

Installation Instructions for 81516

English Wheel

with 6 Anvil Dies

Specifications

Top Die Size	8" (dia.) x 2" (W) (203.2 x 51.3 mm)
Bottom Die Included	2- (50.8 mm) dia.
Throat Size	27-31" (711 mm)
Stock Applications	16 gauge sheet metal, 14 gauge (1/8") soft aluminum and copper
Features	Bottom die set holder with locking bar Quick ad use anvil yoke

Work Area

1. Keep your work area clean and well lit. Cluttered benches and dark areas invite accidents.
2. Do not operate the tool in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust. This tool can create sparks which may ignite the dust or fumes.
3. Keep bystanders, children, and visitors away while operating this tool. Distractions can cause you to lose control. Protect others in the work area from debris such as chips and sparks. Provide barriers or shields as needed.

Personal Safety

1. Stay alert. Watch what you are doing, and use common sense when operating this tool. Do not use this tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating this tool may result in serious personal injury.
2. Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep hair, clothing, and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts.
3. Remove adjusting keys or wrenches before using this tool. A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.
4. Do not overreach. Keep proper footing and balance at all times. Proper footing and balance enables better control of the tool in unexpected situations.
5. Use safety equipment. Always wear eye protection. Nonskid safety shoes, hard hat, and gloves must be used for appropriate conditions. Always wear ANSI approved safety goggles when using or performing maintenance on this tool

Tool Use and Care

1. Do not force the tool. Use the correct tool for your application. The correct tool will do the job better and safer at the rate for which it is designed. Do not force the tool and do not use the tool for a purpose for which it is not intended.
2. Store idle tools out of reach of children and other untrained persons. Tools are dangerous in the hands of untrained users.
3. Maintain tools with care. Properly maintained tools are less likely to bind and are easier to control. Do not use a damaged tool. Tag damaged tools "Do not use" until repaired.
4. Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tool's operation. If damaged, have the tool serviced before using. Many accidents are caused by poorly maintained tools.



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5. Use only accessories that are recommended by the manufacturer for your model. Accessories that may be suitable for one tool may become hazardous when used on another tool.

Service

1. Tool service must be performed only by qualified repair personnel. Service or maintenance performed by unqualified personnel could result in a risk of injury.
2. When servicing a tool, use only identical replacement parts. Follow instructions in the "Inspection, Maintenance, And Cleaning" section of this manual. Use of unauthorized parts or failure to follow maintenance instructions may create a risk of electric shock or injury.

Specific Safety Rules

1. Maintain labels and nameplates on the tool. These carry important information. If unreadable or missing, contact JEGS for a replacement.
2. Maintain a safe working environment. Make sure there is adequate surrounding workspace. Do not use this product in a damp or wet location.
3. Work piece may be sharp. After bending or cutting work pieces use caution. Sharp edges or sharp shreds of metal may be created that can cut arms and hands. Always wear heavy duty gloves when handling work piece.
4. Mount the English Wheel stand to the floor to avoid it from moving or tipping when bending large work pieces.
5. Practice operation of the English Wheel on scrap metal before attempting work on the actual stock.
6. Never allow children to touch this product; keep children out of the work area.

WARNING: The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by operator.

Unpacking

When unpacking, check to make sure that the item is intact and undamaged. If any parts are missing or broken, please call JEGS at 1-800-345-4545.

Assembly Instructions

For additional information regarding the parts listed in the following pages, refer to the Assembly Diagram near the end of this manual and the photo below.

1. Unpack the English Wheel components on the floor where the unit will be located and mounted. The floor must be able to support the weight of the English Wheel and the work pieces.
2. With the upper Frame (1) and Back Stand (17) assembled and lying on the floor, attach the Link Bracket (19) to the Back Stand (17) using two Bolts (35), four Washers (24), and two Nuts (26). Tighten Nuts and Bolts securely.
3. With the help of at least two other people, lift the assembled Frame so that it is upright and balanced on the Back Stand. The Frame must be supported until the total Frame assembly is complete, and all Nuts and Bolts securely tightened.
4. Slide the Front Stand (15) under the Front Tube (16) so that the mounting holes align.
5. Insert two Bolts (25), with two Washers (24), into the holes of the Front Tube (16) and Front Stand (15).



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6. Attach the unsecured end of the Link Bracket (19) to the Front Stand (15) using two Bolts (35), four Washers (24), and two Nuts (26).

7. Securely tighten all assembled frame components.

8. Assemble Eccentric Shaft (7) and Handle (6) with Screw (33).

9. Insert Steel Tube (5) into the Bottom Die Yoke (8). Secure with Screw (32). Place assembly into the mounting hole in Frame (1).

10. Screw Knob (4) into the threaded hole on Frame (1). Lift and turn Steel Tube (5) assembly so the Knob (4) seats into the slot of Steel Tube (5). Tighten Knob (4).

11. Insert Eccentric Shaft (7), with Handle (6), into the hole of Bottom Dies Yoke (8). (7)

12. Thread each Handle Lever (20) into the Thread Rod (14). Securely tighten. Thread on Ball Handles (21).

13. Screw Thread Rod (14) into the bottom of Frame (1). The threads will set into Steel Tube (5) already installed in Frame (1).

14. Assemble the Top Die (2) with Bearing (9) on each side. Place into the top of Frame (1). Secure in place with Shaft (3), two Washers (22), and Nut (31). Securely tighten.

15. Mount Bottom Die Rack (13) to Frame (1) and Back Stand (17) using two Bolts (28). Washers (29), and Nuts (30). Securely tighten.

16. Install Bearing (9) and Shaft (10) in each Bottom Die (11-1 thru 11-6).

17. place each Bottom Die on the Bottom Die Rack (13). Each Bottom Die has its size stamped on it. Place in order of size on the rack.

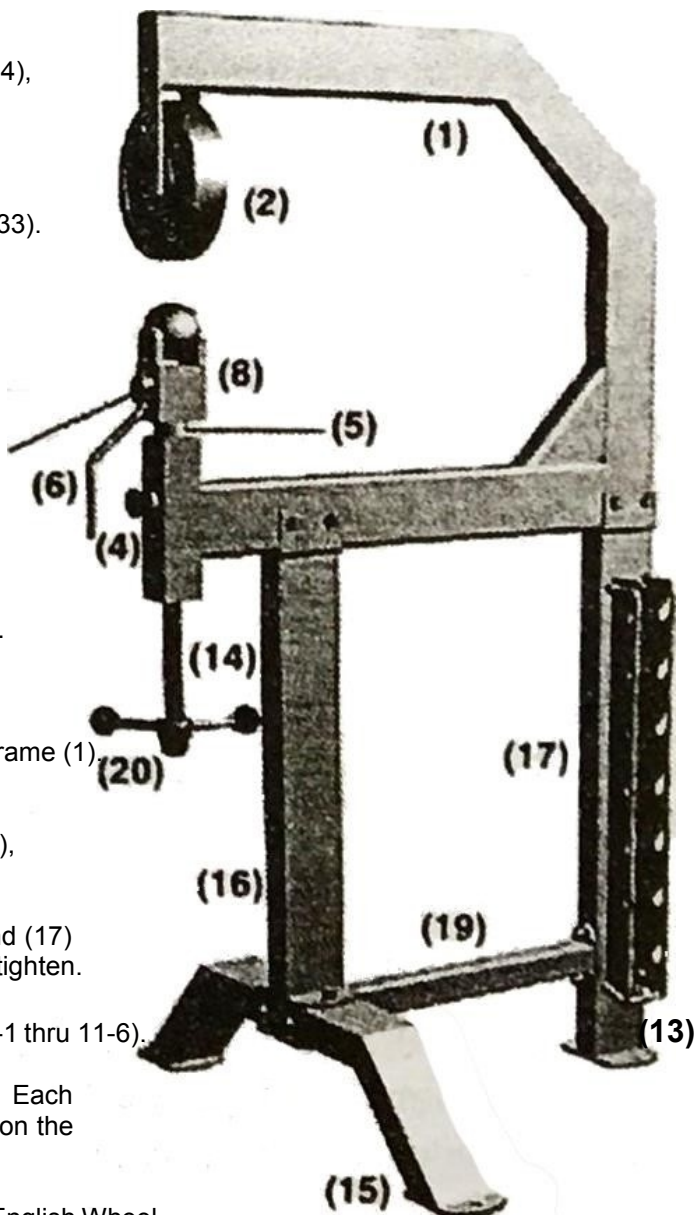
18. With the help of two other people, move the assembled English Wheel to the location where it will be mounted to the floor. Measure the size of the mounting holes in the Front Stand (15) and Back Stand (17), then drill appropriate size holes in the floor to accommodate the mounting hardware (not supplied).

Operating Instructions

Warning: Metal edges can be very sharp. Avoid injuries by wearing ANSI approved safety equipment.

1. Select the Bottom Die from the Bottom Die Rack, and place on the Bottom Die Yoke. When selecting the Bottom Die, consider the type and hardness of the metal being formed as well as the desired curvature of the metal.

2. Insert the work piece in between the Top Die and the Bottom Die.



3. Turn the Thread Rod to raise or lower the Bottom Die Yoke for appropriate clearance (or pinching) of the metal between the two dies. It is better to have a loose pinch than a tight one. A tight pinch will make it harder to push the metal through and may cause unwanted creasing. A loose pinch makes it easier to push the metal through, and with more accuracy. It may take more passes to form the metal, however.

4. Turn Knob clockwise until tight.

5. Begin forming the metal by pushing and pulling it over the dies.

6. If small distance adjustments are required between the dies, loosen Knob (4) and turn Handle. This causes the Eccentric Shaft to slightly raise or lower the Bottom Die. Tighten Knob again before proceeding.

Inspection, Maintenance, and Cleaning

BEFORE EACH USE, inspect the general condition of the tool. Check for loose screws, misalignment or binding of moving pads, cracked or broken parts, damaged electrical wiring, and any other condition that may affect its safe operation. If abnormal noise or vibration occurs, have the problem corrected before further use. **Do not use damaged equipment.**

Maintenance Chart

Maintenance Type	Before Use	After Use	Weekly	In Between	Every 6 Months	Yearly
Inspect tool for damage	x					
Wipe off with clean cloth		x	x	x	x	x
Oil moving parts with a light oil				x		

Parts List

Part	Description	Qty
1	Frame	1
2	Top Die	1
3	Shaft	1
4	Knob	1
5	Steel Tube	1
6	Handle	1
7	Eccentric Shaft	1
8	Bottom Die Yoke	1
9	Bearing	16
10	Shaft	7
11	Bottom Die, 50.8mm, 2"	1
13	Bottom Die Rack	1
14	Thread Rod	1
15	Front Stand	1
16	Front Tube	1
17	Back Stand	1
19	Link Bracket	1

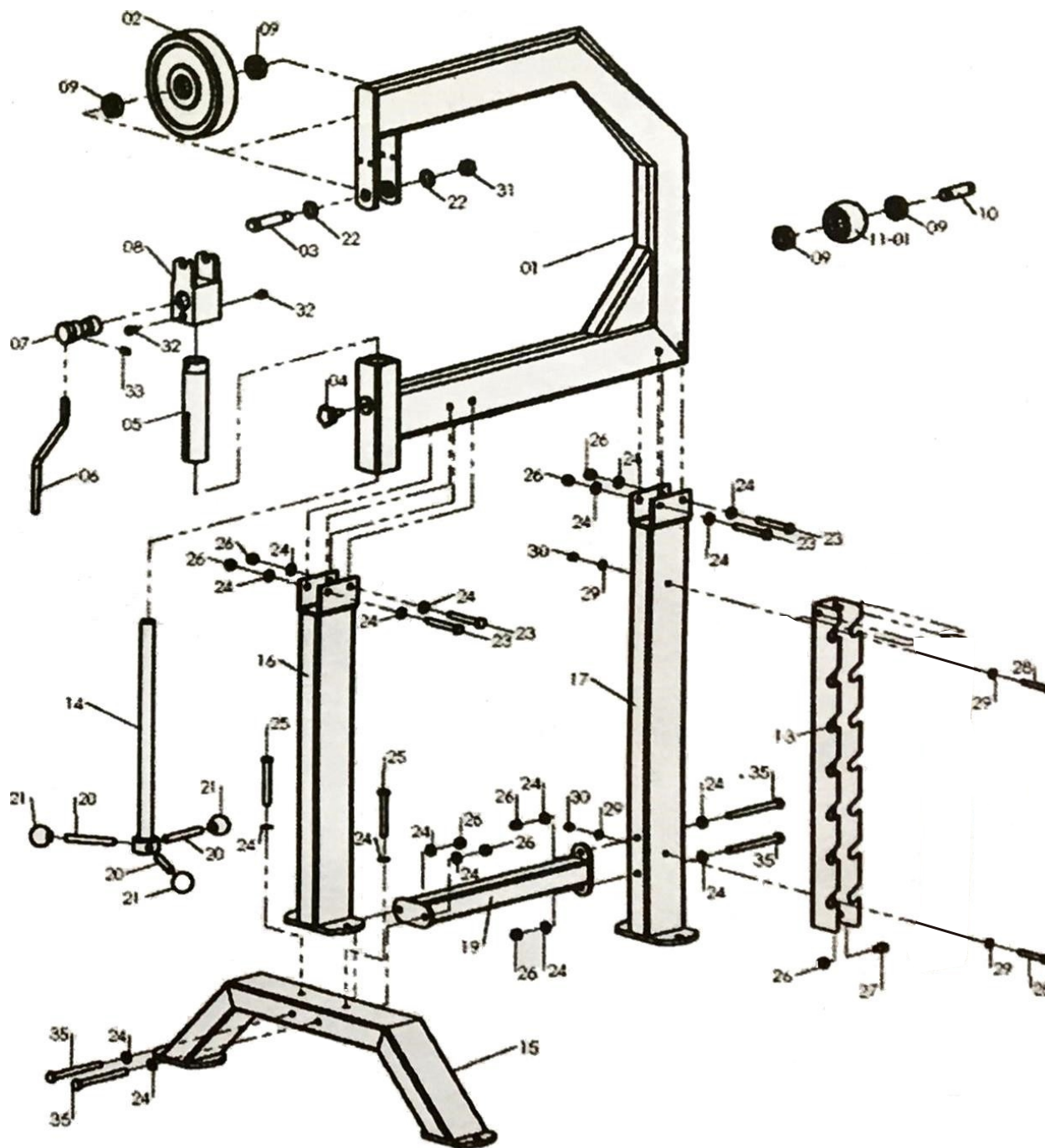
Part	Description	Qty
20	Handle Lever	3
21	Handle Ball	3
22	Washer, 20mm	2
23	Bolt, M10 x 80	4
24	Washer, 10mm	20
25	Bolt, M10 x 85	2
26	Nut, M10	11
27	Screw, M10 x 15	1
28	Bolt, M8 x 120	2
29	Washer, 8mm	6
30	Nut, M8	3
31	Nut, M16	1
32	Screw, M8 x 12	2
33	Screw, M10 x 16	1
35	Bolt, M10 x 130	4

*Size of each Bottom Die stamped on end.



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Assembly Diagram



Record Product & Serial Number Here:

Note: If product has no serial number, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts.



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