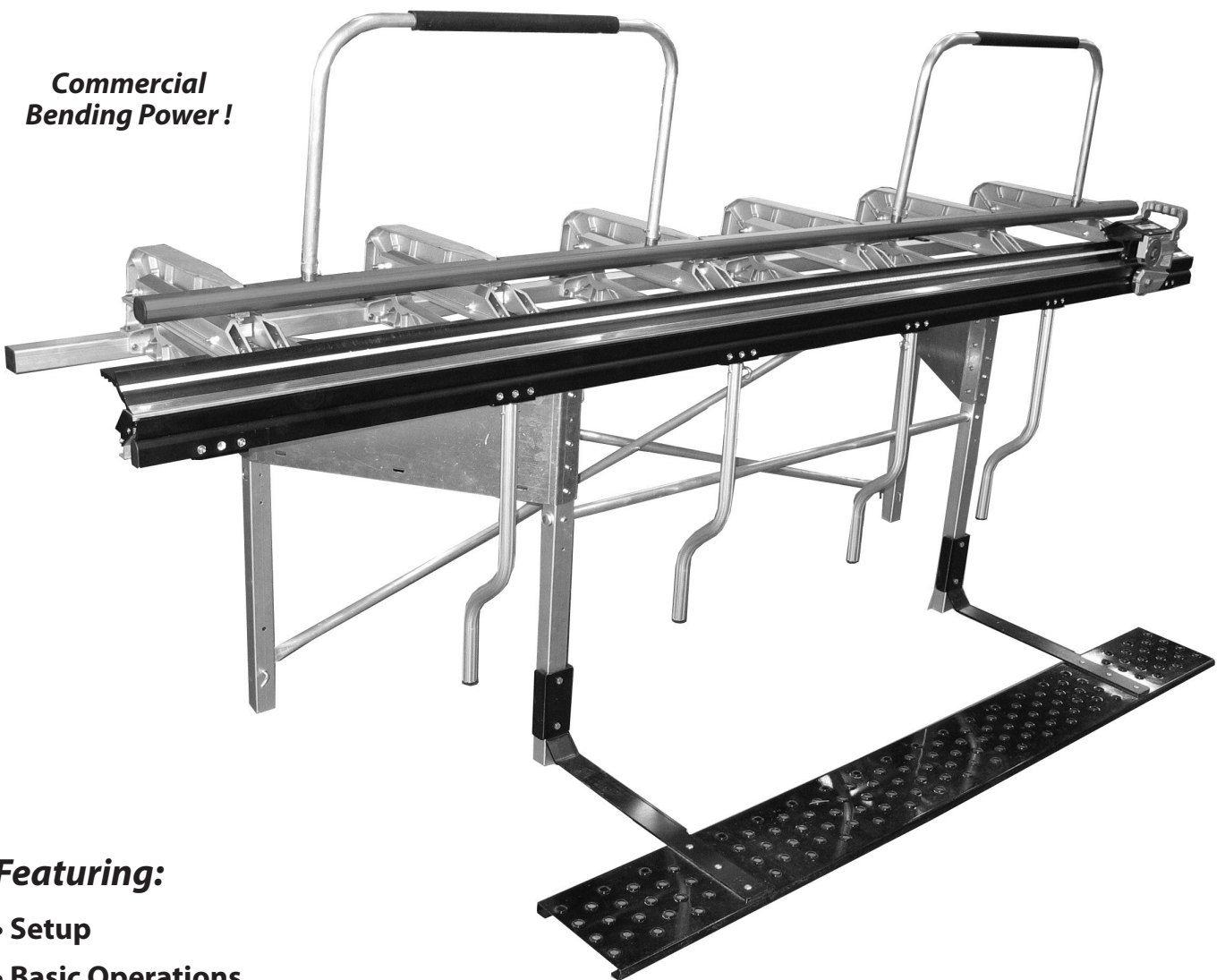


## OPERATIONS MANUAL

# **Tapco** *integrated* **SUPERMAX**

Used for commercial, architectural and industrial sheet metal fabrication

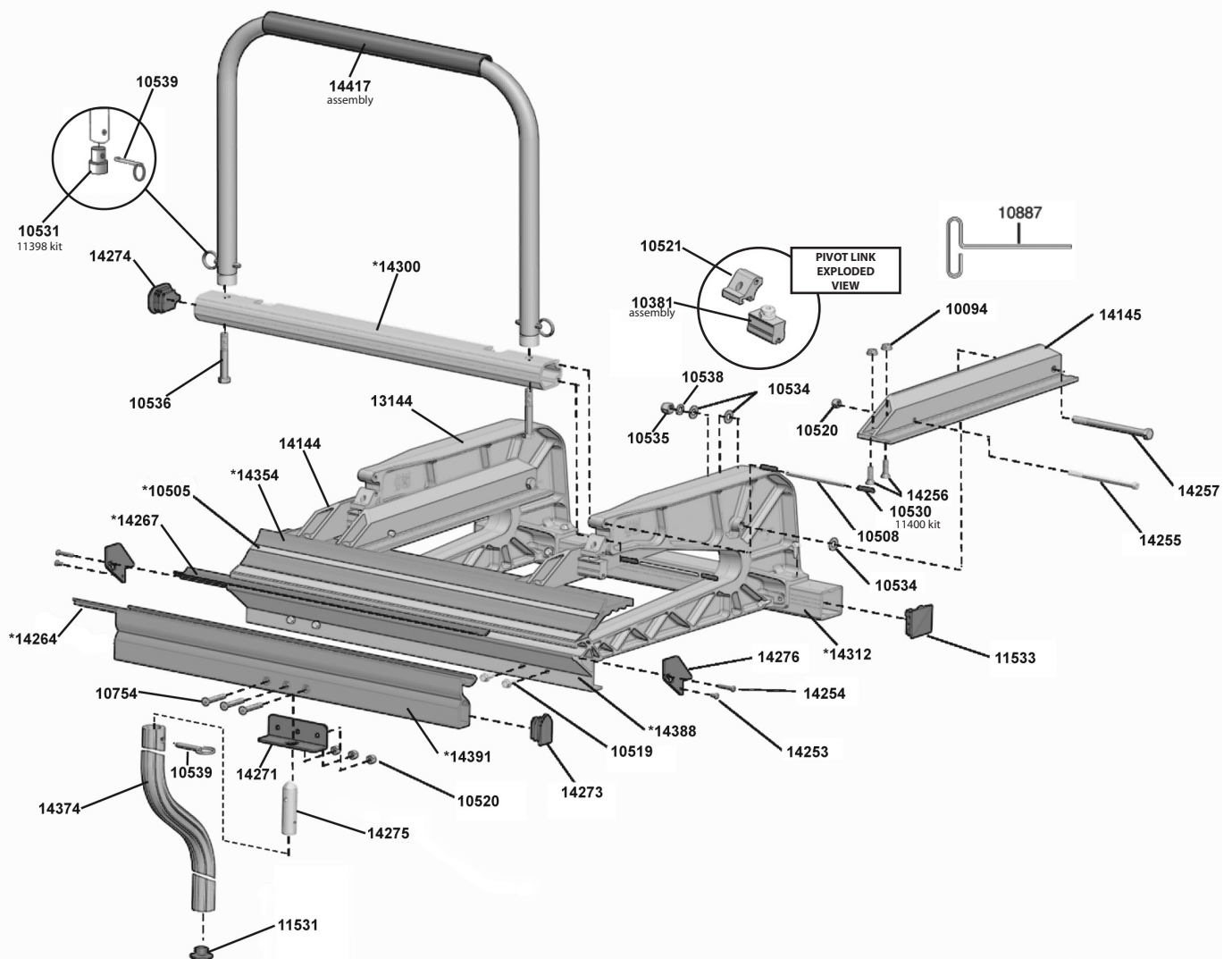
**Commercial  
Bending Power!**



### **Featuring:**

- Setup
- Basic Operations
- Capacity Chart
- Parts List
- Adjustment, Care & Maintenance
- Examples of Basic Shapes

## SUPERMAX BRAKE PARTS LIST



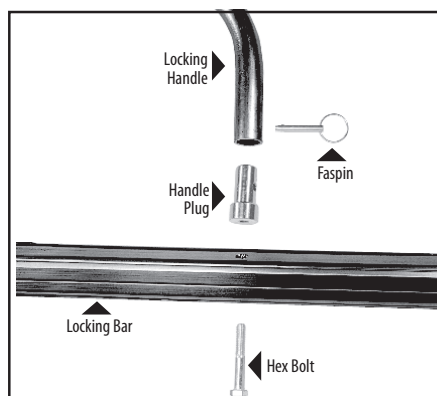
Item #	Description
10491	8'6" Stainless Edge
10492	10'6" Stainless Edge
10493	12'6" Stainless Edge
10504	12'6" Tape Measure
10505	10'6" Tape Measure
10506	8'6" Tape Measure
10519	1/4-20 x 3/4" Hex Washer Head Screw
10534	3/8" Flat Washer
10535	3/8-16 Nylock Hex Nut
10887	T-Handle Hex Key
11396	Pivot Link Assembly Kit (6)
11397	1/4" x 1 1/4" Faspin Kit (4)
11398	Locking Handle Plug Kit Locking Handle Plug 3/8-16 x 2 1/4" Bolt
11400	Locking bar Pin Kit 10 pins, 20 keepers
11531	Lifting Handle Cap
11533	Back Rail Cap
13144	C Castings
14144	Pivot Arm - Left

Item #	Description
14145	Pivot Arm - Right
14253	8-32 x 5/16" Phillips Pan Head Screw
14254	8-32 x 1" Phillips Pan Head Screw
14256	¼-20 x 1" Flat Head Screw
14257	3/8-16 x 5" Hex Cap Bolt
14263	8'6" Rubber Strip
14264	10'6" Rubber Strip
14265	12'6" Rubber Strip
14266	8'6" Wear Strip
14267	10'6" Wear Strip
14268	12'6" Wear Strip
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
14312	10'6" Back Rail

Item #	Description
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
14414	Locking handle Assembly
14456	MX Series™ Brake Parts Bag 8'
14457	MX Series™ Brake Parts Bag 10'/12'
14480	Bolt and Nut Kit ¼-20 x 4 ½" Bolt (5) ¼-20 x Nylok Nut (5)

## SETTING UP THE SUPERMAX BRAKE

### Locking bar Installation

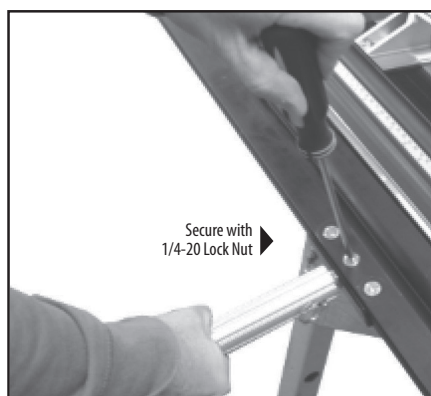
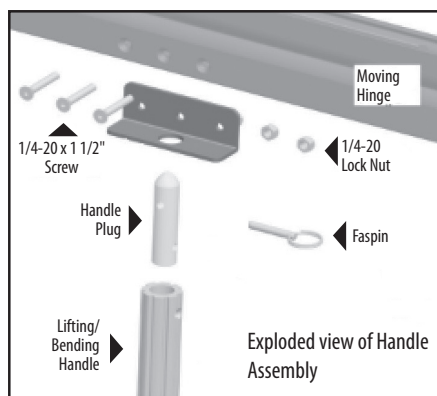


MX Locking Bar Assembly includes:  
(2) Locking bars,  
(4) Handle Plugs, (4) Faspins, (4) Hex Bolts



1. Insert Hex Bolt through Locking bar of your SUPER-MAX 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 Screwdriver 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.

## PIVOT LINK ADJUSTMENT INSTRUCTIONS

**IMPORTANT:** The Pivot Links on your SUPERMAX Industrial Brake have been pre-set at the factory for average holding capacity and ease of operation. However, it's important that you readjust your SUPERMAX Industrial Brake to your stock thickness. Your SUPERMAX Brake may also need periodic adjustment due to extreme weather and/or working conditions. It is important that you follow these steps when you adjust your SUPERMAX Brake to ensure proper gripping tension and maximum performance.

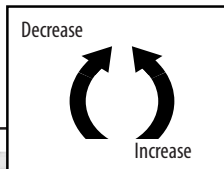
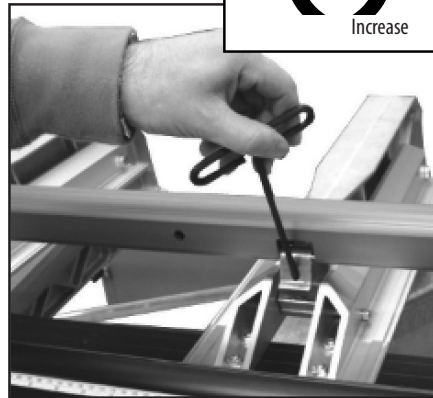
First check the uniformity of the clamping pressure along the entire length of your SUPERMAX Brake by using the following method.



### TO TEST

Cut some narrow strips of aluminium or use strips from stock you will be using and lock one under each shoe casting as indicated above. Then lightly pull the material to determine the tightness and uniformity of each Pivot Link. If the material can be moved when the SUPERMAX handle is locked or if it requires excessive pressure to lock the handle down on the material then the Pivot Arms may need adjustment.

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



### TO ADJUST

Insert the 3/16" hex wrench into the Pivot Link Stud through the access hole in the upper link. Turn 1/4 turn either COUNTER-CLOCKWISE to INCREASE locking tension or CLOCKWISE to DECREASE locking tension.

Repeat test step above to check tension.

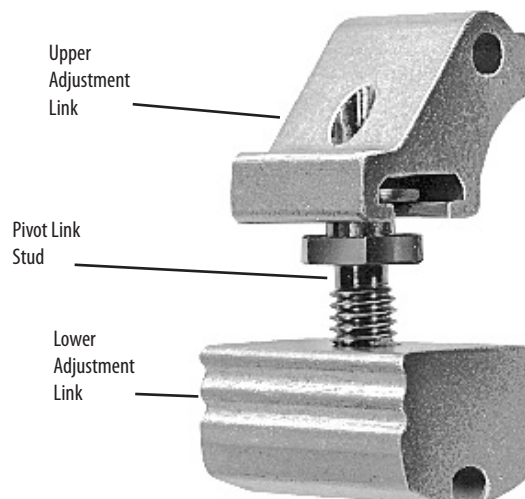


### TO ADJUST (Optional method)-

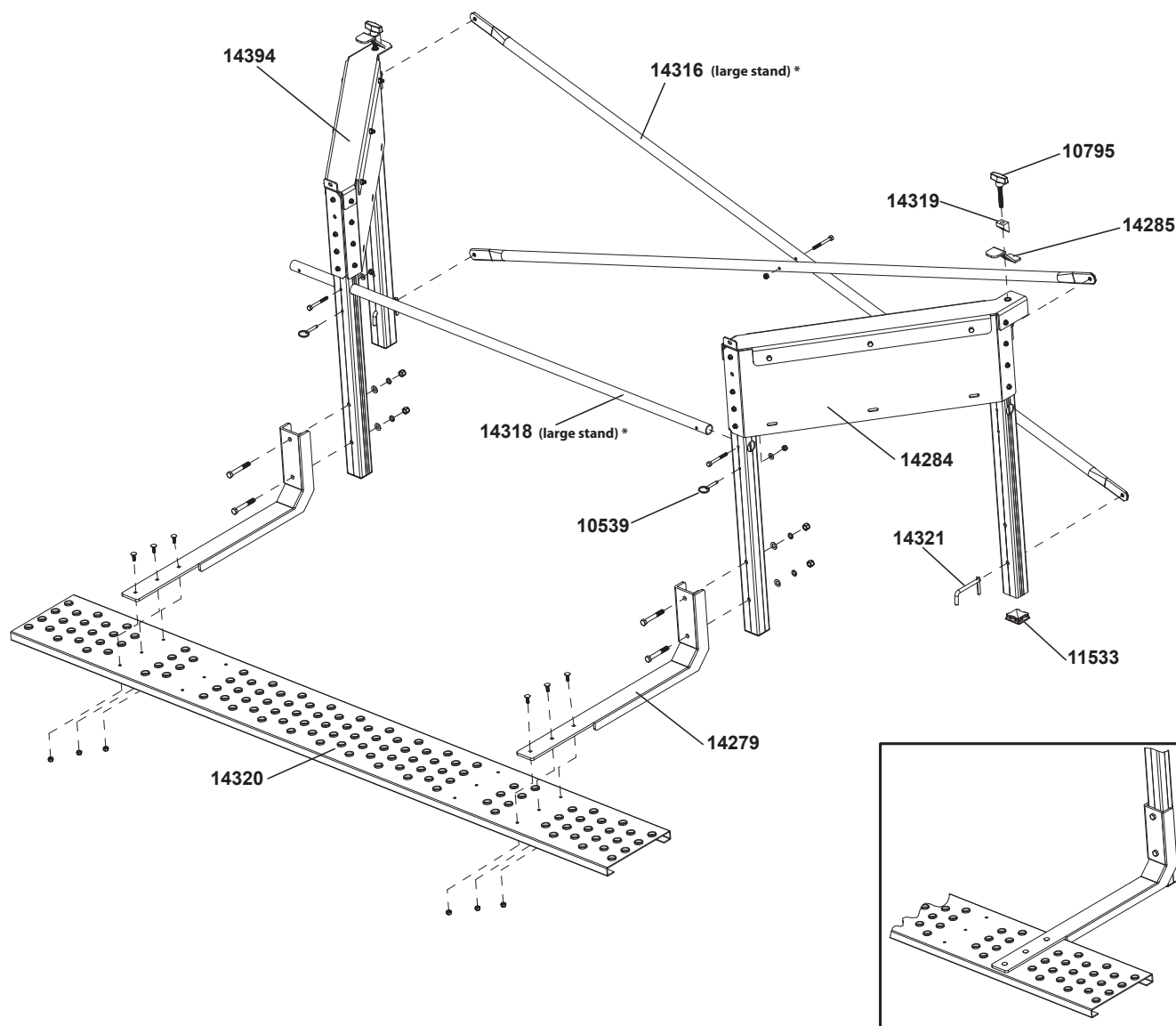
As an alternate method you may use a 5/8" open-end wrench directly on the Pivot Link Stud by turning 1/4 turn either COUNTER-CLOCKWISE to INCREASE locking tension or CLOCKWISE to DECREASE locking tension.

Repeat test step above to check tension.

### Pivot Link Assembly



# SUPERMAX STAND PARTS LIST



Item #	Description
10539	¼" x 1 ¼" Faspin
10795	3/8-16 x 2 ½ 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)



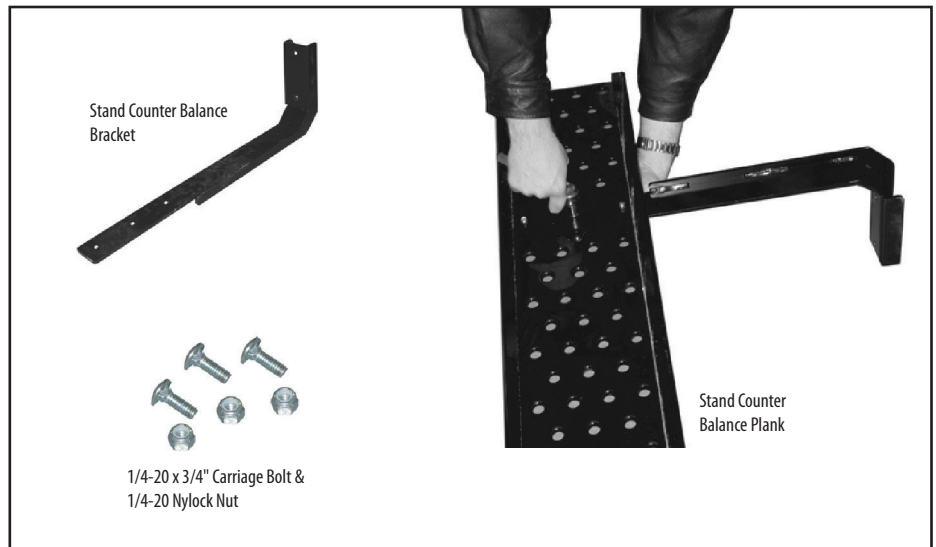
## SUPERMAX STAND SET-UP

Hardware Requirements: (2) 7/16" & (2) 9/16" Open end wrench.

### STEP 1

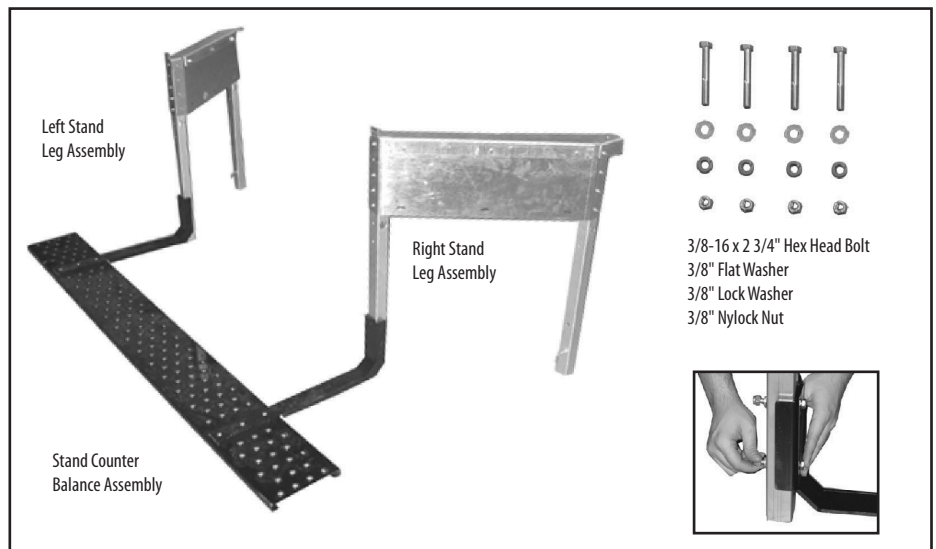
Attach Stand Counter Balance Brackets to Plank with Carriage Bolts and Nylock Nuts using a 7/16" Socket or Open end Wrench.

Counter Balance is required for operation.



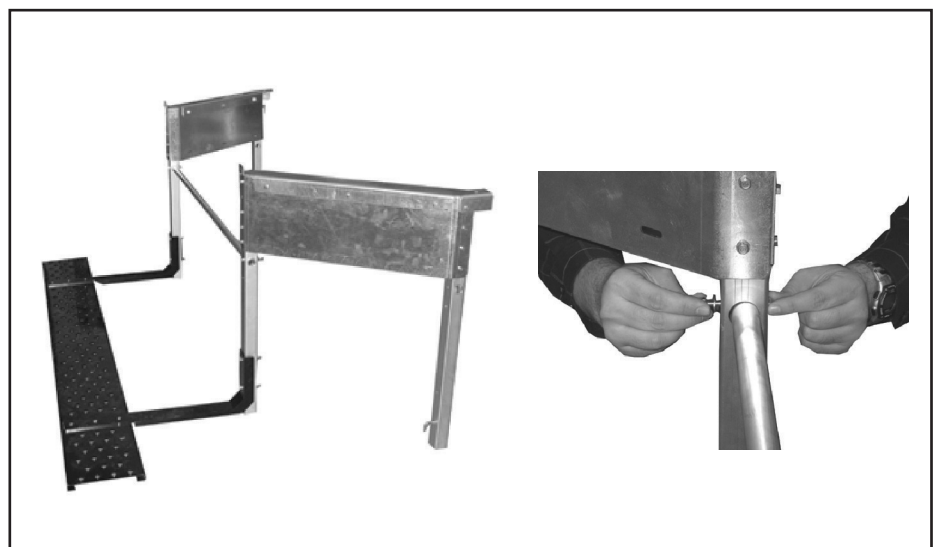
### STEP 2

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.

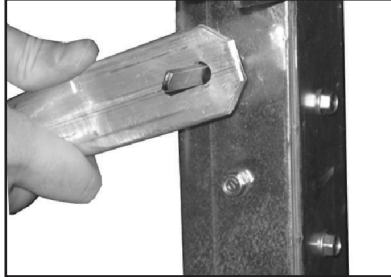


## SUPERMAX STAND SET-UP

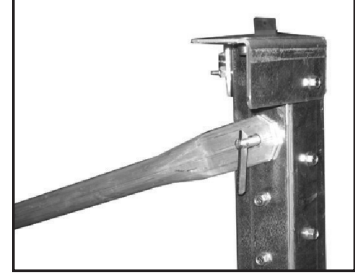
### STEP 4

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.



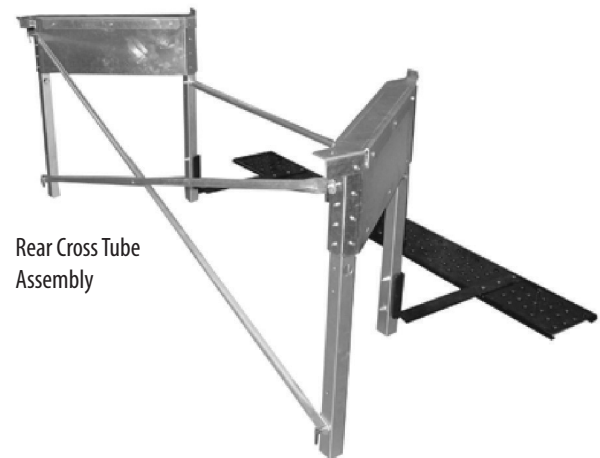
Toggle Pin in Locked position.



Toggle Pin (locked)



Toggle Pin (unlocked)



Rear Cross Tube  
Assembly

## INSTALLING A SUPERMAX BRAKE ON A SUPERMAX STAND

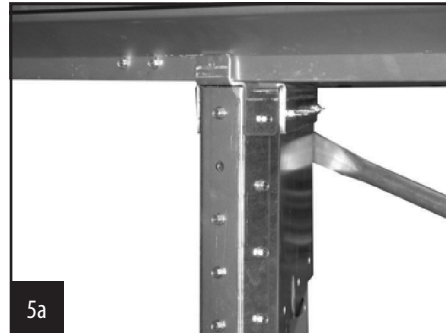
### STEP 5

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 & Right Stand Leg Assemblies.

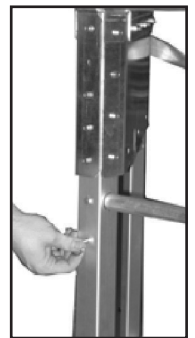
Using 2 people, set Brake on Stand with the hinges above the Front Support Tube.



5a



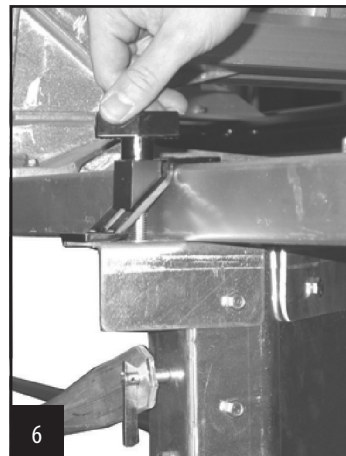
5b



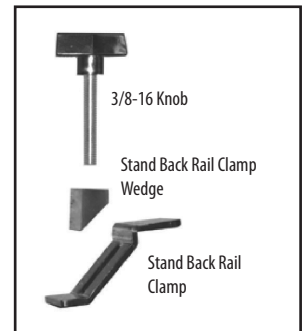
### STEP 6

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.



6

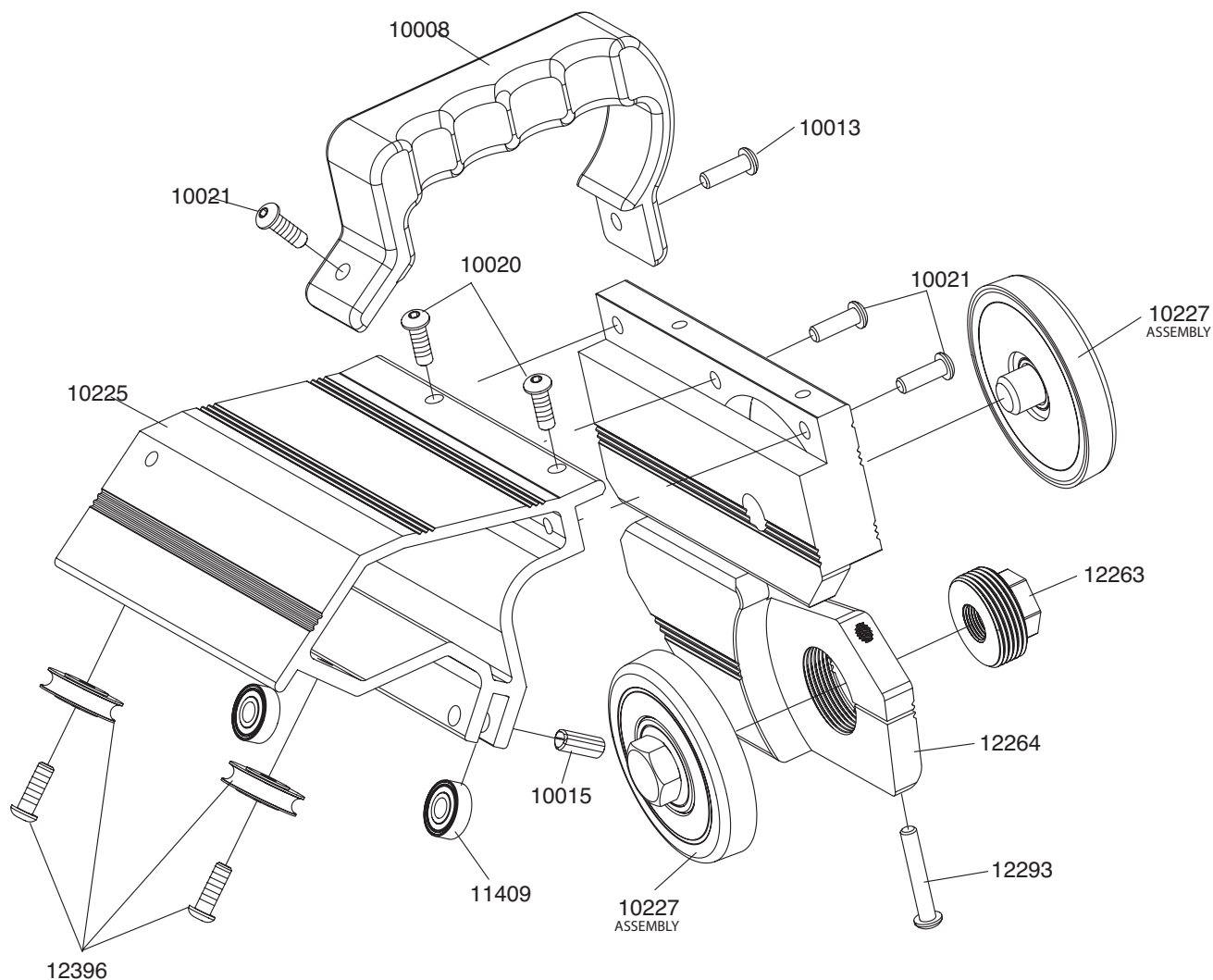


## Removing a SUPERMAX Brake from a SUPERMAX Stand

- Removing the brake from the SUPERMAX 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
10008	Handle
10013	1/4-20 X 1-1/4" Button Head Screw
10020	1/4-20 X 5/8" Hex Button Head Screw
10021	1/4-20 X 1" Hex Button Head Screw
10225	Bridge
10227	MAX Knife Assembly**
10349	Coupling Nut (hook, not shown)
10519	1/4-20 X 3/4" Hex Washer Head Screw (not shown)
11393	Track Bearing Kit (not shown) (2) Track Bearing – 10012
11404	Material Stop Kit (not shown) (2) Material Stop – 10740 (2) 1/4-20 Knurled Knob – 10776 (2) Cut-Off Tape Measure – 10023

Item #	Description
11409	Cut-Off Guide Bearing Kit (2) Guide Bearing 10016 (2) 5/16" Roll Pin 10015
12263	Adjusting Nut
12264	Adjustable MAX Cut-Off Body
12293	1/4-20 X 1 1/2 Socket Head Cap Screws
12396	Flange Track Bearing Kit* (2) Wide Flange Track Bearing – 12334 (2) 1/4-20 X 5/8" Hex Button Head Screw – 12364

\* 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:

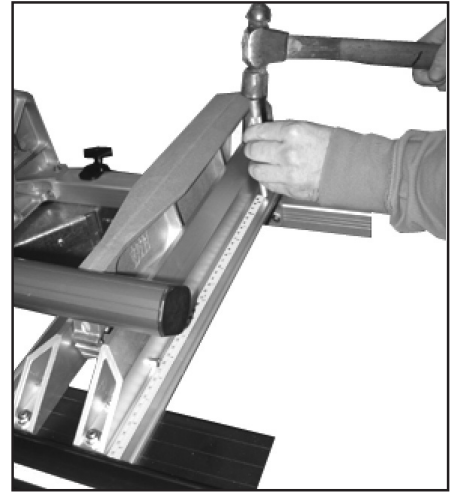
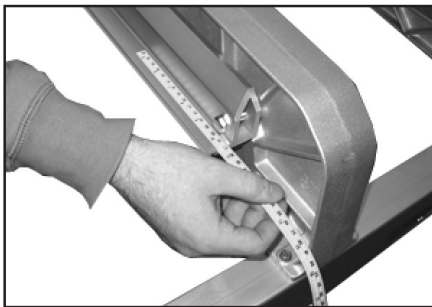
- (1) Adjustable MAX Cut-Off
- (2) MX Material Stop Kit #14485

### 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 Screwdriver

### Wear Strip and Rubber Strip

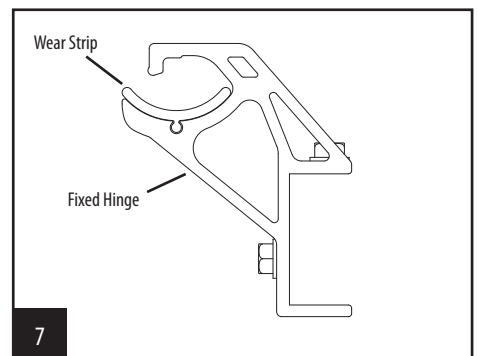
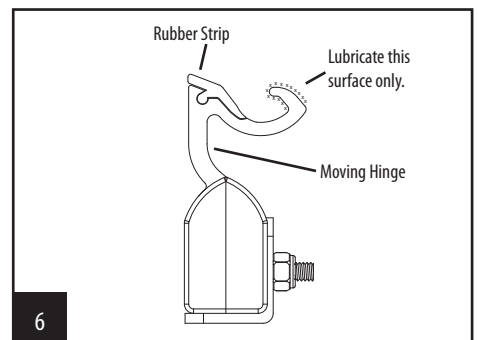
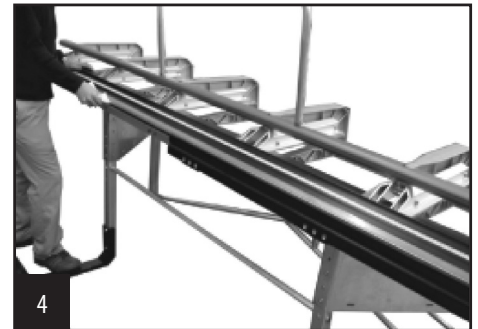
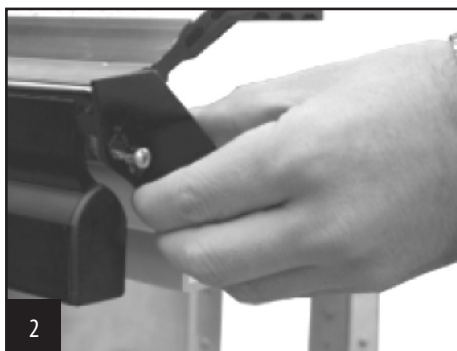
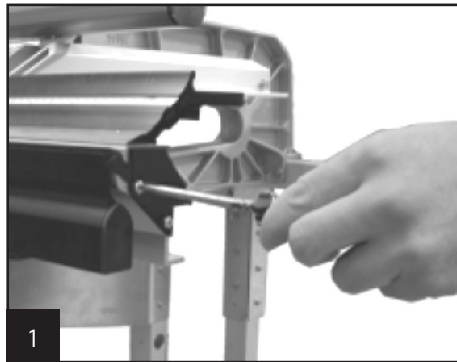
- Use a Phillips head screwdriver to loosen the screw enough to allow the Endcap to be removed by sliding it off of the screw (see Figure 1 & Figure 2).
- With the Endcap removed, slide the Moving Hinge half-way down the length of the Fixed Hinge exposing the Wear Strip and Rubber Strip on the Fixed 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

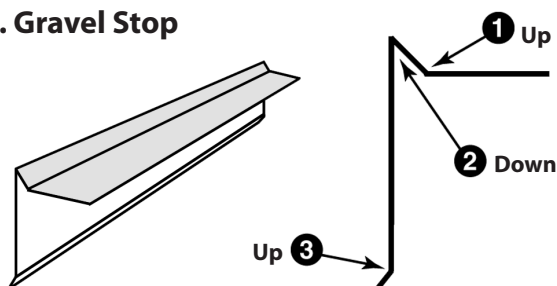
- The SUPERMAX Brake should be transported in the unlocked position unless a piece of cardboard or vinyl siding is clamped between the clamping surfaces.



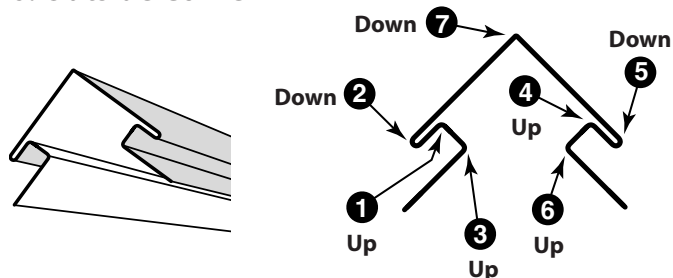
## EXAMPLES OF BASIC SHAPES

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

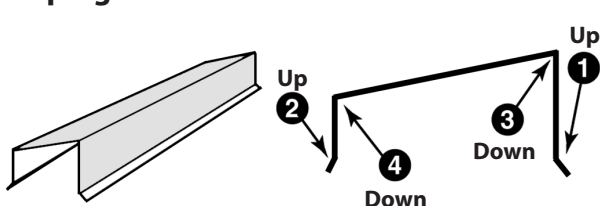
### 1. Gravel Stop



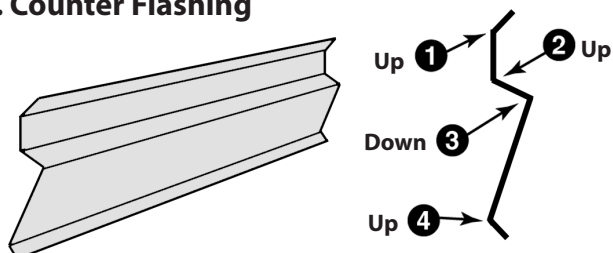
### 6. Outside Corner



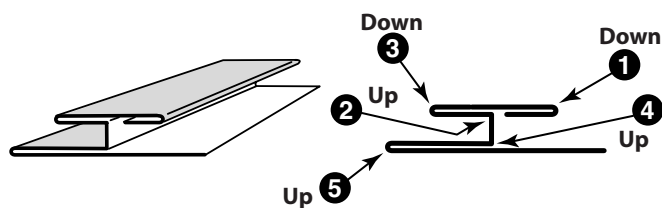
### 2. Coping Cover



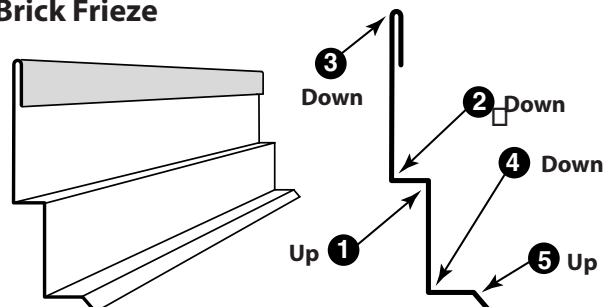
### 7. Counter Flashing



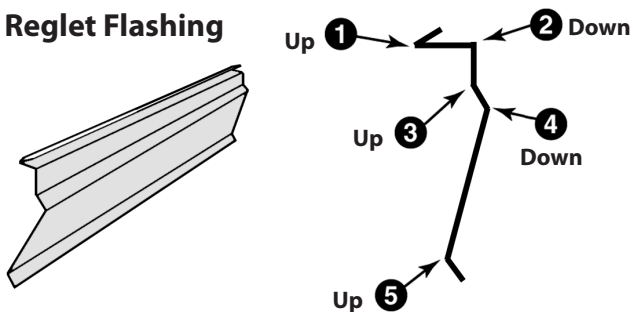
### 3. One Piece Soffit Mitre



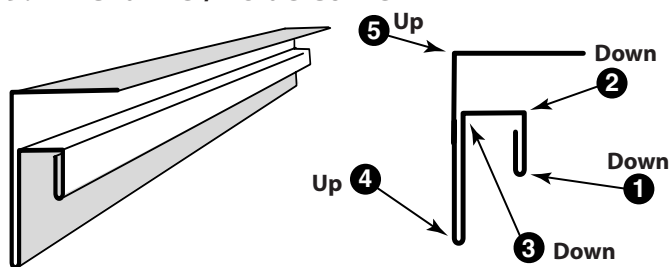
### 8. Brick Frieze



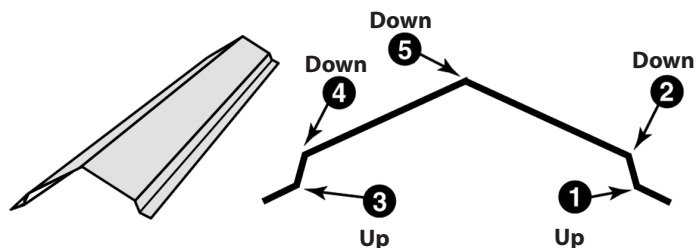
### 4. Reglet Flashing



### 9. "F" Channel/Inside Corner



### 5. Hip/Ridge Cap



### 10. "D" Style Gutter

