

BAR FOLDER

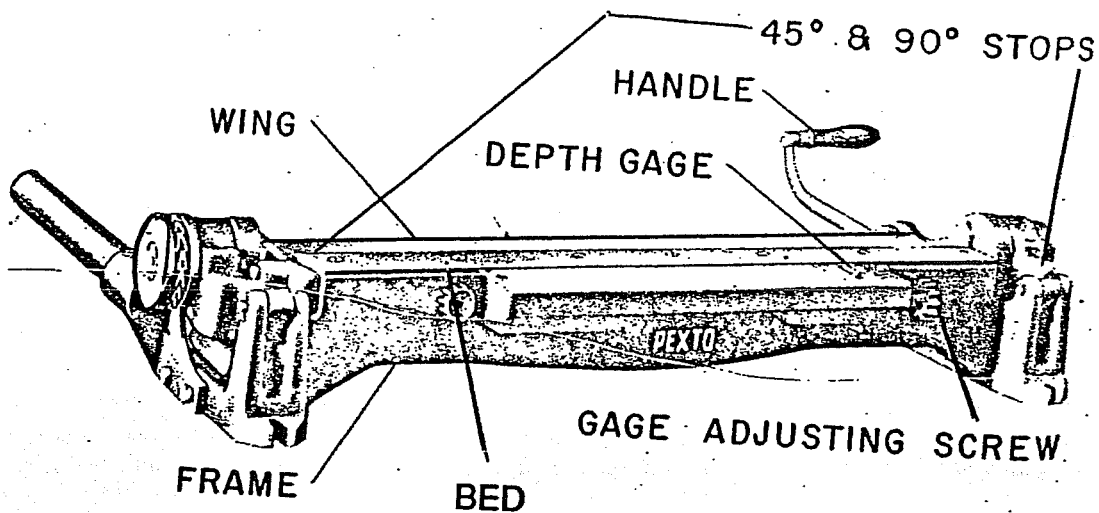
To certify on the bar folder you will need to know:

1. The safety rules.
2. Learn the parts of the bar folder.
3. Demonstrate your ability to bend a 90° angle, 45° angle, a single and double hem on scrap sheet metal.

Bar folder safety rules

1. Wear eye protection.
2. Remove sharp burrs and edges from sheet metal before attempting to work in the bar folder.
3. Never attempt to bend metal which is heavier than the capacity of the bar folder.
4. Keep hands and fingers away of moving parts.
5. Never work more than one thickness of sheet metal.
6. Avoid slamming or dropping the handles.
7. Be careful that moving parts or metal do not strike others.

Parts of the bar folder



How to adjust the bar folder for a 90° and 45° angle bend.

1. First regulate the gage adjustment screw left or right to set the depth gage to your desired depth of bend.
2. To make a 90° bend you will need to flip the 90° stop into place on the right side of the bar folder.
3. Lift the handle and pull the wing over till it hit the stop. Lower the handle and wing and remove the sheet metal.
4. Procedures for a 45° bend are the same as making a 90° bend just use the 45° stop on the left side instead.

How to fold the sheet metal to make hem using the bar folder.

1. First regulate the gage adjustment screw left or right to set the depth gage to your desired depth.
2. Remove all stops, insert sheet metal in bar folder and hold firmly in place with your left hand.
3. With your right hand lift up on the handle and pull towards you until a hem has been formed. Then lower the handle back to its starting position.
4. Remove sheet metal and place it on the bar folder bed. Next lift up and pull down on the handle so wing will apply pressure to flatten the single hem. Return handle to starting position. This will give you a single hem. To make a double hem repeat the process on top of the single hem.