

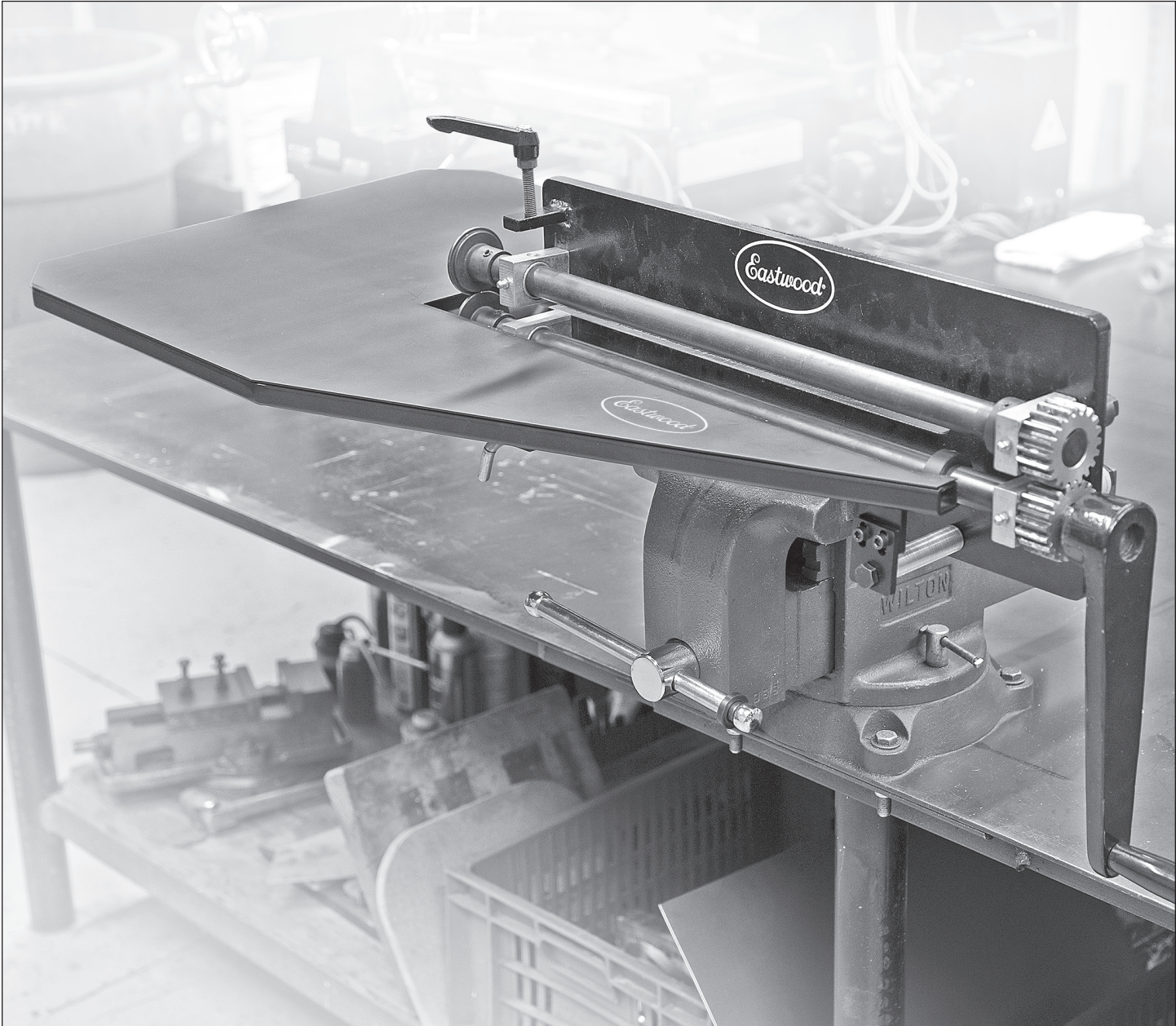


DO THE JOB RIGHT.®

Item #23021

BEAD ROLLER TABLE

INSTRUCTIONS



The **EASTWOOD BEAD ROLLER TABLE** is specifically designed to fit the Eastwood 32044 Bead Roller and other similar plate-type units. The generous 19" width provides a stable platform for handling larger panels. Quick and easy to install, adjust and remove.

CONTENTS

- (1) Bead Roller Table [A]
- (1) Drill & Mount Template [B]
- (1) Anchor Pin [C]
- (1) 3" Support Spacer Sleeve [D]
- (1) 1" Support Spacer Sleeve [E]
- (1) M10 x 150mm Support Bolt [F]
- (1) M10 Nut [G]
- (1) 10mm Flat Washer [H]



LEARN HOW TO SET UP AND USE YOUR BEAD ROLLER TABLE

with FREE How-To Videos Available at eastwood.com –
keyword search "23021"



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.



⚠ READ INSTRUCTIONS

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



⚠ WARNING PINCH AND CRUSH HAZARD!

- The Eastwood Bead Roller Table consists of metal components which can present a hand/finger pinch hazard. Avoid pinching hands while handling and 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 forming. 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 Bead Roller Table, it is absolutely necessary that the Bead Roller be installed in a vice (not included) and properly secured to a sturdy workbench anchored to the floor or wall.

SET UP

MOUNTING HOLE DRILLING

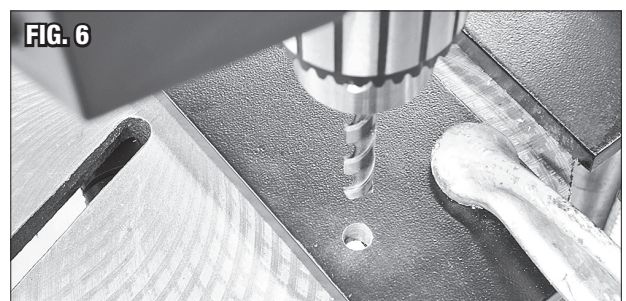
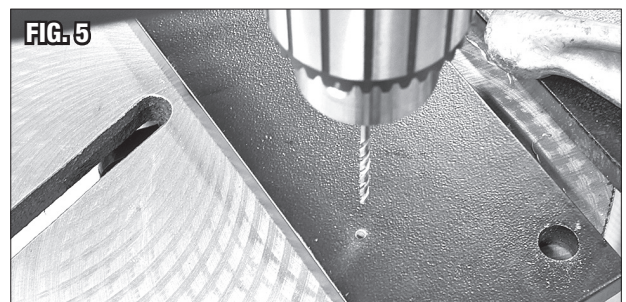
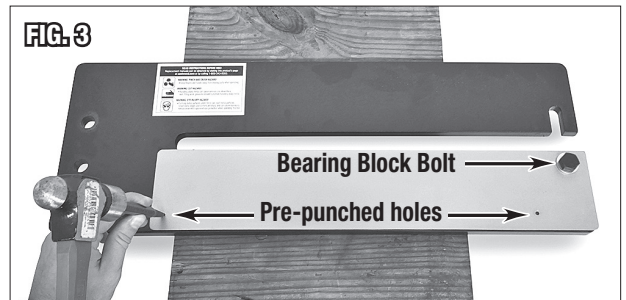
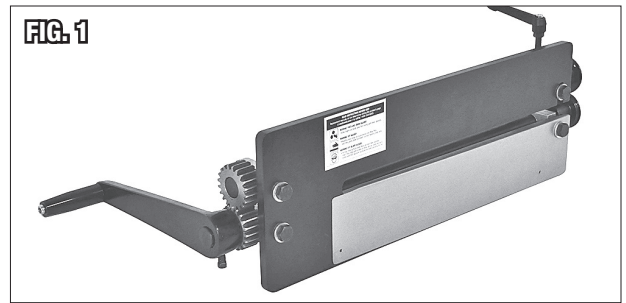
To mount the Bead Roller Table, the Bead Roller must have 2 holes drilled in the frame. For best results, the Bead Roller should be first fully disassembled to allow the frame drilling to be done on an adequately sized drill press.

- Using an 18mm wrench (not included) remove the Bearing Block retaining bolts and set the shafts, gears and bearings aside for re-installation.

▲ NOTICE

The Drill & Mount Template [B], MUST be located properly on the Bead Roller Frame before drilling (Refer to Figs 1 & 2 for clarity only). If the holes are drilled in the incorrect locations, the Bead Roller Table will not mount onto the Bead Roller.

- Place the Bead Roller frame on a solid surface with the back of the Bead Roller Frame facing up (FIG 3).
- Locate the included Drill & Mount Template [B] on the Bead Roller Frame with the pre-punched 12mm hole in the upper right corner over the existing tapped Bearing Block hole of the Bead Roller Frame (FIG 3).
- Using one of the removed Bearing Block Bolts, pass it through the 12mm hole in the upper right of the Template and thread it into the Bead Roller Frame. Make sure the flange on the Template is firmly seated against the lower edge of the slot of the Bead Roller Frame. Secure the Template in place by tightening the Bearing Block Bolt. (FIG 3).
- Using a sharp Centerpunch (Not Included), center the point in one of the pre-punched 1/8" holes in the lower side of the Drill & Mount Template [B] and strike it firmly with a hammer (FIG 3).
- Repeat for the 2nd 1/8" hole (FIG 4).
- Unbolt and remove the Drill & Mount Template [B] and set it aside for later Table height adjustment use.
- Place the Bead Roller Frame on a drill press table. Align the Centerpunched mark with a 1/8" drill bit (not included) and drill a pilot hole through the Bead Roller Frame (FIG 5).
- Repeat for the 2nd pilot hole.
- Keeping the Bead Roller Frame on the drill press, mount a 13/32" drill bit and using the pilot hole, drill through the Bead Roller Frame (FIG 6).
- Repeat for the 2nd hole.



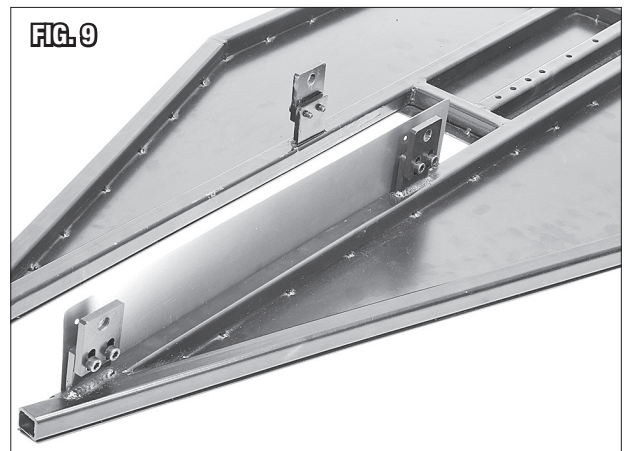
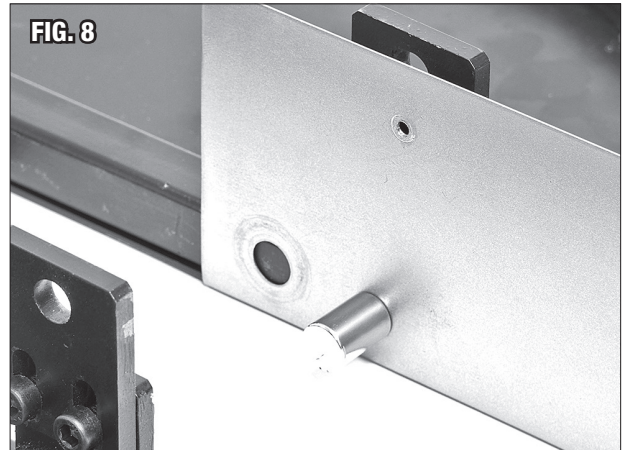
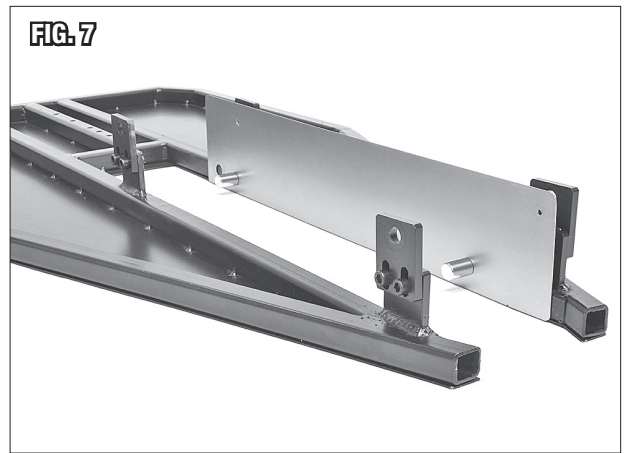
MOUNTING TAB PRE-ADJUSTMENT

The Mounting Tabs are pre-assembled to the Bead Roller Table and must be adjusted prior to assembly to a Bead Roller. The Drill & Mount Template [B] is also used as a height setting guide.

- Place the Bead Roller Table assembly UPSIDE DOWN on a solid surface (FIG 7).
- Set the Drill & Mount Template [B] in the center cutout of the Bead Roller Table (FIG 7) with the flange over the upper surface of the Bead Roller Table.
NOTE: The use of magnets (shown, but not included) or clamps can be helpful to hold the Template in position while adjusting the Table mounting tab height.
- Compare the height of the edge of the Mounting Tabs with the visible upper edge of the Drill & Mount Template [B] and adjust height of Mounting Tab if required (FIG 8).
- If a Mounting Tab height adjusted is needed, loosen (do not remove) the Tab Assembly Screws and move edge of Tab up or down as required to align with the edge of the Template (FIG 9).
- The Bead Roller Table may now be mounted to the Bead Roller.

▲ NOTICE

This adjustment will provide a satisfactory Table level adjustment for most Bead Rollers. For some, a final adjustment may be required once the entire unit is assembled and mounted in a vise.



ASSEMBLY TO BEAD ROLLER

▲ NOTICE

The Bead Roller and Table are heavy. DO NOT lift without the assistance of a capable helper.

▲ CAUTION INJURY HAZARD!

DO NOT attempt to lift the Bead Roller Table into place on the Bead Roller while assembling. Obtain the assistance of a capable helper before beginning assembly.

- First, fully re-assemble the Bead Roller by replacing the shafts with gears and bearing blocks to the Frame (FIG 10).
- Mount the re-assembled Bead Roller securely in a vise as described in the Bead Roller Instructions.
- Align the Outer Table Mounting Tab holes (at tapered end of Table) with the solid (crank) side of the Bead Roller (FIGS 11 & 12).
- Hold the 3" Support Spacer Sleeve [D] and the 1" Support Space Sleeve [E] in position between the Bead Roller Mounting Tabs and the Bead Roller Frame and pass the M10 x 150mm Support Bolt [F] through:
 - Front Mounting Tab.
 - 3" Sleeve [D].
 - The 13/32" drilled hole in the Bead Roller Frame.
 - 1" Sleeve [E].
 - Rear Mounting Tab.
- Secure with the M10 Nut [G] and 10mm Flat Washer [H].
- Next, with the Support Bolt [F] supporting the Bead Roller Table, lift the wide end up into place and align the Bead Roller Mounting Tab holes with the 13/32" drilled hole of the Bead Roller Frame (FIG 13).
- Pin in place with the Anchor Pin [C] by passing it through one Mounting Tab, the 2nd 13/32" drilled hole in the Bead Roller Frame and the opposite Bead Roller Tab (FIG 13).

FIG. 10



FIG. 11

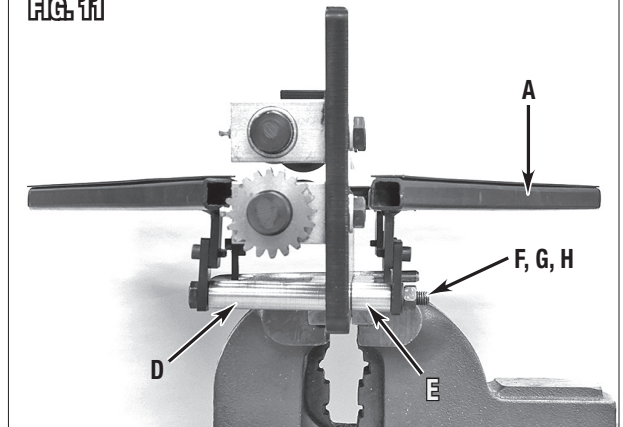


FIG. 12

NOTE: Shown out of vise for clarity

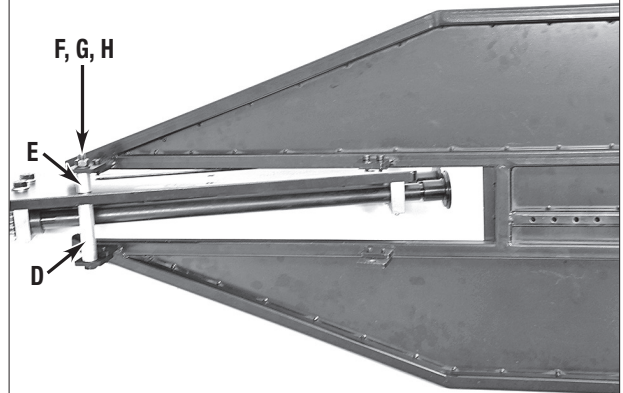


FIG. 13

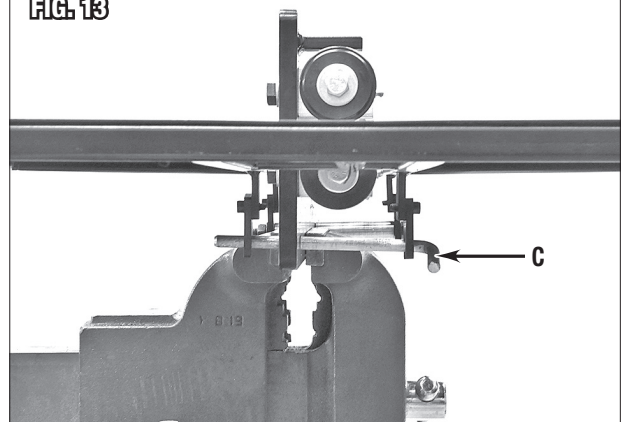


TABLE HEIGHT FINE ADJUSTMENT

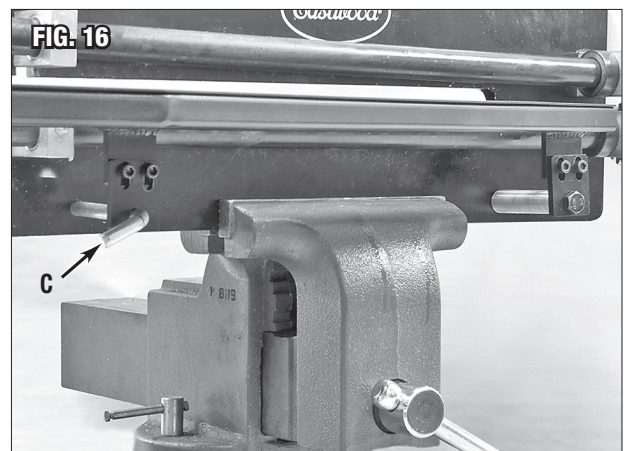
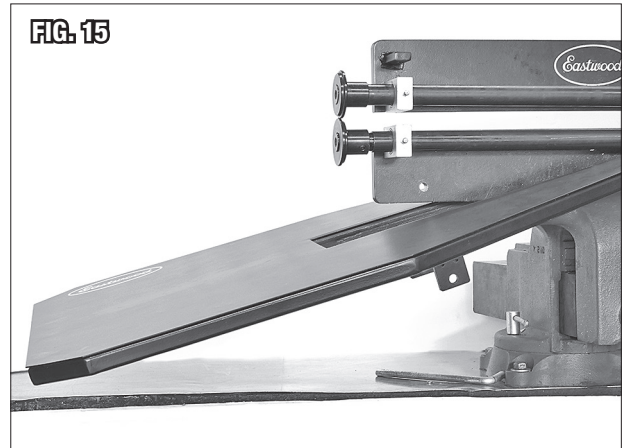
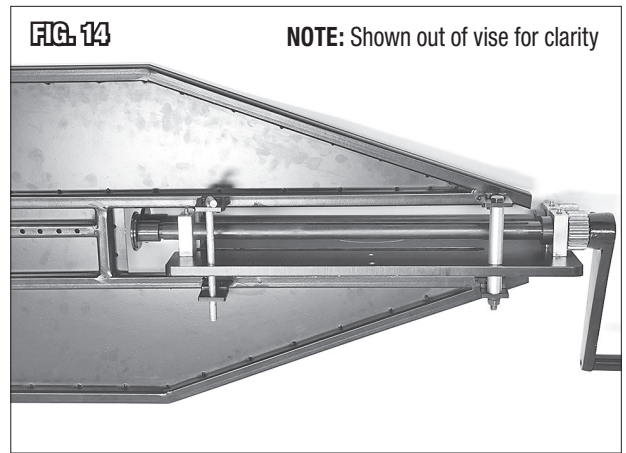
When mounted on a Bead Roller and properly adjusted, the lowest point of any lower die must be equal to or above the surface of the Bead Roller Table. If it is below, the leading edge of a metal workpiece may hit the far edge of the Bead Roller Table in use. If this occurs, slightly loosen the Mounting Tab adjustment screws and lower the Bead Roller Table surface slightly. Be sure to securely re-tighten all Mounting Tab adjustment screws.

OPERATION

Use the Bead Roller normally while allowing the metal panel to slide over and be supported by the Bead Roller Table.

DIE REPLACEMENT

- To gain access to the Dies for removal and installation, the large, working end of the Bead Roller Table may be carefully rotated downward by pulling out the Anchor Pin [C] supporting it and allowing it to rotate down, exposing the Bead Roller Die mounting bolts (FIG 15).
- Remove Die retaining screws, pull Dies from shafts, install replacement Dies.
- Swing the Bead Roller Table back up into place and re-install the Anchor Pin [C] (FIG 16).



ADDITIONAL ITEMS

- #20622B Bead Roller Stand
- #51088 Shrinker/Stretch 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: tech@eastwood.com

PDF version of this manual is available at eastwood.com

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA 800.343.9353 eastwood.com

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