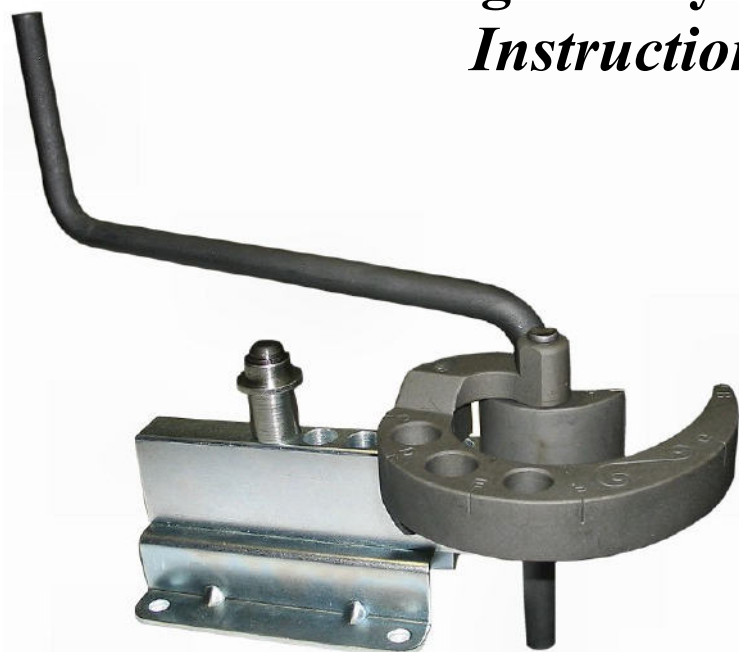


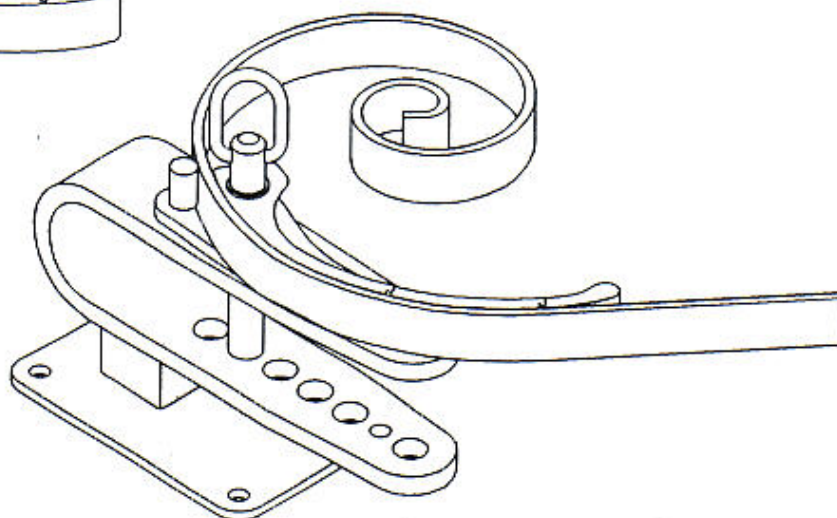
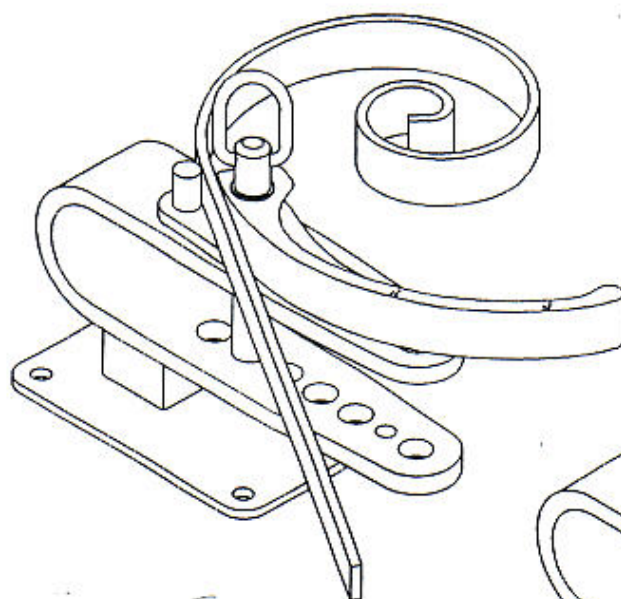
SB - Light Duty Scroll Bender

Instruction Sheet

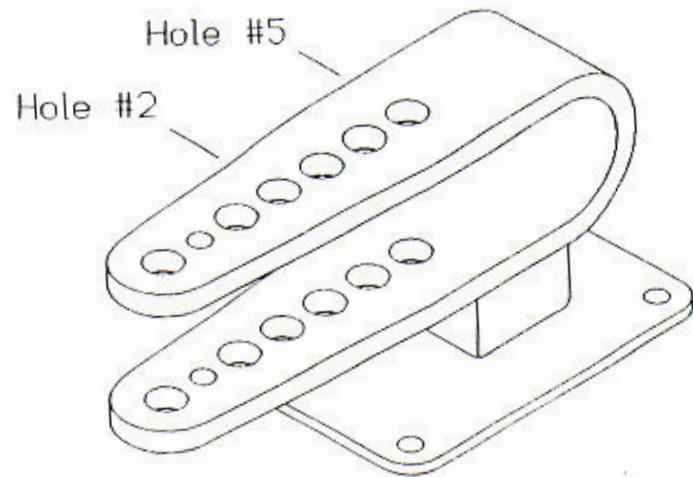
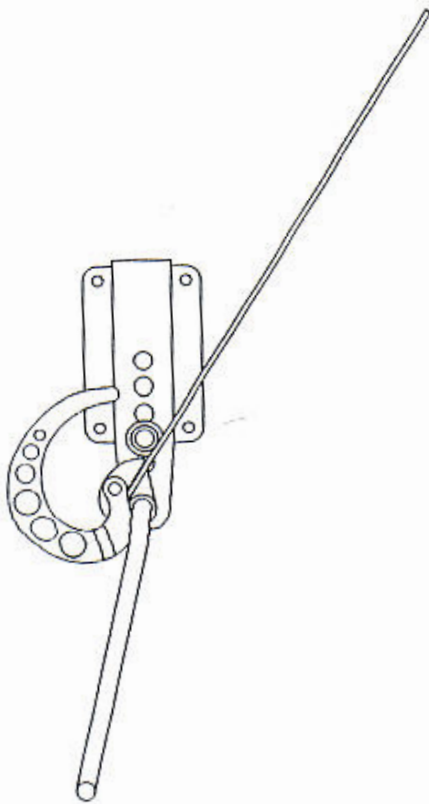


The scroll bending attachment is designed for bending 3/16" x 1/2" up to 3/16" x 1" hot rolled mild flat stock. It is not recommended for bending 1/8" thick material. The bushing supplied with the scroll attachment keeps the scroll flat as it is formed. To make several scrolls of the same size, draw a chalk mark on the top edge of the scroll attachment at the point where the stock just touches the attachment. If each successive scroll is bent until the stock contacts the chalk mark, the scrolls will be of similar size.

The scroll attachment is used to bend scrolls as large as the 'H' size. Bent scrolls may not perfectly match those from the drawing templates; scrolls may need some additional forming to match your designs with your drawings. Even when following our book, always make a test pattern and verify that it will fit your application.

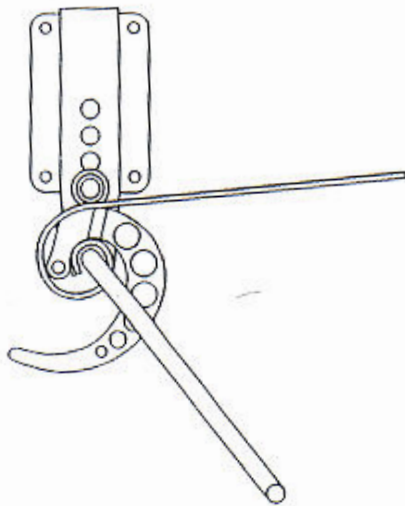


The optional Scroll Enlarger is used to make size 'I' and 'J' scrolls. First, use the scroll attachment to bend the scroll to the 'H' size. (The blank lengths for 'I' and 'J' sizes will be longer than for the 'H' size, however. For more information on the different sizes of scrolls, see pages 12-17.) Next the enlarger is set up as shown above left. Pull the material around the enlarger to until it touches the 'I' or 'J' mark, whichever scroll size you want to make (shown above right).



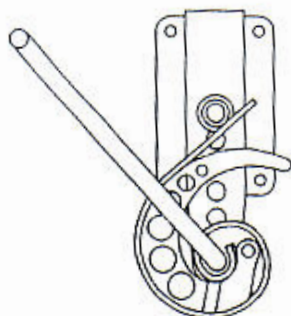
Regardless of the desired scroll size, always begin the scroll by placing the pin and bushing into hole #2.

Make certain that the scroll remains rested on the bottom flange of the roller bushing during all scroll bending operations.



Continue bending the scroll across the entire bending surface of the scroll attachment's center-piece. **Do not** bend the scroll past the end of the centerpiece, or the scroll will be distorted.

If you are bending to a chalk mark, continue to turn the crank handle until the chalk mark just touches the side of the scroll attachment.



When bending larger scrolls, move the pin and bushing to hole #5 after the first stage (bending of the scroll around the centerpiece) has been completed. Never try to start a scroll with the pin and bushing positioned in hole #5.