

Eastwood

DO THE JOB RIGHT.

Item #20552

BEAD ROLLER FENCE

INSTRUCTIONS



Create straight beads, flanges, cuts, and more with the **Eastwood Bead Roller Fence** attachment for the Bead Roller. The Eastwood Bead Roller Fence installs easily and can be quickly adjusted to produce readily repeatable results.

INCLUDES

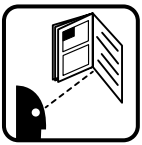
- (1) Bead Roller Fence

SPECIFICATIONS

- All steel construction
- Fence position is adjustable; from 0" up to 12" from Roll Forming Dies

SAFETY INFORMATION

In this manual, on the labeling, and all other information provided with this product:



⚠️ READ INSTRUCTIONS

- Read the entire manual before setup and use.
- Keep this manual in a safe location as it will be necessary to refer to it often.



⚠️ WARNING INJURY HAZARDS

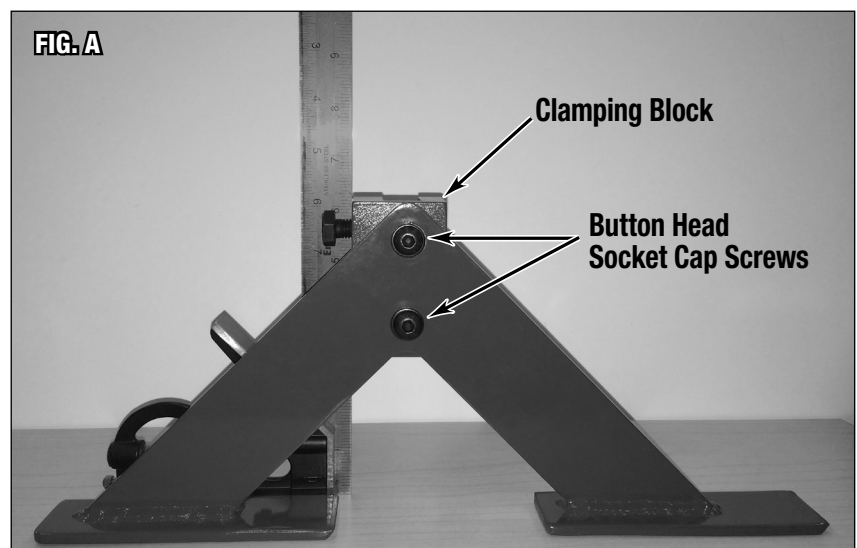
- The Bead Roller has rotating rollers and gears with amplified leverage which can quickly cause severe injury! Keep fingers and hands away from moving parts when operating.
- Wear work gloves and protective clothing. Sheet metal will often have sharp edges which can cause cuts to hands, arms and face.
- Frequently inspect moving parts and structure of the Bead Roller. If damage is observed, discontinue tool use immediately.
- Make sure the Bead Roller Frame is securely mounted in a minimum 4" (6" or larger, strongly recommended) vise properly fastened to a solid work surface before use. **IMPORTANT NOTE:** The Eastwood Bead Roller is moderately heavy, have a helper available when installing in the vise.
- Wear appropriate eye protection.



TOOL SET-UP

TO ENSURE YOUR BEAD ROLLER FENCE IS PERFECTLY ALIGNED AND SQUARE, FOLLOW THESE STEPS:

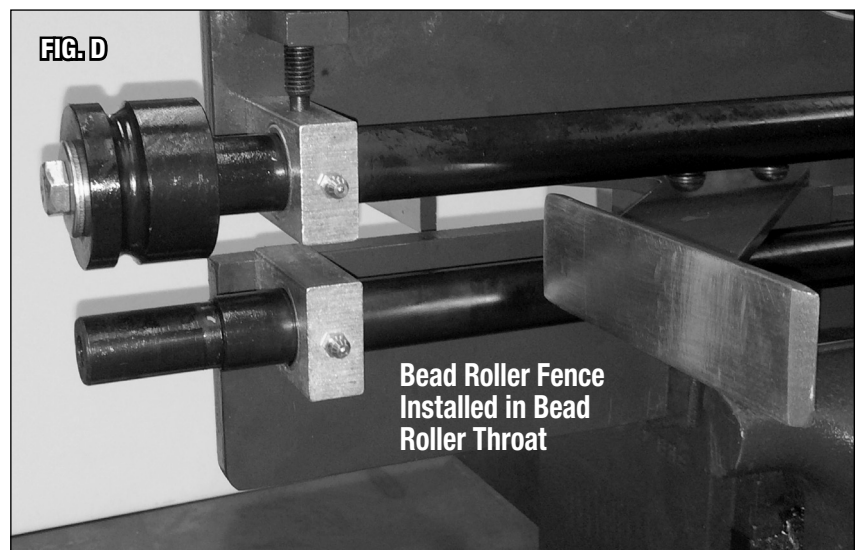
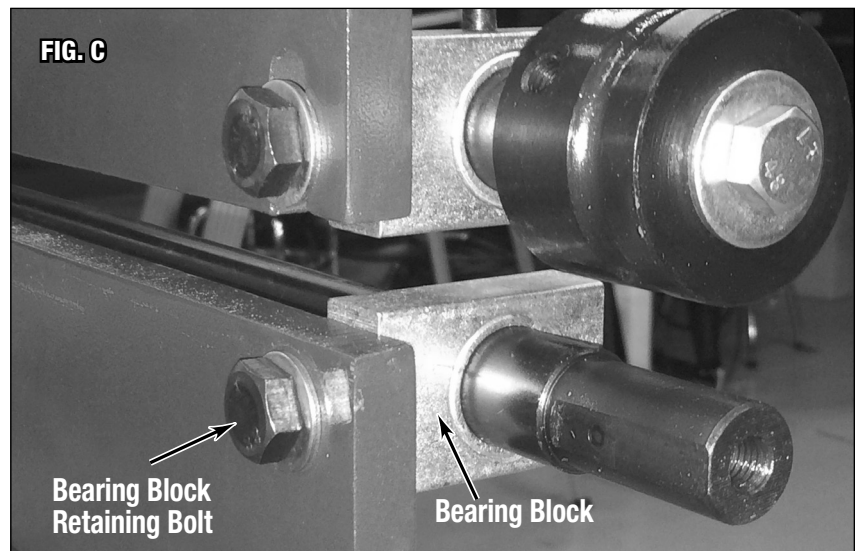
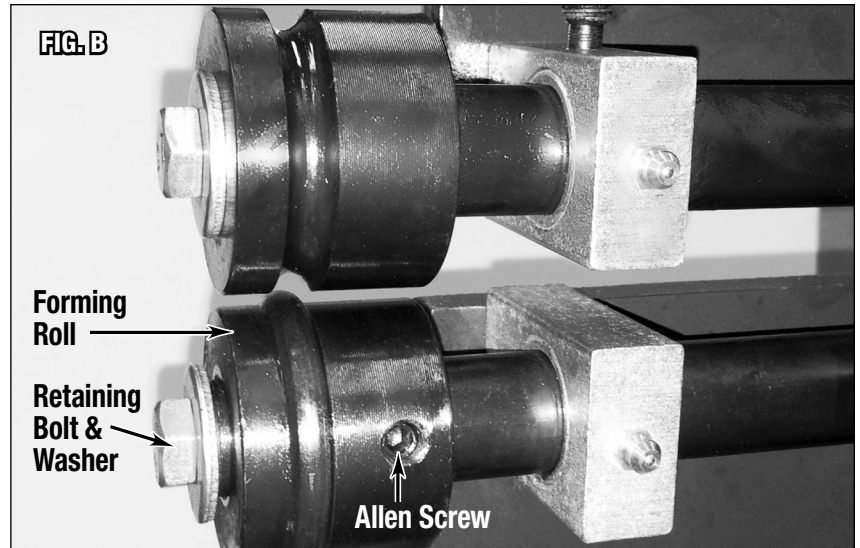
- Place the Bead Roller Fence on a flat surface as shown in **(FIG. A)**. Using a square as shown, check the alignment of the Clamping Block. If good, no adjustment is necessary. If not, proceed to the next step.
- Using a 5mm hex key, loosen the two Button Head Socket Cap Screws holding the Fence Assembly to the Clamping Block.
- Align a vertical edge of the Clamping Block with the square.
- Tighten the Button Head Socket Cap Screws.



TOOL INSTALLATION

INSTALLATION OF THE BEAD ROLLER FENCE REQUIRES MINOR DISASSEMBLY OF YOUR EASTWOOD BEAD ROLLER (#28187). THE INSTALLATION IS EASIEST WITH THE BEAD ROLLER SUPPORTED IN A VISE AS IT WOULD BE FOR NORMAL OPERATION:

- Hold the Roller Drive Handle to prevent it from turning and using a 17mm wrench remove the lower Forming Roll retaining Bolt and Washer (**Fig B**).
- Using a 4mm hex key, loosen any additional Allen Screws from the lower Forming Roll and slide the Roll off of the Shaft. It is acceptable to gently strike the back of the Roll with a wooden block if required.
- Using an 18mm wrench, loosen and remove the bolt that retains the Lower Shaft Bearing Block and slide the Bearing Block off the end of the Shaft (**Fig C**).
- Using a 16mm wrench, loosen the Locking Bolts on the Bead Roller Fence.
- Position the Bead Roller Fence at the throat opening of the Bead Roller with the open channel of the Clamping Block on the bottom (**Fig D**). Temporarily slide the Bead Roller Fence to the back of the Bead Roller throat. Properly installed, the Fence should be facing the Rolls with the Locking Bolts positioned so they tighten against the back surface of the Bead Roller Frame.
- Slide the Bearing Block over the lower Shaft, and install the retaining Bolt through the Bead Roller Frame. Tighten the retaining Bolt.
- Slide the Forming Roll onto the lower Shaft, align with the upper Roll and tighten the Allen Screw.
- Install the Roll retaining Bolt and Washer in the end of Shaft holding the Roller Drive Handle as the fastener is tightened.

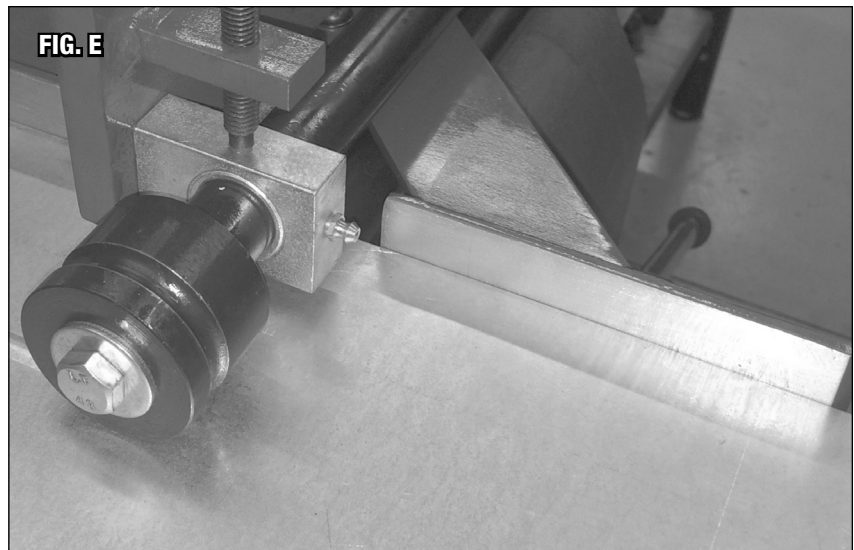


TOOL USAGE

SUGGESTIONS FOR USING YOUR BEAD ROLLER WITH THE EASTWOOD BEAD ROLLER FENCE (FIG E):

- Loosen the Bead Roller Fence Locking Bolts.
- Position the Fence in the desired location and lightly tighten the Locking Bolts.
- Run a test piece of similar gauge material through the Bead Roller to test both forming depth and position.
- Run sheet metal through maintaining light contact with the face of the Fence.

NOTE: Your Bead Roller Fence can remain on the Bead Roller when not in use unless maximum throat depth is required.



STORAGE

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

MAINTENANCE

Check tightness of all hardware

OPTIONAL METALWORKING ITEMS

- #51088 Shrinker/Stretcher Set
- #13475 Eastwood Electric Metal Shears
- #11797 Throatless Shear
- #14042 Versa Bend Sheet Metal Brake
- #20254 Eastwood 24" Slip Roll
- #20267 Eastwood Bead Roller Forming Dies

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

The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: techelp@eastwood.com
PDF version of this manual is available online >> eastwood.com/20552manual

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