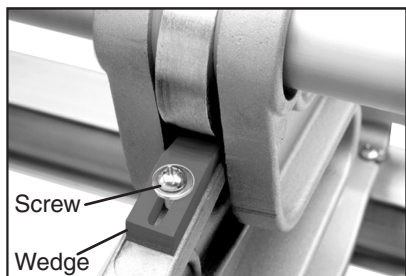


Optional  
UniStand™ USA1

## Making Fine-Tune Adjustments



Your Van Mark brake has been pre-adjusted at the factory for optimum performance. Should you want to Fine-Tune your machine, follow the basic steps outlined below.

**STEP 1.** Cut 4 inch square samples of material you want to adjust your brake to bend (1 for each casting).

**STEP 2.** Insert 2 inches of the samples into the mouth of the brake at each casting. Lock brake.

**STEP 3.** Attempt to pull each sample straight out and determine through feel that each one is held with equal pressure. If you can pull a sample out, that casting requires adjustment.

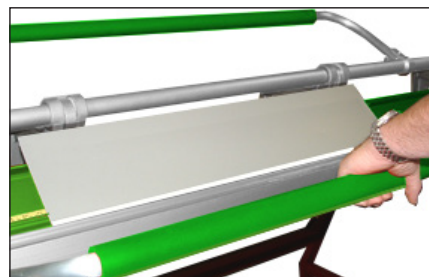
**STEP 4.** To make adjustment, open brake and loosen screw. Slide wedge toward back of brake an 1/8 inch then re-tighten and retest. Repeat step until desired locking pressure is achieved.

## Making a Basic Hem

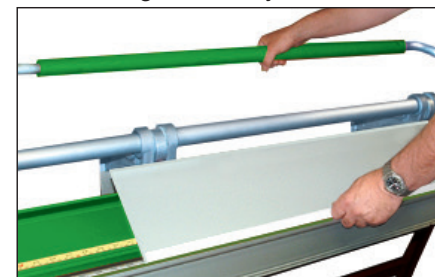
Use the following procedure as a guideline for forming hems in your trim work.



**A.** Insert material into brake to your measurements and lock brake. Bend flat against stainless strip. Unlock brake, remove material, then re-lock.



**C.** Rotate front hinge up to flatten angle against F-Bar to complete hem. Note: It is recommended that you make practice bends with scrap until satisfied with results.



**B.** Place material against F-Bar with angle of material just bent set between Stainless edge and front hinge.



**D.** Standard Hem. Hems can be formed on all Mark Series™ brakes, TrimMaster® brakes and Metal Master® 20 brakes. Visit [www.van-mark.com](http://www.van-mark.com) for more tips and ideas.

## Instructions for Making Basic Shapes

The shapes below are based on common profiles used on many job sites. The exact measurements of each bend may vary from job to job, trim piece to trim piece. We recommend making practice bends with scrap until satisfied with results.

