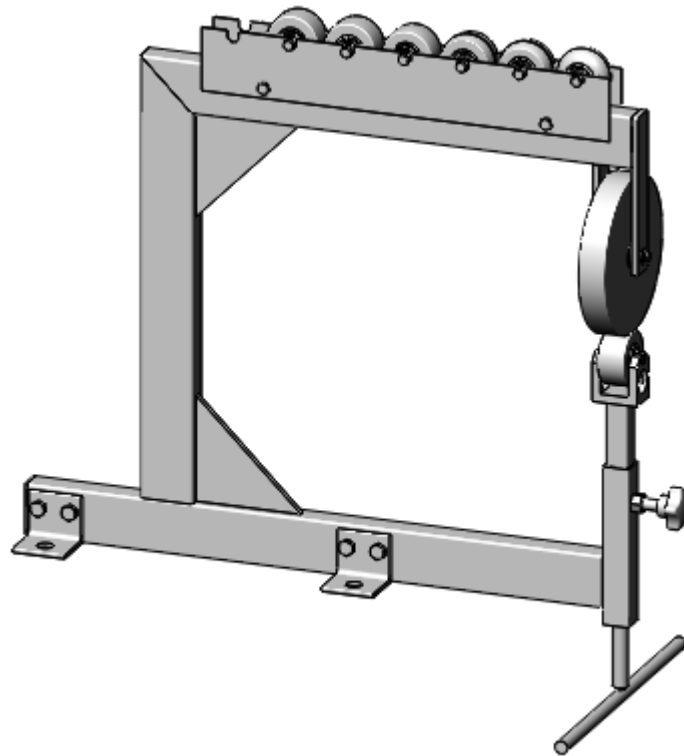


SMALL ENGLISH WHEEL

ITEM MW21

ASSEMBLY & OPERATING INSTRUCTIONS



Diagrams within this manual may not be drawn proportionally
Due to continuing improvements actual product may differ slightly from the product described herein



**Read this material before using this product.
Failure to do so can result in serious injury.
SAVE THIS MANUAL.**

SPECIFICATIONS

Top Die Diameter (mm//in)	147//5-3/4
7 Pcs Bottom Dies Shaping Radius (mm//in)	12.7//1/2,25.4//1,38.1//1-1/2, 63.5//2-1/2,127//5,228.6//9,Flat
Throat (mm//in)	400//15-3/4

SAVE THIS MANUAL

You will need the manual for the safety warnings and precautions, assembly instructions, operating and maintenance procedures, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep the manual and invoice in a safe and dry place for future reference.

SAFETY WARNINGS AND PRECAUTIONS

WARNING: When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage.

Read all instructions before using this tool!

- 1. Keep work area clean.** Cluttered areas invite injuries.
- 2. Observe work area conditions.** Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep work area well lighted. Do not use electrically powered tools in the presence of flammable gases or liquids.
- 3. Keep children away.** Children must never be allowed in the work area. Do not let them handle machines, tools, or extension cords.
- 4. Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
- 5. Do not force tool.** It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool capacity.
- 6. Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. Do not modify this tool and do not use this tool for a purpose for which it was not intended.
- 7. Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
- 8. Use eye and ear protection.** Always wear ANSI approved impact safety goggles. Wear a full face shield if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, wood, and chemical dusts and mists.
- 9. Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines. Keep hands and fingers clear of the Roll Dies when operating.

- 10. Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and, if damaged, have them repaired by an authorized technician. The handle must be kept clean, dry, and free from oil and grease at all times.
- 11. Remove adjusting keys and wrenches.** Check that keys and adjusting wrenches are removed from the tool or machine work surface before plugging it in.
- 12. Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
- 13. Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the tool if any switch does not turn on and off properly.
- 14. Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool.
- 15. Do not operate tool if under the influence of alcohol or drugs.** Read warning labels if taking prescription medicine to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.
- 16. Maintenance.** For your safety, service and maintenance should be performed regularly by a qualified technician.
- 17. Workpiece may be sharp.** After bending or cutting workpieces use caution. Be aware of sharp edges or sharp shreds of metal that may be created. Use heavy duty gloves when handling the workpiece.

WARNING: The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

FEATURES

- 1. Make smooth radian surface in sheet metal without heating and hammering.**
- 2. Easy for adjusting & assembly.**
- 3. Bottom Anvil Dies for different radian.**
- 4. All steel construction.**

UNPACKIG

When unpacking, check to make sure that the item is intact and undamaged. If any parts are missing or broken, please contact the seller.

ASSEMBLY

1. Place the Top Die (2#) into the bracket at the top of the unit. Fix in place with the Top Die Shaft (3#) and secure with the C-Ring (4#).
2. Put the Anvil Bracket (5#) into the holder at the end of the Frame (1#).
3. Screw the Adjusting Screw (14#) into the unit.
4. Screw the Knob (9#) into the threaded hole on Frame (1#). Lift Anvil Bracket (5#) to let the Knob (9#) seat into the slot of Anvil Bracket (5#). Tighten Knob (9#).
5. Place the two pieces of the Die Rack (13#) onto the unit and secure with Nut M6 (11#) , Washer 6mm (8#) and Bolt M6x40 (15#).
6. Secure the English Wheel at its mid-point with a vise. Only mount the English Wheel on a work surface that is capable of supporting both the weight of the Wheel and the work piece.
7. Slide the Anvil Shafts (6#) through the hole in the Anvils (12-01#,12-02#,12-03#,12-04#,12-05#,12-06#,12-07#) and place them in the Die Rack (13#).
8. Connect Angle Steel (16#) with Frame (1#) with Bolt M8x45 (17#), Washer 8mm (18#) and Nut M8 (19#).

OPERATION

1. Always wear work gloves when performing operations with the English Wheel.
2. Select the proper Anvil (12-01#,12-02#,12-03#,12-04#,12-05#,12-06#,12-07#) for the job and place it on the Anvil Bracket (5#).
3. Insert the work piece between the Top Die (2#) and the chosen Anvil (12-01#, 12-02#, 12-03#, 12-04#,12-05#,12-06#,12-07#).
4. Turn the Adjusting Screw (14#) until the Top Die (2#) and the Anvil(12-01#, 12-02#, 12-03#,12-04#,12-05#,12-06#,12-07#) engage the metal. It is recommended to have a loose pinch , rather than a tight one. A tight pinch will make it harder to move the metal and may cause creasing. A loose pinch makes it easy to move the metal, and allows greater accuracy. Although, it may take more passes to form the metal.
5. Form the metal by pushing and pulling it between the dies.
6. When finished, loosen the Adjusting Screw (14#) and remove the work piece from the English Wheel.
7. Clean, then store the product indoors out of children's reach.

MAINTENANCE

1. Keep the machine clean.
2. Lubricate the moving parts with grease.
3. Coat the outside surface with antirust oil.

PLEASE READ THE FOLLOWING CAREFULLY

THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS DIAGRAM IN THIS MANUAL AS A REFERENCE TOOL ONLY. NEITHER THE MANUFACTURER NOR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT. IN FACT, THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

PARTS LIST

Part No.	Description	Qty
1	Frame	1
2	Top Die	1
3	Top Die Shaft	1
4	C-Ring	16
5	Anvil Bracket	1
6	Anvil Shaft	7
7	Bearing	16
8	Washer 6mm	4
9	Knob	1
10	Screw M5x12	2
11	Nut M6	2
12-01	Flat Anvil	1
12-02	1/2" Radius Anvil	1
12-03	1" Radius Anvil	1

Part No.	Description	Qty
12-04	1-1/2" Radius Anvil	1
12-05	2-1/2" Radius Anvil	1
12-06	5" Radius Anvil	1
12-07	9" Radius Anvil	1
13	Die Rack	2
14	Adjusting Screw	1
15	Bolt M6x40	2
16	Angle Steel	4
17	Bolt M8x45	4
18	Washer 8mm	4
19	Nut M8	4
20	Bolt M14x40	4
21	Washer 14mm	4
22	Nut M14	4

PARTS DIAGRAM

