VEVOR W-1.0X1220

VEVOR 48-Inch Box and Pan Brake Instruction Manual

Model: W-1.0X1220

Overview Setup Operation Maintenance Troubleshooting Specifications Safety Information Product Warranty & Support

1. Safety Information

Read and understand all safety warnings and instructions before operating this machine. Failure to follow the warnings and instructions may result in electric shock, fire, and/or serious injury.

- Always wear appropriate personal protective equipment, including safety glasses and gloves, when operating the box and pan brake.
- Ensure the machine is securely mounted to a stable workbench before use.
- Keep hands and fingers clear of the bending area during operation.
- Do not attempt to bend materials exceeding the specified maximum thickness or width.
- Keep children and bystanders away from the operating area.
- Inspect the machine for any damage or loose parts before each use. Do not operate if damaged.

2. Product Overview

The VEVOR 48-Inch Box and Pan Brake is designed for precise bending of various sheet metals. Its robust construction and adjustable features make it suitable for both professional and DIY applications.

Key Features:

- **Mini Sheet Metal Brake:** Maximum bending width of 48 inches (1220 mm). Features a 0.31" thick blade and reinforced rib design for excellent bending results.
- **Capacity:** Effortlessly accommodates 20-gauge low carbon steel and 14-gauge aluminum.
- **Convenient Usage:** Integrated press plate design secures sheet metal without external clamps. Simple installation of two power handles for efficient processing.
- **Flexible Bending:** Adjustable bending angle from 0° to 135° to meet diverse work requirements.

- **Heavy-Duty Steel Construction:** Crafted from Q235 steel for durability. Compact design allows for workbench mounting or portability.
- **Wide Application:** Suitable for bending stainless steel, copper, aluminum, iron, galvanized, and other steel sheets in various settings.

Figure 2.1: VEVOR 48-Inch Box and Pan Brake, Model W-1.0X1220.

3. Setup

3.1 Unpacking and Inspection

- Carefully remove all components from the packaging.
- Verify that all included components are present: 1 x User Manual, 2 x Locking Knob Bolts, 2 x Power Handle.
- Inspect the machine for any signs of damage during transit. Contact customer support if any damage is found.

3.2 Mounting the Brake

The box and pan brake must be securely mounted to a stable workbench or surface before operation to ensure safety and stability.

- Position the brake on your workbench.
- Utilize the mounting holes on the heavy angle iron sides of the brake.
- Secure the brake using either lag screws (for permanent installation) or heavy-duty clamps (for temporary setup).

Figure 3.1: Securely mounting the box and pan brake to a workbench using clamps.

3.3 Attaching Power Handles

- Insert the two power handles into the designated slots on each side of the bending bar.
- Secure the handles using the provided locking knob bolts. Ensure they are tightened sufficiently to prevent movement during operation.

4. Operation

4.1 Preparing the Sheet Metal

- Measure and mark your desired bend line on the sheet metal.
- Ensure the sheet metal is clean and free of debris.

4.2 Clamping the Material

- Loosen the locking knob bolts to allow the press plate to lift.
- Slide the sheet metal under the press plate, aligning your marked bend line with the edge of the bending bar.

- Tighten the locking knob bolts firmly to secure the sheet metal. The integrated press plate design eliminates the need for external clamps.

Figure 4.1: Integrated press plate design for fixing metal sheets.

4.3 Bending the Sheet Metal

- Grasp both power handles firmly.
- Apply even pressure to lift the bending bar, slowly bending the sheet metal to the desired angle.
- The brake is designed to automatically stop at a 90-degree angle. For angles greater than 90 degrees (up to 135 degrees), you may need to adjust the bending bar.

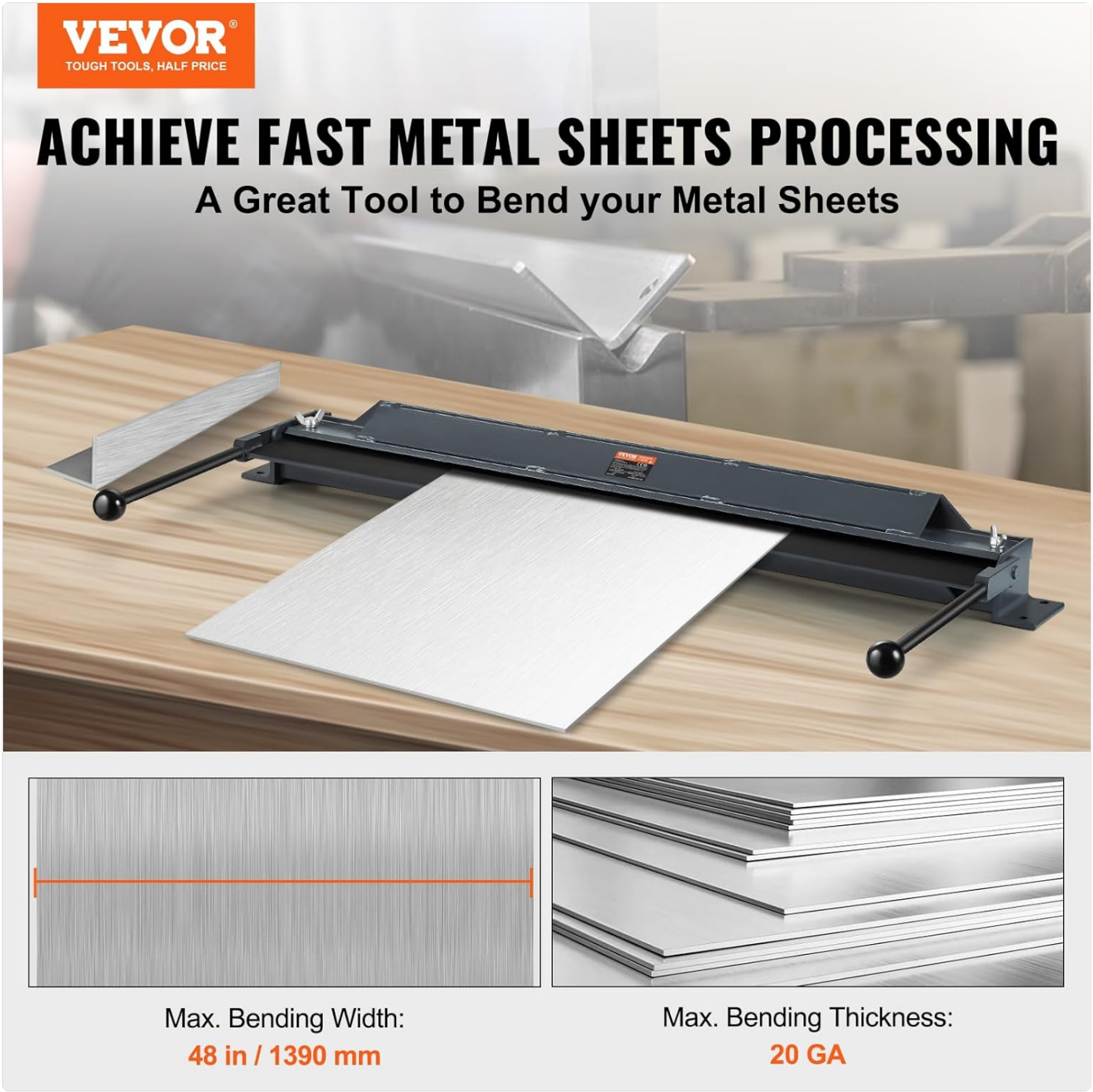

Figure 4.2: Bending sheet metal with the VEVOR Box and Pan Brake.

4.4 Adjusting Bending Angle (0-135°)

- For angles greater than 90 degrees, the bending bar can be flipped.
- Loosen the locking knob bolts and carefully remove the bending bar.
- Flip the bending bar to its alternative position and re-insert it, securing it with the locking knob bolts. This allows for bends up to 135 degrees.

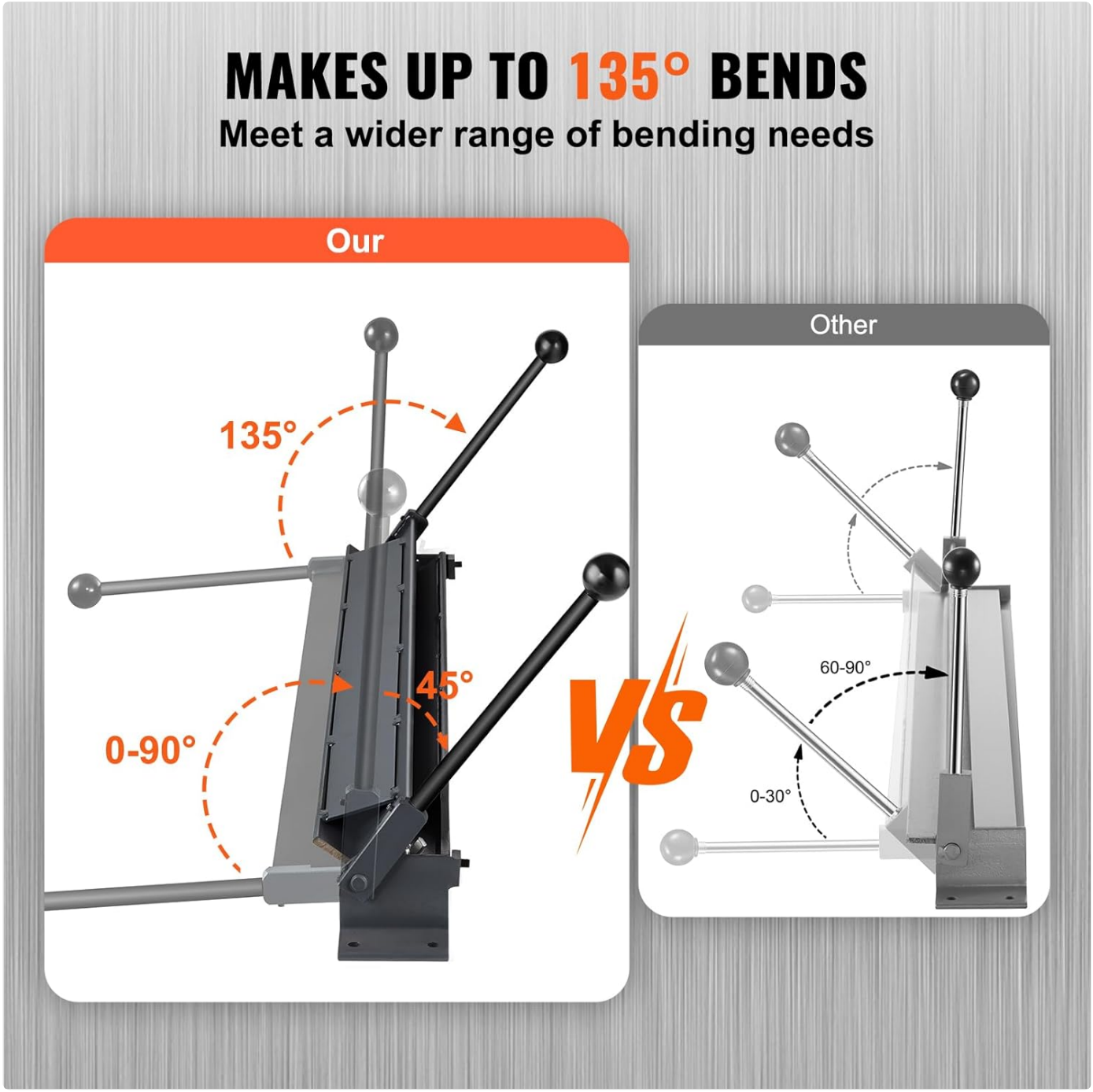

Figure 4.3: The VEVOR Box and Pan Brake offers flexible bending up to 135 degrees.

5. Maintenance

5.1 Cleaning

- After each use, wipe down the machine with a clean cloth to remove metal shavings and dust.
- Periodically clean the bending blade and press plate to ensure smooth operation and prevent material buildup.

5.2 Lubrication

- Apply a light coat of machine oil to moving parts and pivot points as needed to prevent rust and ensure smooth articulation.

5.3 Storage

- Store the box and pan brake in a dry environment to prevent corrosion.

- If storing for extended periods, consider applying a rust preventative to exposed metal surfaces.

6. Troubleshooting

6.1 Handles Not Fully Inserting

- If the power handles do not fully insert into the receiving holes, it may be due to manufacturing debris or paint buildup.
- Use a drill bit (e.g., 25/64 inch, slightly larger than 3/8 inch) to carefully clear out the receiving holes.
- Loosen the set screws on the handle mounts before drilling, then re-tighten after inserting the handle.

6.2 Inconsistent Bends

- Ensure the sheet metal is clamped securely and evenly across the entire bending width.
- Verify that the locking knob bolts are tightened sufficiently.
- Check for any debris on the bending bar or press plate that might interfere with the bend.

6.3 Difficulty Bending Material

- Confirm that the material thickness and type are within the machine's specified capacity (e.g., 20-gauge low carbon steel, 14-gauge aluminum).
- Apply even and firm pressure to both power handles during the bending process.

7. Specifications

Feature	Detail
Model Number	W-1.0X1220
Material	Q235 Steel
Maximum Bending Width	48 ± 0.6 inches / 1220 mm ± 15 mm
Maximum Bending Thickness (Low Carbon Steel)	20 Gauge
Maximum Bending Thickness (Aluminum)	14 Gauge
Maximum Bending Angle	0° - 135° ± 1°
Weight	61.7 lbs / 28 kg
Dimensions (L x W x H)	54.7 x 17.7 x 6.1 inches / 1390 x 450 x 155 mm
Power Source	Hand-powered
Included Components	1 x User Manual, 2 x Locking Knob Bolts, 2 x Power Handle

Figure 7.1: Detailed dimensions and key specifications of the VEVOR Box and Pan Brake.

Figure 7.2: Versatile applications for bending various metal sheets including stainless steel, copper, aluminum, iron, steel, and galvanized steel.

8. Warranty & Support

For warranty information or technical support, please refer to the official VEVOR website or contact their customer service directly. Keep your purchase receipt and model number (W-1.0X1220) handy for faster service.
This product is eligible for a 30-day easy return policy. Protection plans are also available for extended coverage.