



# FOREMOST BANTAM PRESS BRAKE

**Big in Power Brake  
Performance...  
Bantam in Size  
Cost and  
Maintenance**



# Use the versatile Foremost Bantam for a multitude of prototype and production press brake operations

- bending
- flanging
- hemming
- flattening
- staking
- box forming
- and more

## Stroke Power Control

Twelve or twenty-four tons of ram force is available throughout the stroke to bend material up to 3/8" or 1/2" thick. Adjusting the air pressure alters power to suit the operation, extends tool life and reduces air consumption.

## Stroke Speed Control

Hooded foot valve provides full control of stroke speed. The operator can inch the ram down to a scribe line or run it down for higher production. The stroke may be stopped or reversed at any point, and the forming action may be slowed to reduce sheet whip-up. Counterbalanced ram automatically reverses when the foot control is released or the air supply is turned off.

## Stroke Length Control

Positive stop screw adjustment assures accurate stroke length control, from 0" to maximum. Shortening the stroke speeds production and reduces air consumption. Bed adjusts to accommodate various dies and to reduce the pinch point to a minimum.

## Rugged Construction

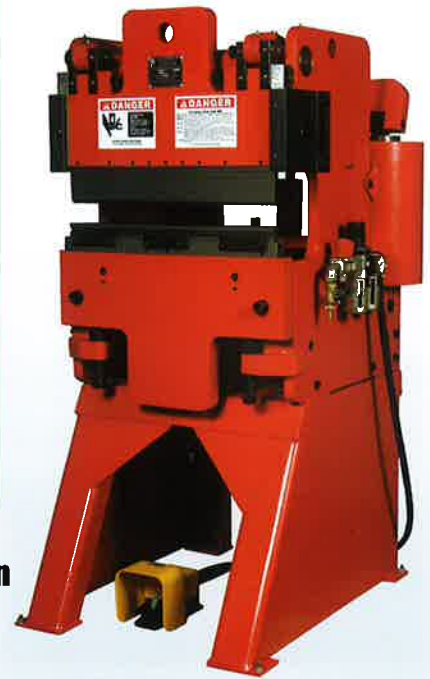
Heavy steel plate limits deflection to less than .0015" per foot. Dual air cylinders provide power through a one-piece rocking lever designed to resist off-center loads. Ram guides are adjustable for minimum tolerance and maximum precision.

## Low Maintenance

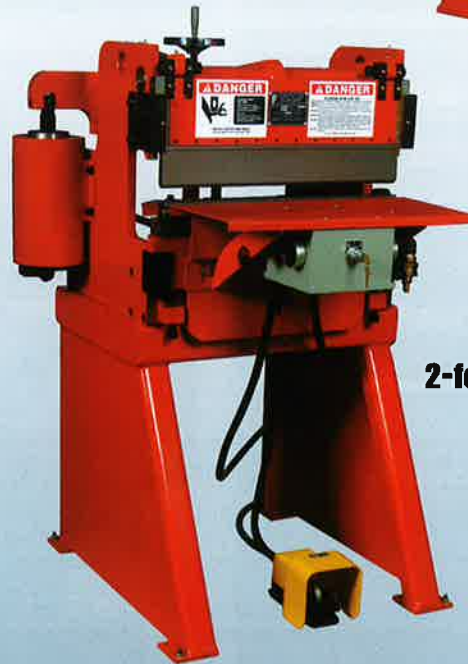
Completely pneumatic; there is no motor, clutch or brake to service or adjust. With a minimum of moving parts, Foremost Bantam Press Brakes assure years of trouble-free service.

## Standard Equipment

Every Foremost Bantam comes with 90° male punch, 4-way steel bottom die, lower die holder for all standard press brake dies, hooded foot control valve, manual back gauge, quick exhaust with muffler, manual shut-off/speed control valve and air line filter/regulator/lubricator.



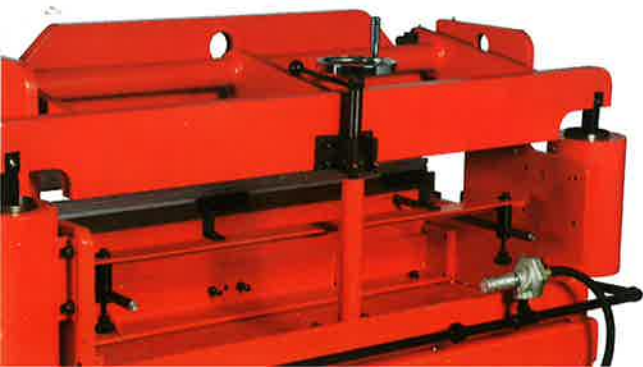
2-foot / 24-ton



2-foot / 12-ton



4-foot / 12-ton





# FOREMOST BANTAM PRESS BRAKE

Choose the Foremost Bantam that suits your job requirements

Bed lengths from 2 feet to 8 feet  
Capacities 12 ton and 24 ton



6-foot / 24-ton

12 Ton Rated at 90° PSI	Model	Bed Width (ft.)	Ram Height (in.)	Max. Back Ga. Depth (in.)	Max. Free Air	Max. Speed @ Full Stroke	Shipping Weight (lbs)
	B 212	2	5-7/8	18	2.2 ft. <sup>3</sup>	30 SPM	880
B 412	4	9-7/8	1340				
B 512	5	13-7/8	1650				

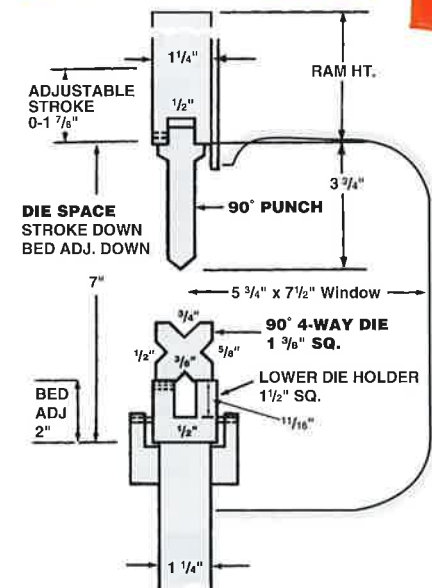
24 Ton Rated at 90° PSI	Model	Bed Width (ft.)	Ram Height (in.)	Max. Back Ga. Depth (in.)	Max. Free Air	Max. Speed @ Full Stroke	Shipping Weight (lbs)
	B 224	2	8	19/21-1/2 See Note	4.4 ft. <sup>3</sup>	20 SPM	1920
B 424	4	13	2880				
B 624	6	17-1/2	3850				
B 824	8	23-5/8	4500				

Note: Full 21-1/2" back gauge depth possible only on sheets 7" narrower than maximum width.

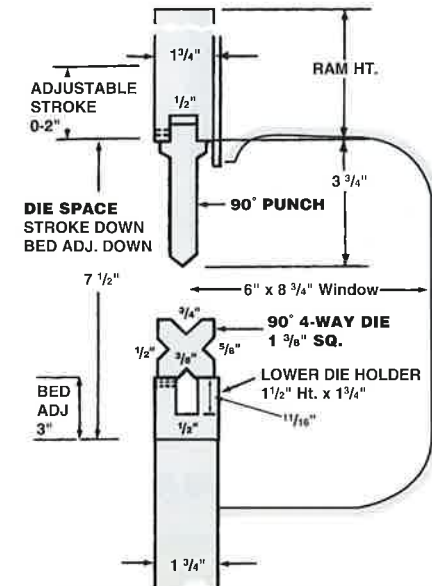
## Requirements for 90° Bends, Mild Steel

Thickness	Vee Die	Bending Force Tons/ft.	Min. Ram Stroke (in.)	12-Ton		24-Ton	
				Free Air Per Stroke	Max. Sheet Width (in.)	Free Air Per Stroke	Max. Sheet Width (in.)
22ga. (.030)	1/4	1.8	.12	.14	60	.26	96
20ga. (.036)	5/16	2.1	.14	.16	60	.31	96
18ga. (.048)	3/8	3.0	.17	.20	48	.38	96
16ga. (.060)	1/2	3.7	.23	.26	39	.51	72
14ga. (.075)	5/8	4.6	.28	.32	31	.62	63
13ga. (.090)	3/4	5.5	.31	.36	26	.68	52
12ga. (.105)	7/8	6.4	.38	.44	22	.84	45
11ga. (.120)	1	7.4	.44	.51	20	.97	39
10ga. (.135)	1-1/8	8.3	.50	.57	17	1.10	35
9ga. (.150)	1-1/4	9.2	.56	.64	16	1.24	31
3/16 (.187)	1-1/2	12.0	.68	.78	12	1.50	24
1/4 (.250)	2	16.0	.93	1.07	9	2.06	18
5/16 (.312)	2-1/2	20.0	1.17	1.34	7	2.59	14
3/8 (.375)	3	24.0	1.41	1.62	6	3.12	12
1/2 (.500)	4	32.0	1.88	NA	NA	4.15	9

## Die Space - 12 Ton Models



## Die Space - 24 Ton Models





## Pushbutton Control

Two-hand control keeps fingers away from the die when bending small parts while allowing operator full control of the stroke through the foot pedal. Both pushbuttons must be simultaneously depressed and held to activate the foot control valve. The ram retracts when the foot valve or either pushbutton is released. Full length support table adjusts to level of bottom die. Pushbutton control is also easily retrofitted on previous models.

- Two-hand pushbutton control in sturdy metal enclosure.
- Sheet support table 12" deep x bed length.
- Keyed Mode-of-Operation selector switch.
- Key removable in all three modes.

**HAND:** Operate with pushbuttons and foot valve.

**FOOT:** Operate with foot valve only.

**OFF:** Press brake will not operate.

## Sheet Support Table

Table 12" deep x bed length in 10 gauge welded steel fabrication. Vertical adjustment accommodates a full range of die heights. Same as table included with the pushbutton control option.

## Floor Stand

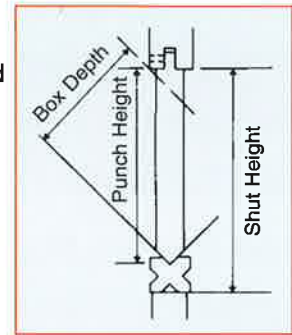
Welded 10 gauge steel construction. Corner mounting plates have a through hole to accommodate vibration mounts or to bolt the machine to the floor.

## Micrometer Back Gauge

Gauge permits faster, more accurate set-up. Unit is independently adjustable from 0 to 4". Handwheel graduations read movement in .001" increments. Vertical and horizontal adjustments.

## Extra Shut Height

This option provides added die space for one-piece box forming. Chart is based on a maximum thickness of 13 gauge using lower 4-way die provided. Consult factory for variations. Standard top punch is not included with extra shut height option.



## Box Forming

	Shut Height (inches)	Max. Box Depth (inches)	Punch Height (inches)
<b>12 Ton</b>	7	2.2	3-3/4
	7	3.3	5-3/8
	9 (opt)	4.7	7-3/8
	11 (opt)	6.1	9-3/8
	13 (opt)	7.6	11-3/8
<b>24 Ton</b>	7-1/2	2.0	3-3/4
	7-1/2	3.7	6-1/8
	9-1/2 (opt)	5.1	8-1/8
	11-1/2 (opt)	6.5	10-1/8
	13-1/2 (opt)	7.9	12-1/8

## Foremost Bantam Press Brake Options