

- Model HBU48-16
- Model HBS48-16

- Model U48-22
- Model S48-22

Hand Brakes



Model HBU48-16 – Shown with optional stand.



Model HBS48-16 – Shown with optional stand.



Model U48-22 – Shown with optional stand.



Model S48-22 – Shown with optional stand.

TENNSMITH'S bench-mounted hand brakes provide an economical means of performing a wide range of sheet metal bending and forming operations. These brakes are of all-steel welded construction, readily adjustable, and utilize bronze bearings at pivot points.

Radius Bending and Forming Information

TENNSMITH hand brakes come equipped with 1/64-inch radius nose bars and fingers as standard equipment. We recommend clearances between the edge of the nose bar and bending apron of twice the material thickness for 16-gauge and heavier materials and one and one-half times the material thickness on lighter than 16-gauge materials. This will approximate a 1/64-inch inside radius on the work piece. Larger radius bends can be made using the standard nose bar by allowing more clearance between the edge of the nose bar and bending apron.

SPECIFICATIONS

Bench-Mounted Hand Brakes	Model HBU48-16	Model HBS48-16	Model U48-22	Model S48-22
Capacity, mild steel	16 gauge 1.6 mm	16 gauge 1.6 mm	22 gauge 0.75 mm	22 gauge 0.75 mm
Bending length	48-1/4 in. 1225 mm	48-1/4 in. 1225 mm	48-1/4 in. 1225 mm	48-1/4 in. 1225 mm
Maximum depth of box	4 in. 101.7 mm	—	3 in. 76.2 mm	—
Maximum lift of beam	1-1/4 in. 31.75 mm	1-3/4 in. 44 mm	7/8 in. 22.2 mm	7/8 in. 22.2 mm
Front to rear beam adjustment	5/8 in. 16 mm	5/8 in. 16 mm	1/4 in. 6 mm	1/4 in. 6 mm
Minimum reverse bend	1/4 in. 6 mm	1/4 in. 6 mm	5/16 in. 7.9 mm	5/16 in. 7.9 mm
Minimum flange in capacity material	1 in. 25 mm	1 in. 25 mm	3/8 in. 9.5 mm	3/8 in. 9.5 mm
Finger widths	2, 3, 4 in. 51, 76, 101 mm	—	2, 3, 4 in. 51, 76, 101 mm	—
Shipping weight	495 lbs. 224.5 kg	460 lbs. 208.7 kg	280 lbs. 127 kg	220 lbs. 100 kg
Export crate	23.6 cu. ft. 0.67 cu. m	23.6 cu. ft. 0.67 cu. m	17.4 cu. ft. 0.49 cu. m	17.4 cu. ft. 0.49 cu. m
Optional stand, shipping weight	95 lbs. 43 kg	95 lbs. 43 kg	95 lbs. 43 kg	95 lbs. 43 kg
Export crate	2.5 cu. ft. 0.07 cu. m	2.5 cu. ft. 0.07 cu. m	2.5 cu. ft. 0.07 cu. m	2.5 cu. ft. 0.07 cu. m

Available options: bolted assembly stand and radius fingers.

Tennsmith's bench-mounted hand brakes are rugged, dependable USA-made tools that won't break your budget. The Model HBU48-16 is a heavy-duty bench brake suitable for box and pan or straight bending in up to 16-gauge mild steel. The brake features a removable apron angle and apron insert permitting 1/4-inch reverse bends in lighter materials. The upper leaf and nose bar has a wide range of adjustment for radius bending. Standard equipment includes an apron stop rod for repeat bends, extension handles and a counterweight. The Model HBS48-16 is identical in features and capacity to the HBU48-16 but is intended solely for straight bending. Like our larger hand brakes, the HBS48-16 features a removable nose bar.

The Models U48-22 and S48-22 are lighter capacity versions of the four-foot bench brake which offer economical alternatives in working 22-gauge and lighter materials. Also, their lighter weights make these models better suited for transporting to remote job sites.

