

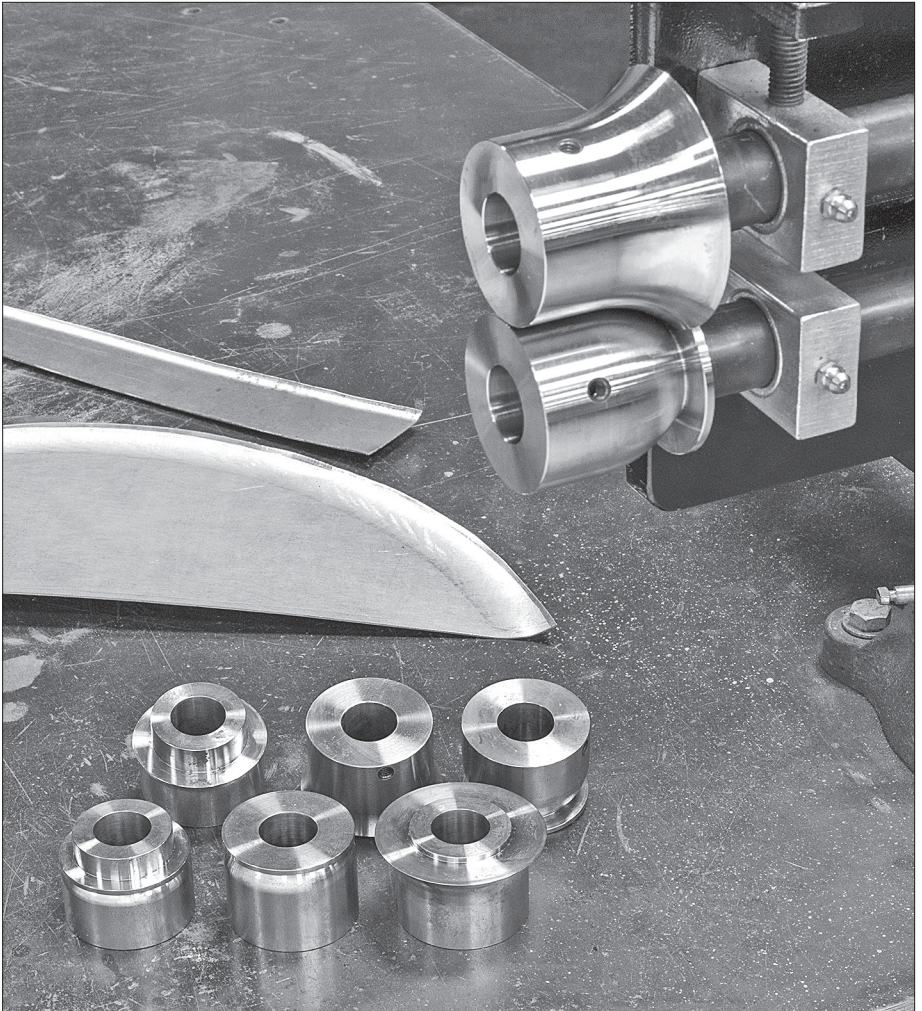


DO THE JOB RIGHT.®

Item #20269

# RADIUS EDGE DIES

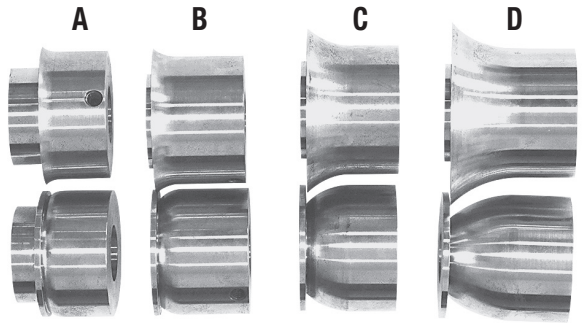
## INSTRUCTIONS



The **EASTWOOD RADIUS EDGE DIES** produce smooth, even, large-radius edges in steel and aluminum. Fits Eastwood #21487, #32044, 28187, and #21327 Bead Rollers and other units with 22mm shafts.

## CONTENTS

- (1) Set of 5/16 Radius Dies (A)
- (1) Set of 1/2 Radius Dies (B)
- (1) Set of 1" Radius Dies (C)
- (1) Set of 1-1/2" Radius Dies (D)



## SPECIFICATIONS

- Material: CR12
- Hardness: 35 HRc

## SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on 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.

# SAFETY INFORMATION



## **⚠ READ INSTRUCTIONS**

- Thoroughly read and understand this manual before using.
- Save for future reference.



## **⚠ WARNING PINCH AND CRUSH HAZARD!**

- Bead Rollers consist of heavy metal components which can present a hand/finger pinch hazard and cause potentially serious injuries if dropped. Avoid pinching hands while handling. The use of safety shoes is strongly recommended. Keep fingers and hands away from moving parts when operating.



## **⚠ WARNING CUT HAZARD!**

- Handling sharp metal can cause serious cuts. Wear thick, well-fitting work gloves to prevent cuts from handling sharp metal.



## **⚠ WARNING EYE INJURY HAZARD!**

- Metal particles can be ejected from the metal surface when bending. Sheet metal edges and corners are sharp and can injure eyes. Always wear ANSI approved eye protection when operating this tool.



## **⚠ WARNING**

- Before beginning ANY work with this tool, it is necessary that it be installed in a vice properly secured to a sturdy, workbench anchored to the floor or wall.
- Strenuous physical force may need to be applied to the Bead Roller during use. Failure to ensure proper footing can quickly result in a fall which could inflict serious personal injury or property damage. Always work in a clean, uncluttered environment.
- Be sure there is sufficient working room around the tool to allow for safe handling of various sizes of metal.

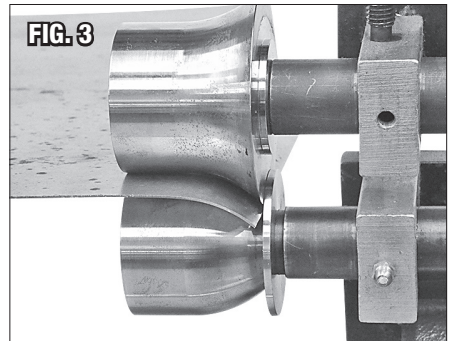
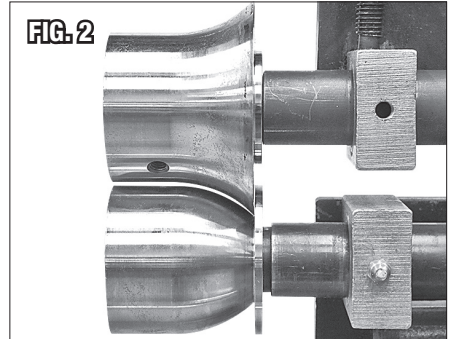
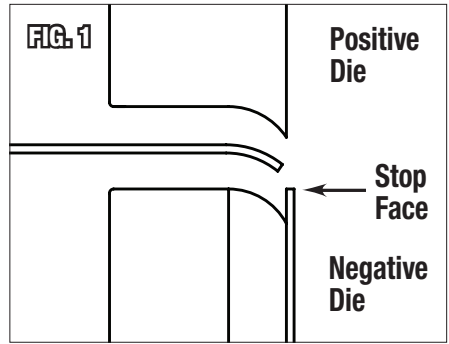


## **⚠ NOTICE**

- Excessive resistance while operating could indicate a defect with the workpiece material or broken or damaged Bead Roller components. To avoid injury, stop work immediately and inspect workpiece material for nicks, dents, welds, excessive scale or remaining coatings. Clean or repair as necessary or discard and begin with a new piece. Also inspect Bead Roller components for looseness or damage.

# SET UP AND OPERATION

- Follow the specific model Bead Roller Instructions for complete Bead Roller set-up and operation. If the Instruction Manual originally supplied with an Eastwood Bead Roller is unavailable, contact Eastwood at [www.Eastwood.com](http://www.Eastwood.com) or call 1-800-345-1178 to request a replacement.
- Install Dies so that the outer edge of the flare of the Positive Die just meets the stop face of the Negative Die (**FIG 1**).
- Adjust the spacing between the Dies to allow for the gauge of metal to be formed (**FIG 2**).
- Slowly feed the metal panel between the Dies keeping the edge firmly against the stop face of the Negative Die (**FIG 3**).



## STORAGE

- Apply a thin film of light oil or rust-preventive to all bare steel areas.
- Store in a clean, dust-free, dry, dampness-free area, preferably covered with plastic.

## ADDITIONAL ITEMS

- #51088 Shrinker/Stretcher Set
- #13475 Eastwood Electric Metal Shears
- #11797 Throatless Shear
- #14042 Versa Bend Sheet Metal Brake
- #20254 Eastwood 24" Slip Roll

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

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: [techhelp@eastwood.com](mailto:techhelp@eastwood.com)

PDF version of this manual is available at [eastwood.com](http://eastwood.com)

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