

Eastwood

DO THE JOB RIGHT.

Item #20622

MOTORIZED BEAD ROLLER

INSTRUCTIONS

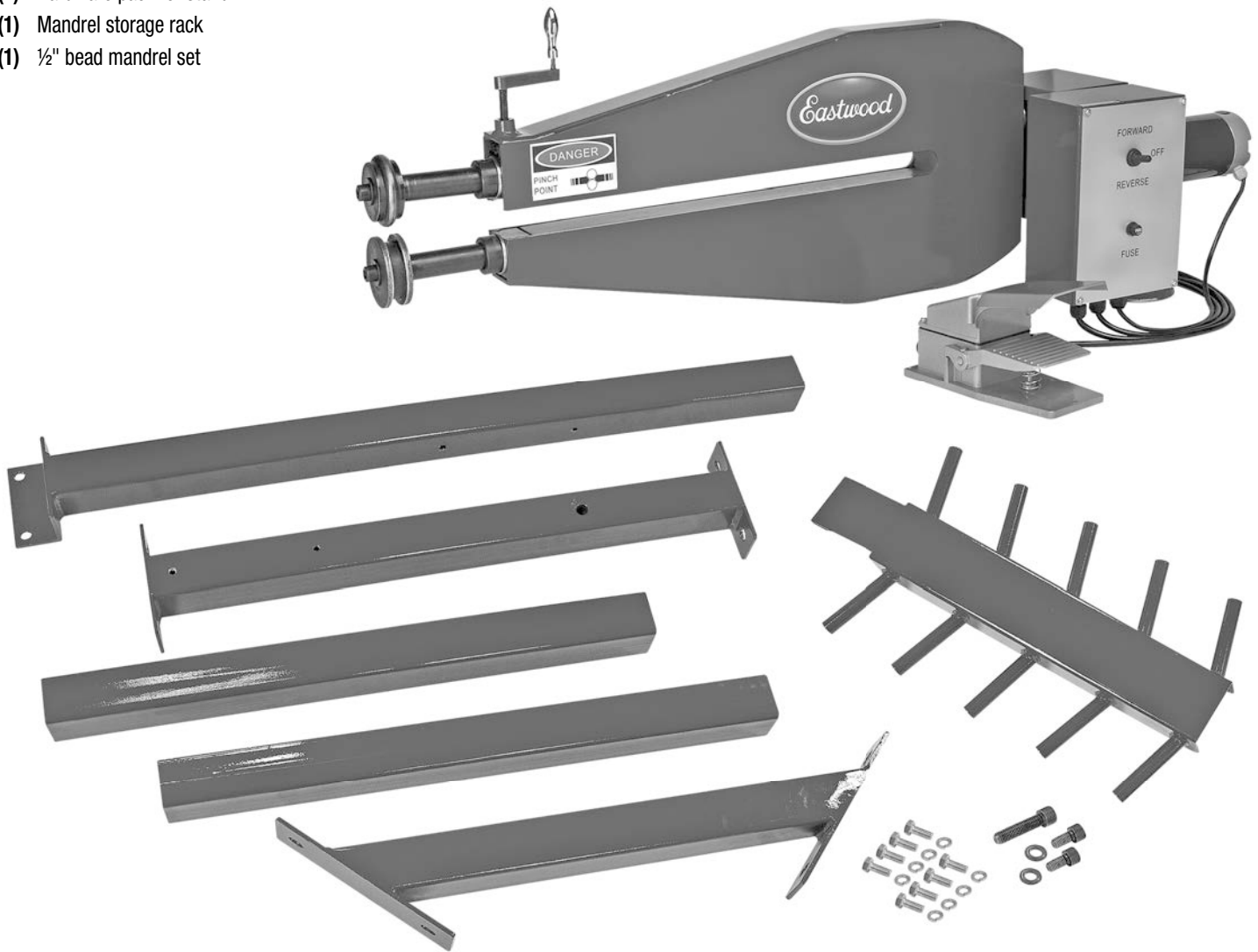


The **Eastwood Motorized Bead Roller** is a professional metal fabrication tool. It is excellent for producing strengthening ribs in replacement floor pans, firewalls, trunk floors, inner fenders, and more. With its full range of bead mandrels, it can also create decorative custom designs in door panels, dashes and much more. Channels and flanges can be formed using offset flange mandrels.

INCLUDES

The motorized bead roller ships in 2 boxes – one containing the assembled bead roller and one containing the unassembled stand. Open both boxes and verify that all components are present.

- (1) 24" throat motorized bead roller frame
- (1) Foot pedal
- (1) Stand
- (1) Hardware pack for stand
- (1) Mandrel storage rack
- (1) ½" bead mandrel set



SPECIFICATIONS

- Maximum material working thickness: Steel = 18 Gauge, Aluminum = 16 Gauge
- Maximum panel width (working from center) = 48"
- Shaft diameter/Mandrel bore 3/4"

NOTE: Eastwood Bead Roller Forming Dies (#20267) are not compatible with this bead roller

SAFETY INFORMATION

In this manual, on the labeling, and all other information provided with this product:

DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING

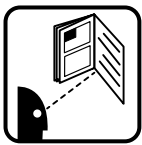
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE

NOTICE is used to address practices not related to personal injury.



- Read and understand all instructions before using this machine. Save this instruction manual for future reference.
- Keep out of reach of untrained persons and children.



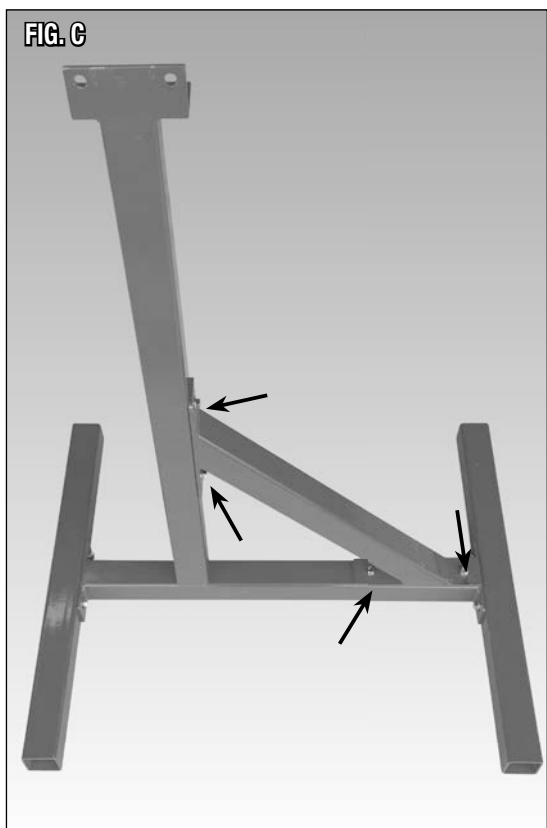
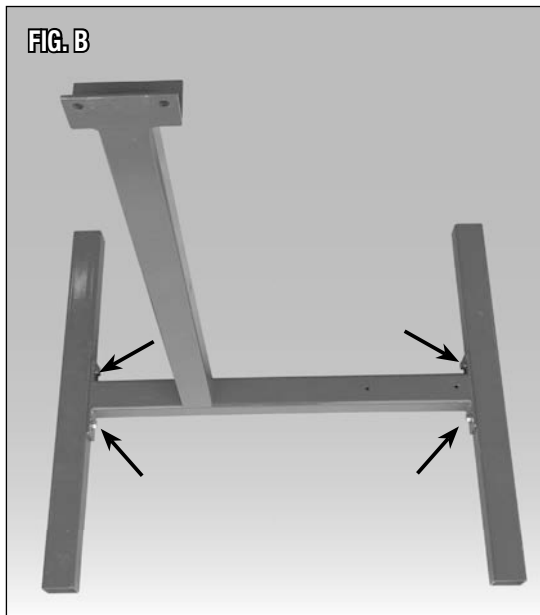
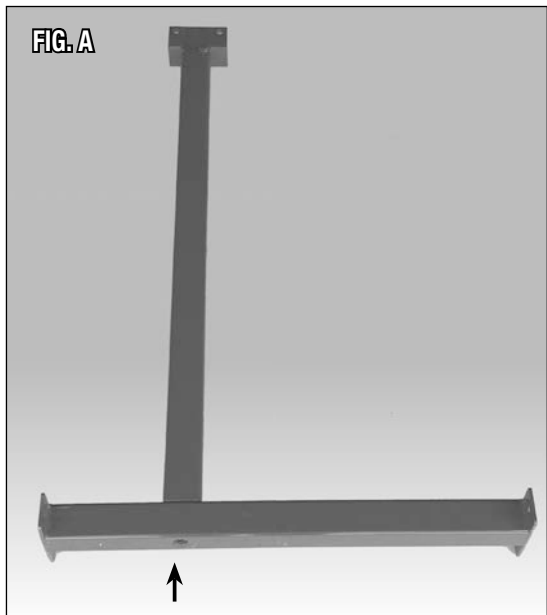
WARNING INJURY HAZARDS!

- The cut edges of sheet metal are sharp and can cause severe cuts to hands, arms, body and face. Wear thick, well fitting work gloves and protective clothing to prevent injury.
- This tool has rotating rollers which can quickly cause injury. Keep fingers and hands away from moving parts when operating.
- Unplug bead roller before adjusting or changing mandrels to prevent accidental starting and injury.
- Unplug bead roller when not in use.
- Wear eye protection.



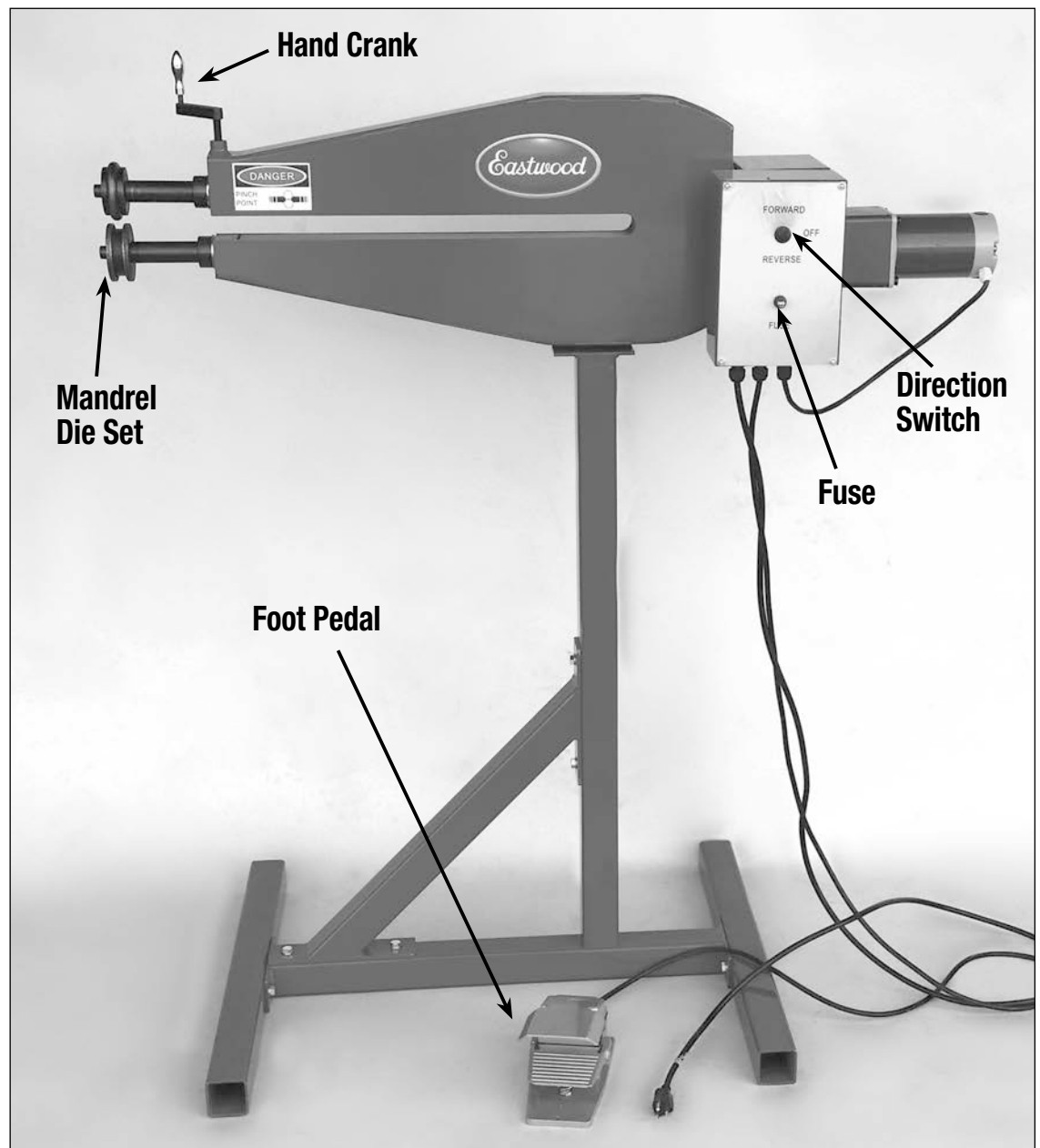
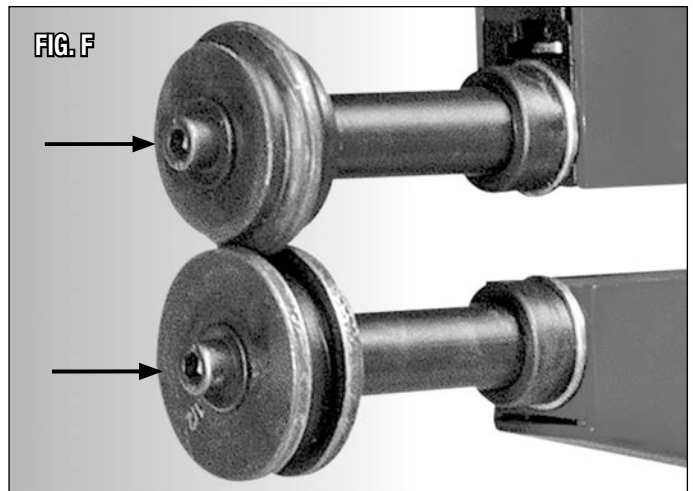
ASSEMBLY INSTRUCTIONS

1. Attach the vertical post to the base using (1) M12 x 1.75 socket head cap screw (**FIG. A**).
2. Attach the two feet to the base using (4) M8 x 1.25 hex head cap screws (**FIG. B**).
3. Attach the diagonal brace as shown below using (4) M8 x 1.25 hex head cap screws (**FIG. C**).
4. Attach the motorized bead roller to the base using (2) M10 x 1.5 socket head cap screws (**FIG. D**).
5. Hang the mandrel rack on the stand by putting the hook of the rack in the space between the (2) M10 x 1.5 socket head cap screws that hold the bead roller to the stand (**FIG. E**).



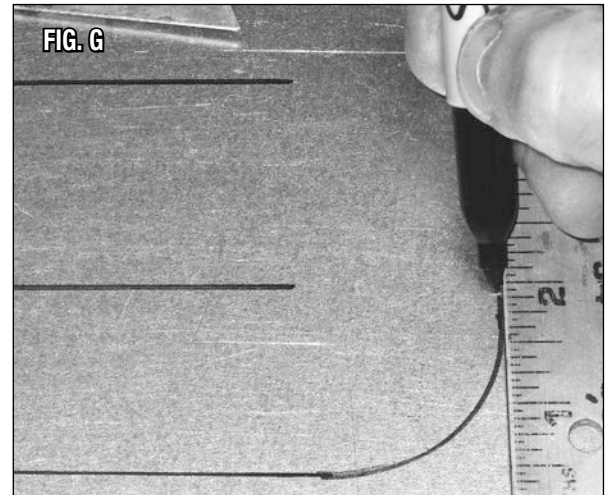
MANDREL DIE INSTALLATION

- Remove the socket head cap screw and washer on the lower shaft and install the female mandrel die of the die set. Replace the washer and cap screw (FIG. F).
- Remove the socket head cap screw and washer from the upper shaft. Using the hand crank, raise the upper shaft until the male mandrel die can be installed. Replace the washer and socket head cap screw (FIG. F).
- Removal is the reverse of installation.



LAYOUT & PLANNING

- Using a suitable marker, draw the pattern or shape you want to form with beads right on the panel. We recommend using a T-square and straightedge or long ruler for straight lines. For curves, use a circle or radius template.
- Work carefully and lay out your design lines as neatly as possible (**FIG.G**).
- When forming beads, be sure to work from the inside of the piece toward the outside. The bead roller shrinks metal and if you work from the outside toward the center, the bead you previously formed will be distorted and the entire piece may warp.



GETTING STARTED

- Ensure that the bead roller direction switch is in the off position. Plug in the bead roller.
- Put the bead roller direction switch in the forward direction and slowly depress the foot pedal. Check that the mandrel dies turn freely without binding. Reverse the direction of the bead roller and check again.
- Raise the upper shaft by turning the hand crank until the work piece can be slid between the mandrels.
- Center the upper mandrel die ridge over the previously drawn pattern line, then lower the upper shaft to take up the slack.
- Tighten the hand crank to begin forming the bead.
CAUTION: Do not over tighten as this may tear the metal work piece, jam the roller dies or deform the frame.
- Slowly depress the foot pedal to start the bead roller and begin forming a bead.

CREATING STRAIGHT BEADS

- Drive the bead roller slowly as you follow your marked guideline (**FIG. H**).
- Keep the marked guideline aligned with the center of the upper male mandrel die ridge as you go. When you reach the end of the guideline, you may re-roll the bead by switching the drive motor to the opposite direction. This produces a more sharply defined bead. Tightening the hand crank and re-rolling will make a more pronounced bead.
- When finished, turn the crank handle to raise the upper mandrel die until the work piece can be removed.



FORMING CURVES

- The trick to forming curves with the bead roller is careful coordination between the motor speed controlled by the foot pedal, and the movement of the work piece through the mandrel dies.
- Proceed slowly, and keep the guideline aligned with the center of the upper male mandrel die ridge as you go. If your design forms an oval, start the bead in the center of a straight or larger radiused section.
- Do not start at a corner or a joint between two lines, since it will be extremely difficult to line up the bead perfectly when you finish.
- By using combinations of curves and straight lines, there is almost no limit to the designs you can create with the Eastwood Motorized Bead Roller.

STORAGE:

- Apply a thin film of light oil or rust-preventive to all bare steel areas.
- Store in a clean dry area, preferably under a loose fitting breathable cover.

MAINTENANCE:

NOTE: Maintenance should be performed before each use.

- Clean dirt and debris from Mandrel Dies.
- Check tightness of all hardware.
- Check operation for binding.

AVAILABLE BEAD ROLLER DIE KITS:

- #20623 – 1/8" Round Bead Kit
- #20624 – 1/4" Round Bead Kit
- #20625 – 3/8" Round Bead Kit
- #20626 – 1/16" Step Roll Kit
- #20627 – 1/8" Step Roll Kit
- #20628 – 1-1/4" Spoiler Roll Kit

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: techelp@eastwood.com
PDF version of this manual is available online >> eastwood.com/20622manual

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