

100 TECHNICAL METAL FOLDER



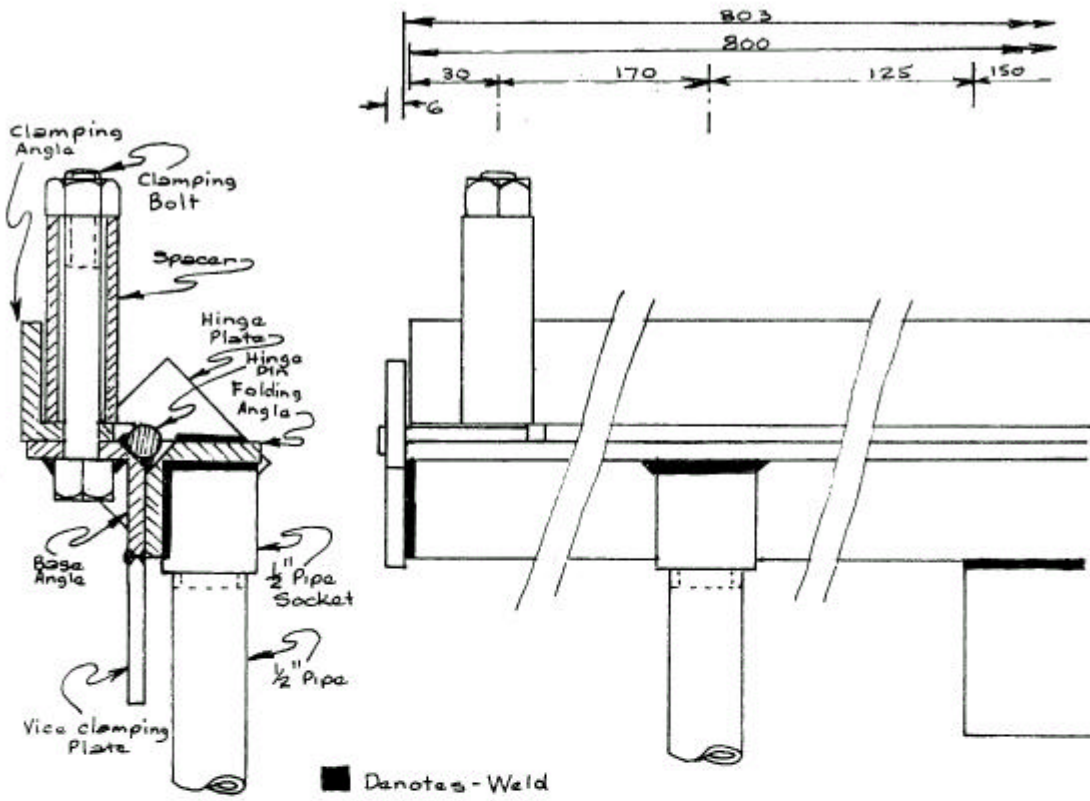
1. Recess 45mm at both ends of the base angle and weld on the 50mm x 1/2" pivot pins leaving 12mm protruding. **The centre line of the pivot pins must be in line with the right angle edge of the angle iron.**
2. Weld the vice clamping plate to the centre of the bottom of the base angle.
3. Recess 45mm at both ends of the folding angle (to clear the pivot pins when assembled) and clamp it to the base angle with the horizontal faces in line.
4. Place the hinge plates over the pivot pins and weld them to the folding angle.
5. While still clamped together weld on the two pipe connectors. **Keep heat to a minimum to prevent distortion.**
6. Recess 45mm at both ends of the clamping angle and grind / file the fold edge to an angle of about 60 deg.
7. Clamp the clamping angle to the base angle with the fold edge 1mm behind the front edge of the base angle, drill the two 1/2" holes, install the two bolts, spacers and nuts and weld the bolt heads to the underside of the base angle.
8. You are now ready to go afolding.

To make an end folds when both sides have been folded, use a piece of square section tube or bar slightly higher than the side folds and slightly shorter than the distance between, under the clamping angle e.g. When folding the ends of the Bead Blasting Cabinet, fold both sides, then the bottom, then with a piece of 30mm square bar just under 200mm long between the clamping angle and the cabinet side, fold the top flange first, then the angled door flange.

All sorts of refinements could be made - bushes, wear adjustments etc. - but at a cost of \$12 for the three pieces of angle when the pivots wear or the angle bends or warps, you throw it away and make another. Mine has folded the Bead Blasting Cabinet and a lot of other work without any appreciable wear.

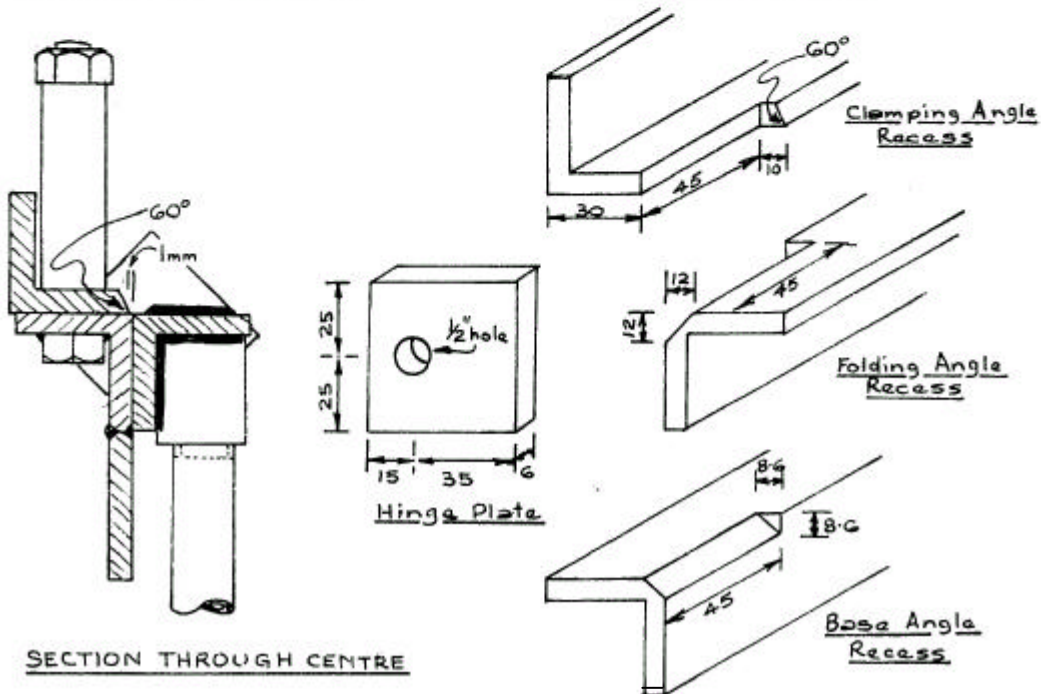
PARTS LIST

40 x 40 x 6 mild steel angle	2 off 800mm....1 off 803mm
Hinge plates.....	2 off 50x50x6mm
Vice clamping plate.....	1 off 150x50x6mm
Hinge pins	2 off 50x1/2" dia. round.
Bolts and nuts.....	2 off 3 'x1/2" Whitworth
Spacers.....	2 off 2"x1/2" Int. dia.
Folding handles.....	2 off 1/2" pipe x 300mm
Pipe connectors.....	2 off 1" pipe



SECTION THROUGH BOLT

PART ELEVATION



SECTION THROUGH CENTRE