BEAD ROTARY MACHINE

OPERATION MANUAL

WARNING

Read and understand all instructions before using this tool. The operator must follow basic precautions to reduce the risk of personal injury and/or damage to the equipment.

HAZARD DEFINITIONS

Please familiarize yourself with the hazard notices found in this manual. A notice is an alert that there is a possibility of property damage, injury or loss of life if certain instructions are not followed.

DANGER! This notice indicates an immediate and specific hazard that will result in severe personal injury or loss of life if the proper precautions are not taken.

WARNING! This notice indicates a specific hazard or unsafe practice that could result in severe personal injury or loss of life if the proper precautions are not taken.

CAUTION! This notice indicates a potentially hazardous situation that may result in minor or moderate injury if proper practices are not taken.

NOTICE! This notice indicates that a specific hazard or unsafe practice will result in equipment or property damage, but not personal injury.

WORK AREA

1. Operate in a safe work environment, Keep your work area clean, well- lit and free of distractions. Place lights so you are not working in a shadow.
2. Keep anyone not wearing the appropriate safety equipment away from the work area.
3. Store unused tools properly in a safe and dry location to prevent rust or damage. Lock tools away and keep out of the reach of children.

Usage

1. This bead roller Rotary machine is hand operated and will form sheet metal up to 18 Gauge thickness mild steel (or equivalent). The Rotary machine is constitute of cast iron and steel, and ensuing minimum deflection of the work piece dung forming operations. Six die sets are included, allowing the following operation to be performed wiring, edging, ogee bead, single bead, and elbow edging.

2. Main technical specification

Model	RM- 18
Max. Capacity of Mild Steel	18 Gauge
	1.2mm
Throat Depth	18”
	457mm
Six Pairs of Dies	1/16", 1/8", 1/4" step dies and 1/4", 3/8", 1/2" bead dies
	1.6mm, 3.2mm, 6.35mm step dies 6.35mm, 9.5mm, 12.7mm bead dies
Packing Size (L x W x H)	28-47/64” x 10-7/16” x 5- 1/8”
	730mm x 265mm x 130mm
Net Weight	57.3 lbs
	26 kg
Shipping Weight	59.5 lbs
	27 kg

3. Installation and caution

3.1 Installation

3.1.1 Please check whether the part of this machine are fully equipped and not damaged according to the parts list or part figure.

3.1.2 This machine should be mounted on table clamp or specific stand (not supplied), Be sure to provide clearance for crank am rotation area.

3.1.3 Please leave plenty room around the machine for your easy operating, in order to avoid injury.

3.1.4 Please remove the anti- rust grease on processing surfaces and some parts included kerosene.

3.2 Caution

3.2.1 Please read the manual before operation and make yourself understand its structure and principle completely.

3.2.2 Please don't operate the material width and thickness than table list max. range.

3.2.3 Do not force the rotary machine. It will do the job better and more safety at the rate for which it was intended.

3.2.4 Do not over reach. Keep proper footing and balance at all times.

3.2.5 Please don’t touch the bead roller during operation.

3.2.6 Stay alert watch what you are dong Do not operate any machinery when you are tired.

4. Operation

4.1 Select the die set required for the operation to be performed.

4.2 Place spacer's dies and retaining nuts onto the driving and driven shafts Tighten the retaining nuts with wrench provided.

4.3 Adjust the position of the upper die according to thickness of the work piece by using the adjusting handle.

5. Maintenance

5.1 Keep tools clean for better and safer performance Keep handle dry, clean.

5.2 Check for damaged parts, before using any tool, any part that appears damaged should be carefully checked to determine that it would operate properly and perform its intended function Check for alignment and binding of moving parts, any broken pans or mounting fixtures, and any other condition that may affect proper operation Any part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.

5.3 All exposed iron surfaces should be coated with light oil to prevent rusting Use a multi-purpose or bearing grease for lubrication.

5.4 The adjusting block should be greased.

5.5 Oil the driving shaft through the oil ports monthly.

6. Parts list

Part#	Description	qty
1	Head screw M10	2
2	Washer	2
3	Hex screw	4
4	Concave wheel	1
5	Screw	1
6	Washer	2
7	Head screw M12	4
8	Cam	1
9	Hex Screw M6	2
10	Bushing	2
11	Main spindle	1
12	Driven shaft	1
13	Vertical bracket	1
14	Washer	4
15	Supporting block	4

Part#	Description	qty
16	Copper bushing	2
17	Gear	2
18	Square screw	1
19	Handle	1
20	Handle lever	1
21	Concave wheel II	1
22	Cam II	1
23	Cam III	1
24	Concave wheel III	1
25	Roll dies Ⅰ-1	1
26	Roll dies Ⅰ-2	1
27	Roll dies Ⅱ-1	1
28	Roll dies Ⅱ-2	1
29	Roll dies Ⅲ-1	1
30	Roll dies Ⅲ-2	1

7. Assembly diagram