

BEAD FORM JUNIOR 3/8"



INSTRUCTIONS

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STEP1: Choosing your tubing

Never use hardened tubing. Always use tubing that is soft or has been annealed. This will insure that the tube will not crack or break during bead forming operation. Bead form JR is designed for tubing with a maximum wall thickness of 0.028inches. Bead form 3/8" and 1/2" can be used for thicker wall depending on the material used. If you are using stainless steel, it must be annealed.

STEP 2: preparing your tube for forming.

The tubing to which you are applying a bead must be cut off square and edge must be chamfered. If the tubing has a weld seam on the inner diameter, remove it with a grinder, file, lathe, etc.

STEP 3: Setting Bead Form for tubing wall thickness.

Before beginning your bead, set the final roller separation distance. Set this distance by placing your tube section between the two rollers and tighten the T-handle. Do not insert the tube between the actual forming surface (see figure a). When you've tightened the T-handle so that the tube is loosely clamped between the two rollers, set the jam nut so that the larger roller travel is limited here. The jam nut is set by placing a wrench on the nut and 3/16 inch Allen wrench through the top of the T-handle. During this operation, do not turn the crank handle. You are simply limiting the distance the rollers can together during the actual forming operation. Once the jam nut is set, loosen the T-handle and remove the tube section.

STEP 4: Forming the bead.

Liberally oil the inner and outer surface of the tube. Insert the tube against the stop block and lower the larger roller with the T-handle until it touches the tube. Now, turn the T-handle 1/8 turn into the tube and run the tube through two or three rotations with the crank. Proceed in the manner, advancing the T-handle 1/8 turn each time until you reach your pre-set limit of travel. Your bead should now be fully formed.

STEP 5: Inspection and caution.

When finished with the bead forming process, remove the tube section (by raising the T-handle), wipe off any excess oil, and inspect the inner and outer surface of the bead.

Caution: it is possible to fracture or cut the tubing in the weld area or through the bead section. If you see such cracking, consider using soft material.

