

BEAD ROLLER MACHINE

MODEL: RM24 / RM36 / RM42



OPERATING MANUAL

SAFETY

The purpose of the safety section of this manual is to inform operators and maintenance personnel of the precautions to be taken while operating or servicing the machine. The following are a few basic guidelines to follow, but as with any type of machinery good judgment and a safe attitude should be applied at all times.

1. Always disconnect power, lock-out and tag-out machine per OSHA regulations before attempting to service this machine.
2. Always wear safety glasses or other approved eye protection while operating or servicing the machine.
3. Keep all body parts and any foreign objects away from moving parts. Don't reach into the machine without first disconnecting all power sources.
4. Do not attempt to override any safety device on the machine.
5. Do not operate the machine if it has been damaged or is not operating properly.
6. Do not wear jewelry (watches, rings, necklaces, etc.), or loose fitting clothing while operating or servicing the machine.
7. The machine should only be operated or serviced by properly trained, authorized personnel.
8. Replacement parts should have the same specification and operation as the original parts on the machine.
9. All guards and covers must be in place before operating the machine.
10. Before starting the machine be sure it is set up properly.
11. Make sure the machine is properly grounded.
12. The machine and work area should be kept neat and clean.
13. Do not operate or service any machine while under the influence of drugs or alcohol.

NOTE: THESE SAFETY RULES ARE FOR YOUR BENEFIT TO HELP PREVENT INJURY TO YOURSELF AND/OR YOUR CO-WORKERS. REVIEW ALL SETUP AND OPERATING PROCEDURES, WHETHER COVERED OR NOT, IN THIS MANUAL TO HELP INSURE SAFE OPERATION OF THE MACHINE.

MACHINE SET UP

1. Remove machine from packaging.
2. Assemble stand by bolting through the bottom of stand with the M12x60 allen bolt.
3. Then secure gusset from the top with (2) M8X16 bolts.
4. Place machine on top of the bead roller stand and secure using (2) M10x25 allen bolts.
5. Remove the shoulder bolt holding the aluminum handle to the bottom of the bead depth adjuster.
6. Place the aluminum handle on top of the bead depth adjuster and secure using the shoulder bolt.
7. Remove the (2) M10x25 allen bolts and washers from the ends of the shafts.
8. Turn the bead depth adjuster counter-clockwise a few turns to allow room for the rolls to slide onto the shafts.
9. Place the bead rolls on the shafts toward the machine. Either roll can be put either shaft, but we usually recommend that the male type roll go on the top.
10. Secure the rolls to the shafts with the bolts removed in step #7 and snug them down.
11. Unwrap power cord and variable speed foot pedal.
12. Plug in the 110v volt power.

13. Machine is now ready for use.

OPERATION

1. Step down on the foot pedal to determine if the rolls are turning in the direction you are going to feed the metal from.
2. Release the foot pedal.
3. If the rolls are not turning in the proper direction, flip the forward / reverse switch.
4. Now you are ready to set your bead depth. This step will require some experimentation to get the proper depth so it is recommended that you use a scrap piece of the same material you want to bead roll.
5. Do not start with the rolls completely closed as you may find that the rolls are too close together and find it difficult to feed the material.
6. Lightly step down on the foot pedal and feed the metal in from the desired side of the machine. The foot pedal controls the speed.
7. Turn the bead depth adjustment clockwise until you get the desired bead depth. Now you are ready to bead roll your panel.
8. If you find that you need to change the direction of the rolls during a bead, release the foot pedal before changing from forward to reverse.

Part list

Item	Description	Specification	Qty
1	Motor	0.9 kw	1
2	Key	5x16	1
3	Linker	AL-075-16H	1
4	Washer of linker	AL-075	1
5	Linker	AL-075-19H	1
6	gear		2
7	Spring roll pin	6X50	2
8	Set collar	26	2

9	Key	6X20	1
10	Upper shaft		1
11	Lower shaft		1
12	Bolt	M8X7X9.9X5.5	1
13	Copper collar B		3
14	Upper shaft back block		1
15	Frame		1
16	Bolt	M8X7X9.9X5.5	1
17	Handle mount		1
18	Handle	M6X50	1
19	Upper shaft front block		1
20	Nut		1
21	Spring roll pin	3X14	1
22	Copper collar A		3
23	Set collar	26	2
24	Upper die		1
25	Washer	10	2
26	Allen bolt	M10X25	2
27	Allen bolt	M12X60	1
28	Base		1
29	Washer	8	2
30	Bolt	M8X16	2
31	Lower die		1
32	Stand		1
33	Roll hold		1
34	Allen bolt	M10X25	2
35	Washer	10	2
36	Motor mount plate		1
37	Switch box cover		1
38	Allen bolt	M10X25	2
39	Allen bolt	M6X20	4
40	Spring washer	6	4
41	washer	6	4

