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1. POSITION POLE BRAKE AS SHOWN IN VISE.
 2. POSITION PART BETWEEN FRONT AND REAR POLES SO THAT THE CENTER OF THE BEND TANGENTS IS LOCATED ON THE CENTERLINE OF THE FRONT POLE AND TIGHTEN VISE.
 3. SQUEEZE VISE UNTIL PROPER BEND IS ACHIEVED. BE SURE TO ACCOUNT FOR SPRING BACK.

