

ENGLISH WHEEL

Model: F1.2X710



Assembly and Operating Instructions

DESCRIPTION

English Wheel is hand operated and will form sheet metal up to 1.2mm thickness mild steel (or equivalent). The English wheel is constructed of cast iron and steel ensuring minimum deflection of the workpiece during forming operations.

SAVE THIS MANUAL

You will need this manual for the safety instructions, operating procedures. Maintenance procedures, parts list, and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep both this manual and your invoice in a safe dry place for future reference.

Check for shipping damage. If damage has occurred, a claim must be filed with carrier. Check for completeness. Immediately report missing parts to dealer.

READ ALL INSTRUCTIONS BEFORE USING THIS TOOL!

SAFETY INSTRUCTION

1. **KEEP WORK AREA CLEAN.** Cluttered areas invite injuries.
2. **OBSERVE WORK AREA CONDITIONS.** Do not use tools in damp, wet, or poorly in locations. Don't expose to rain. Keep work areas well fit. Do not use electrically powered equipment in the presence of flammable gases or liquids.
3. **KEEP CHILDREN AWAY.** Children must never be allowed in the work area. Don't let them handle the benders.
4. **STORE IDLE EQUIPMENT.** When not in use, tools must be locked up in a dry location without rust. Always lock up tools and keep out or reach of children.
5. **DO NOT FORCE THE ROTARY MACHINE.** It will do the job better and more safety at the rate for which it was intended.
6. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
7. **MAINTAIN TOOLS WITH CARE.** Keep tools clean for better and safer performance. Keep handle dry, clean, and free from oil and grease.
8. **STAY ALERT.** Watch what you are doing. Do not operate any machinery when you are tired.
9. **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 parts 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.

10.REPLACEMENT PARTS AND ACCESSORIES. When servicing, use only identical replacement parts. Only use accessories intended for use with this tool.

11.DO NOT OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS. Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

SPECIFICATIONS

The English Wheel with an optimal working depth for all sheet metals

- Deep throat of 710 mm for sheets over 1400mm
- LxWxH=960x870x1524mm, Weight: 75kg, incl. forming wheels.
- For steel sheets up to ca. 1.2mm, aluminium ca. 1.9mm, strengthening easily possible.
- Professional version with pressure control by foot, quick lever mechanism and sideways adjustment of the lower forming rolls.
- Upper wheel now with round edges for a scratch free result made from new improved specially hardened steel.
- Upper wheel now movable for optimum and easy adjustment!
- Industrial forming wheels made from tool quality steel (CNC finished, hardened and perfectly polished) for professionals and the industry. Excellent for polishing aluminum etc.

ASSEMBLY AND OPERATION

Machine should be installed on a level surface, with proper lighting. Area around machine should be clear of scraps, oil or dirt. Apply a suitable non-skid material to floor. Be sure to keep hands clear of forming wheels when rotating crank handle.

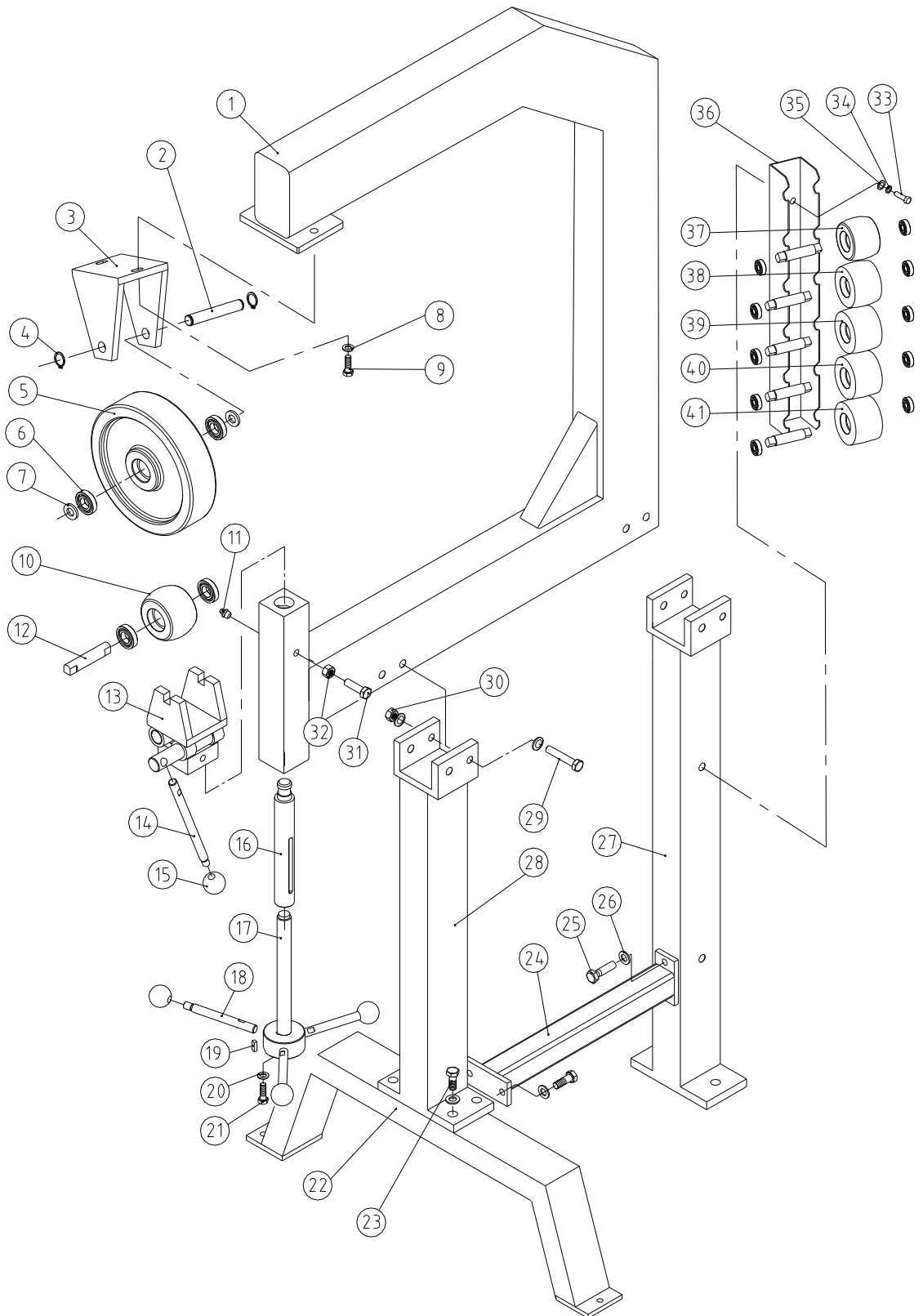
1. The front leg 28# is fixed with back leg seat 22# through bolt 23#, and washers, and the back leg 27# is connected with front leg and seat through connecting pipe 24# and flat washer 26#,bolt 25#.
2. The upper frame 1# is fixed with leg support 28#, 27# through bolt 29#, washer 26# and nut 30#.
- 3.The upper wheel bracket 3# is connected with upper wheel 5# through shaft pin 2# . The bearing 6# is respectively put into the both side of curve of upper wheel 5# . Then the upper wheel 5# and bracket 3# is fixed with upper frame 1# through bolt 9# and washer 8#.
4. The bearings 6# which are put in the both ends of the wheel 10# (37# 38# 39# 40# 41#) are connected with shaft pin12# so as to process one set and a work piece. Then you can put this set and work piece to the upper socket of 13#.

5. The shaft 16# are put into the upper frame 1 # from the upper hole and then fixed by guiding bolt 31# and nuts 32# to make the shaft 16# can not be rotary but can sliding up and down. Inserted adjustable threaded shaft 17 # to the upper frame 1# from the lower hole and connected with the flat key 19# and handle seat , then fixed by washer 20# and bolt 21#. The top of 16# is connected with adjustable support stand13# and locked tensely with bolt 14#.
6. The end of adjustable handle 18# with marking device is inserted into handle seat .You can turn the handle to adjust the distance between lower wheel 13# and threaded shaft17#.
7. The hanger 36# is fixed with upper frame through spring washer 34,flat washer 35 and bolt 33.
8. After assembling the whole machine, the work piece will be processed between upper wheel 5# and lower wheel 13#. According to the needs of processing, you can choose wheel 37#, 38#, 39#, 40#, 41# instead of 10#.

LUBRICATION

1. All exposed iron surfaces should be coated with light oil to prevent rusting. Use a multi-purpose or bearing grease for lubrication.
2. The adjusting block should be greased.
3. Oil the driving shaft through the oil ports monthly.

ASSEMBLY DRAWING



PARTS LIST

Part No.	Description	QTY	Remark
1	Main frame	1	
2	Upper wheel shaft	1	
3	Bracket for upper wheel	1	
4	Cover	2	
5	Upper wheel	1	
6	Bearing	14	
7	Washer	2	
8	Flat washer	2	
9	Hex. Bolt	2	
10	2" Lower wheel	1	
11	Oil cup	1	
12	Lower wheel bearing	6	
13	Bracket for lower wheel	1	
14	Handle	1	
15	Handle ball	4	
16	Adjustable shaft	1	
17	Adjustable threaded shaft	1	
18	Handle	3	
19	Flat key	1	
20	End Cover	1	
21	Hex. Bolt	1	
22	Back Leg seat	1	
23	Hex. Bolt	4	
24	Connecting pipe	1	
25	Hex. Bolt	4	
26	Flat washer	16	
27	Back Leg	1	
28	Front Leg	1	
29	Hex. Bolt	4	
30	Nut	4	
31	Guide bolt	1	
32	Nut	1	
33	Screw	2	
34	Spring washer	2	
35	Flat washer	2	
36	Hanger	1	
37	3" Lower wheel	1	
38	4" Lower wheel	1	
39	6" Lower wheel	1	
40	8" Lower wheel	1	
41	12" Lower wheel	1	