



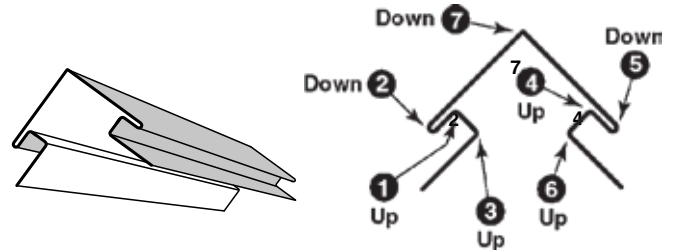
Examples of BASIC Shapes

NOTE: UP and DOWN refers to the clad, painted or FINISH SIDE of the material as it is placed into the Bender.

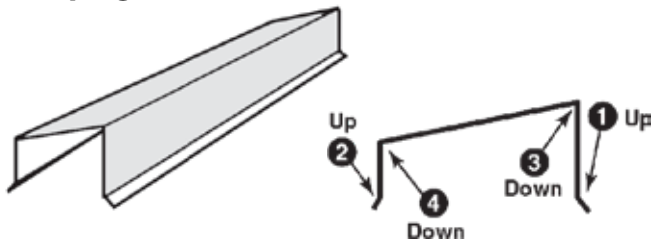
1. Gravel Stop



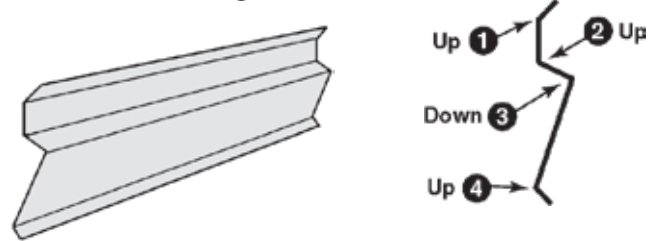
6. Outside Corner



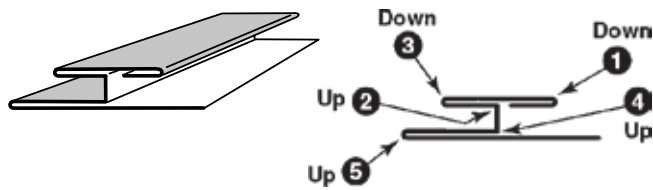
2. Coping Cover



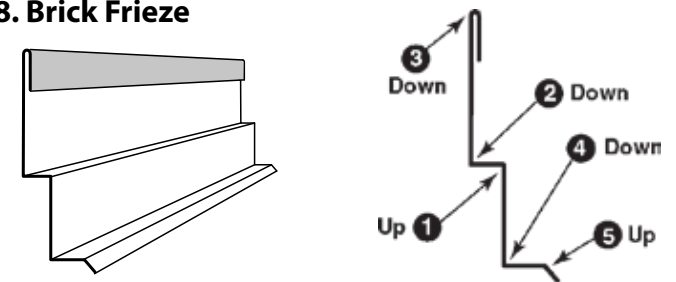
7. Counter Flashing



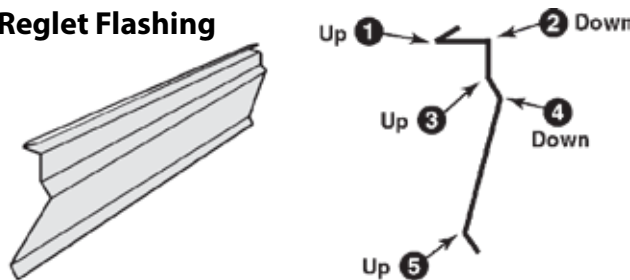
3. One Piece Soffit Mitre



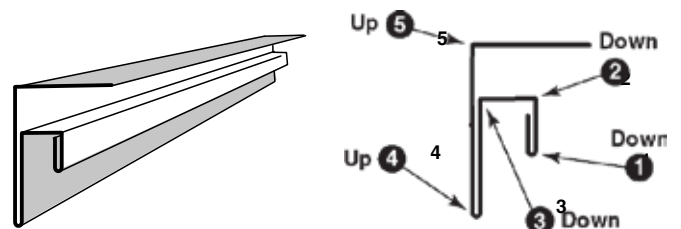
8. Brick Frieze



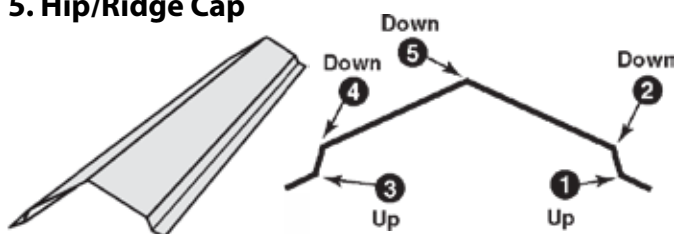
4. Reglet Flashing



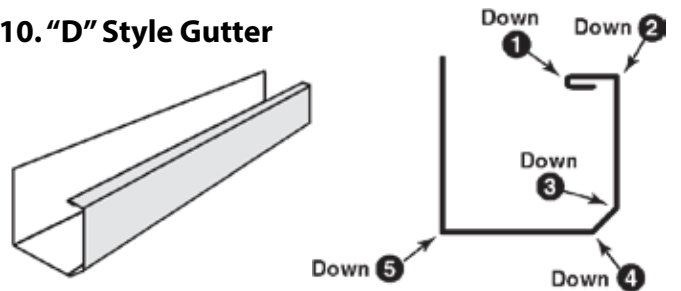
9. "F" Channel/Inside Corner



5. Hip/Ridge Cap



10. "D" Style Gutter



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