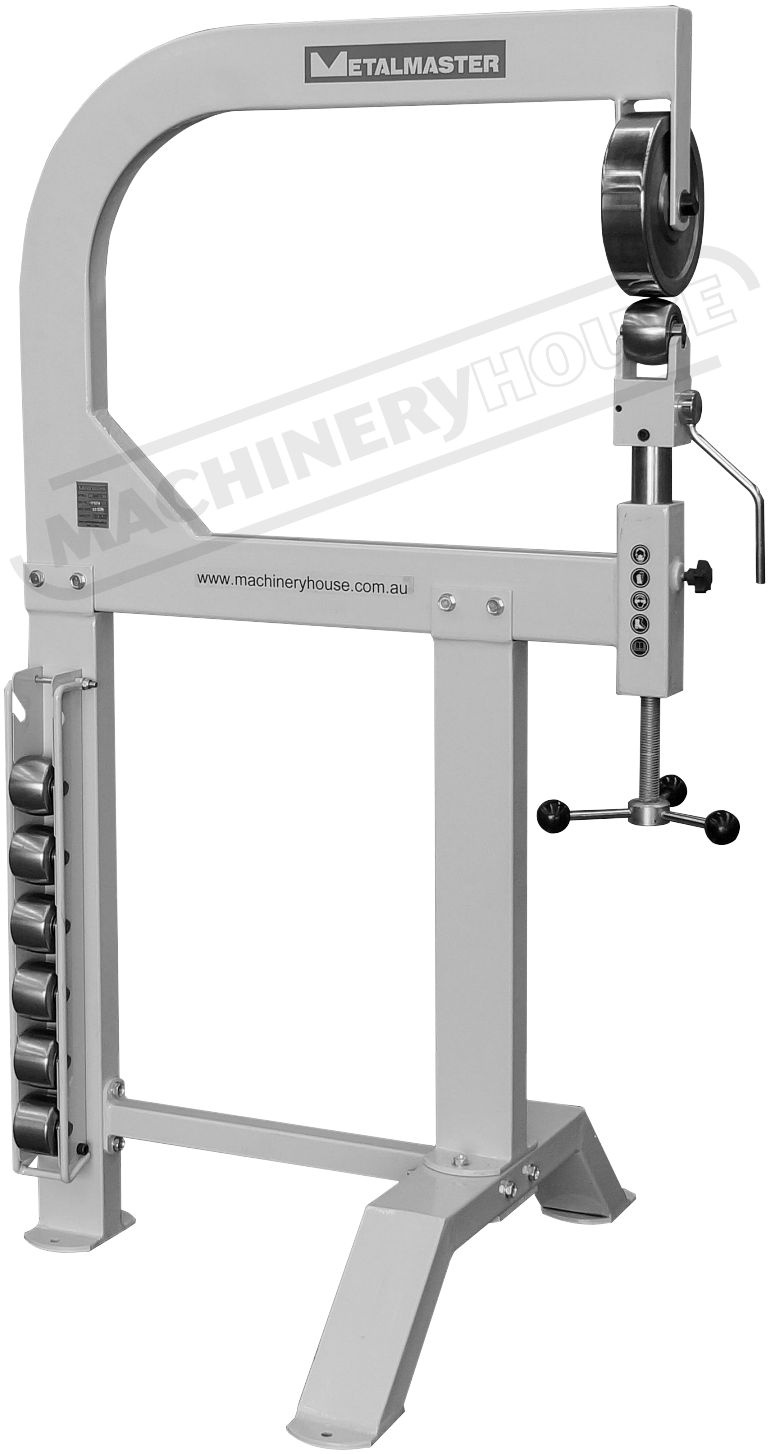
INSTRUCTION MANUAL

EWM-75
English Wheel
1.6mm Mild Steel



S225

SPECIFICATIONS

Top Die Diameter (mm//in)	203.2//8
7 Pcs Bottom Dies Shaping Radius (mm//in)	50.8//2,76.2//3,101.6//4, 152.4//6,203.2//8,304.8//12,Flat
Throat (mm//in)	710//28
Capacity(mm//ga)	1.5//16 Mild Steel,2//14 Aluminum

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.



UNPACKING

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

Note: For additional information regarding the parts listed in the following pages, refer to the Parts Diagram.

1. Unpack the English Wheel components on the floor where the unit will be located and mounted. The floor must be able to support the weight of the English Wheel and the workpieces.

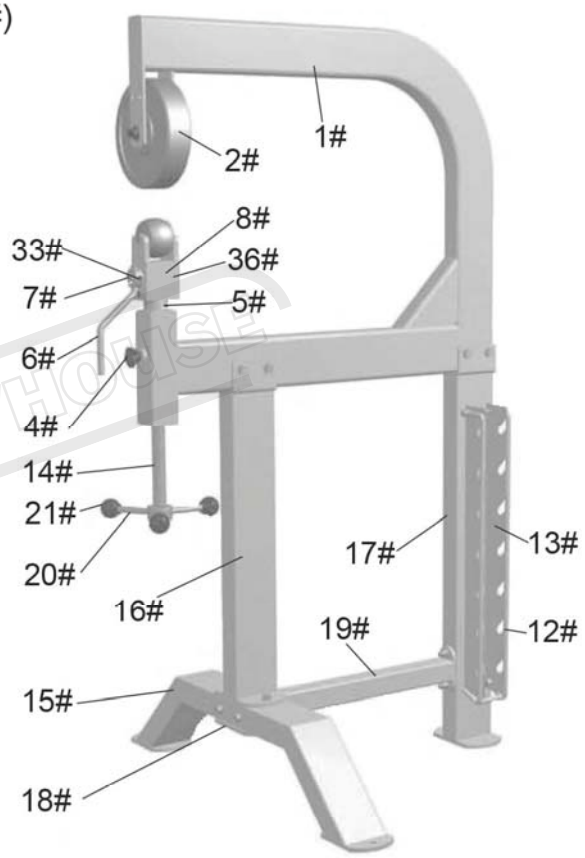
2. With the Frame(1#) and Back Stand (17#) assembled and lying on the floor. attach the Link Bracket (19#) to the Back Stand (17#) using two Bolts (35#), four Washers (24#), and two Nuts (26#). Tighten Nuts and Bolts securely.

3. With the help of at least two other people, lift the assembled Frame so that it is upright and balanced on the Back Stand (17#). The Frame (1#) must be supported until the total Frame Assembly is complete, and all Nuts and Bolts securely tightened.

4. Slide the Front Stand (15#) under the Front Tube (16#) so that the mounting holes align.

5. Insert two Bolts (25#), with two Washers (24#), into the holes of the Front Tube (16#) and Front Stand (15#).

6. From the bottom of the Front Stand (15#), insert Plate (18#) over the Bolts, and secure with two Washers (24#) and two Nuts (26#). Hand tighten .



7. Attach the unsecured end of the Link Bracket (19#) to the Front Stand (15#) using two Bolts (35#), four Washers (24#), and two Nuts (26#).

8. Securely tighten all assembled frame components.

9. Insert Steel Tube (5#) into the Bottom Die Yoke (8#). Secure with two Screws (32#). Place Assembly into the mounting hole in Frame (1#).

10. Screw Knob (4#) into the threaded hole on Frame (1#). Lift and turn Steel Tube (5#) so that the Knob (4#) seats into the slot of Steel Tube (5#). Tighten Knob (4#).

11. Insert Eccentric Shaft (7#), with Handle (6#), into the hole of Bottom Dies Yoke (8#).
12. Thread each Handle Lever (20#) into the Thread Rod (14#). Securely tighten. Thread on Handle Balls (21#).
13. Screw Thread Rod (14#) into the bottom of Frame (1#). The Thread Rod (14#) will set into Steel Tube (5#) already installed in Frame (1#).
14. Place the Top Die (2#) with Bearings (9#) on each side into the top of the Frame (1#). Secure in place with Shaft (3#), Washers (22# & 37#),and Nut (31#). Securely tighten.
15. Mount Bottom Die Rack (13#) to Back Stand (17#) using two Bolts (28#), Washers (29#), and Nuts (30#). Securely tighten.
16. Mount the Lock Bracket (12#) onto the Bottom Die Rack (13#) using Bolt (34#), Washer (29#), and Nut (30#). Securely tighten.
17. Install Shafts (10#) in each Bottom Die (11#-01 thru 11#-06) with Bearings (9#).
18. Open the Lock Bracket (12#) and place each Bottom Die (11#-01 thru 11#-06) on the Bottom Die Rack (13#). Each Bottom Die has its size stamped on it. Place in order of size on the Bottom Die Rack (13#).
19. With the help of two other people, move the assembled English Wheel to the location where it will be mounted to the floor. Measure the size of the mounting holes in the Front Stand (15#) and Back Stand (17#), then drill appropriate size holes in the floor to accommodate the mounting hardware(not supplied).

OPERATION

Warning: Metal edges can be very sharp. Avoid injuries by wearing ANSI approved safety equipment.

1. Select the Bottom Die from the Bottom Die Rack (13#), and place on the Bottom Die Yoke(8#). When selecting the Bottom Die, consider the type and hardness of the metal being formed as well as the desired curvature of the metal.
2. Insert the workpiece in between the Top Die (2#) and the Bottom Die.
3. Turn the Thread Rod (14#) to raise or lower the Bottom Die Yoke (8#) for appropriate clearance (or pinching) of the metal between the two dies. It is better to have a loose pinch than a tight one. A tight pinch will make it harder to push the metal through and may cause unwanted creasing. A loose pinch makes it easier to push the metal through, and with more accuracy. It may take more passes to form the metal, however.
4. Turn Knob (4#) clockwise until tight.
5. Begin forming the metal by pushing and pulling it over the dies.
6. If small distance adjustments are required between the dies, loosen Knob (4#) and turn Handle (6#). This causes the Eccentric Shaft (7#) to slightly raise or lower the Bottom Die. Tighten Knob (4#) again before proceeding.

MAINTENANCE

BEFORE EACH USE,inspect the general condition of the tool. Check for loose screws,misalignment or binding of moving parts,cracked or broken parts, and any other condition that may affect its safe operation. If abnormal noise or vibration occurs, have the problem corrected before further use.**Do not use damaged equipment.**

MAINTENANCE CHART						
Maintenance Type	Before Use	After Use	Weekly	Monthly	Every 6 Months	Yearly
Inspect tool for damage	X					
Wipe off with clean cloth		X	X	X	X	X
Oil moving parts with a light oil				X		

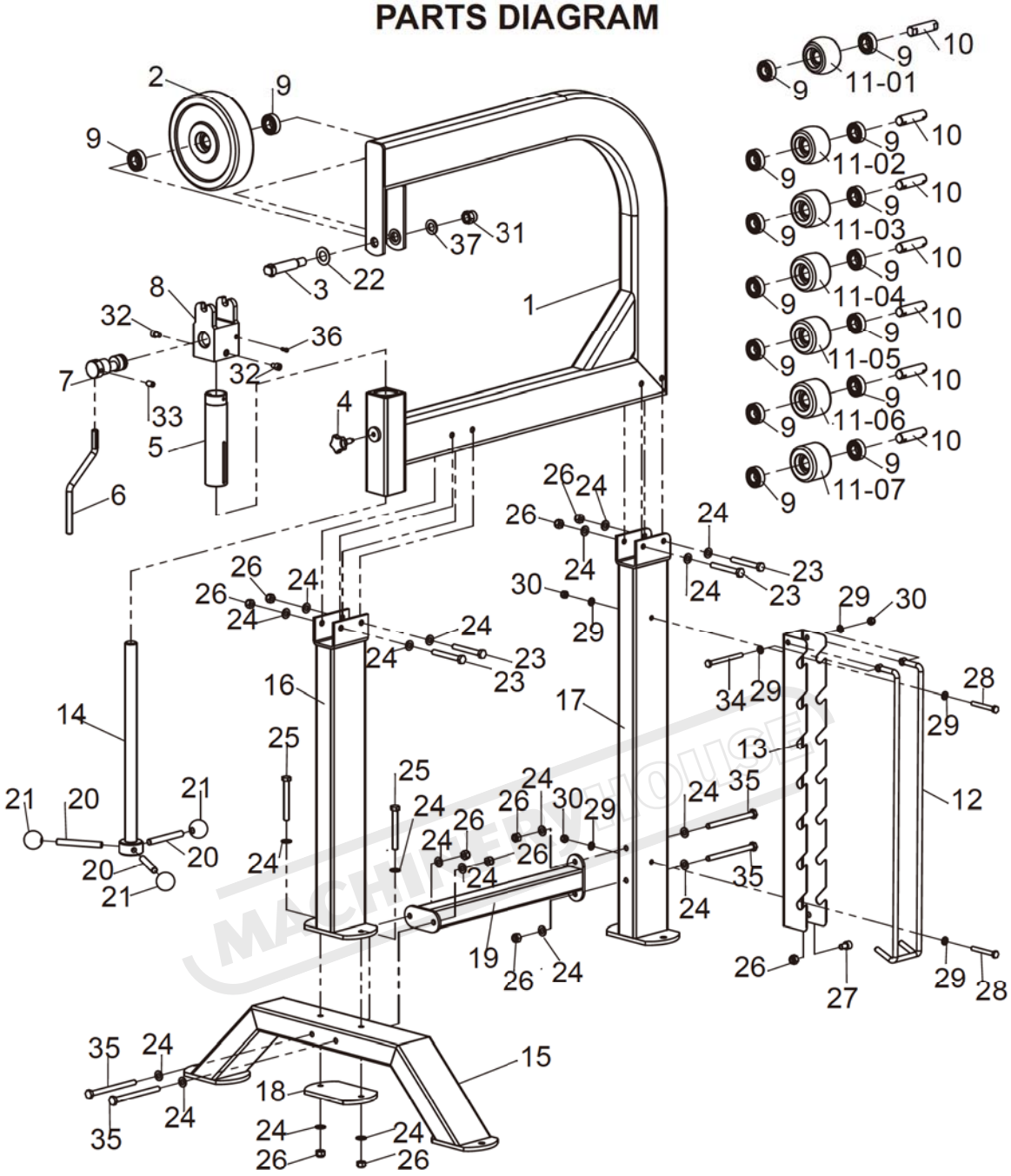
PARTS LIST

Part No.	Description	Qty
1	Frame	1
2	Top Die	1
3	Shaft	1
4	Knob	1
5	Steel Tube	1
6	Handle	1
7	Eccentric Shaft	1
8	Bottom Die Yoke	1
9	Bearing	16
10	Shaft	7
11-01	Bottom Die 50.8mm/2″ *	1
11-02	Bottom Die 76.2mm/3″ *	1
11-03	Bottom Die 101.6mm/4″ *	1
11-04	Bottom Die 152.4mm/6″ *	1
11-05	Bottom Die 203.2mm/8″ *	1
11-06	Bottom Die 304.8mm/12″ *	1
11-07	Flat Die	1
12	Lock Bracket	1
13	Bottom Die Rack	1
14	Thread Rod	1
15	Front Stand	1
16	Front Tube	1

Part No.	Description	Qty
17	Back Stand	1
18	Plate	1
19	Link Bracket	1
20	Handle Lever	3
21	Handle Ball	3
22	Washer 20mm	1
23	Bolt M10X80	4
24	Washer 10mm	20
25	Bolt M10X85	2
26	Nut M10	11
27	Screw M10X15	1
28	Bolt M8X65	2
29	Washer 8mm	6
30	Nut M8	3
31	Nut M16	1
32	Screw M8X12	2
33	Screw M10X16	1
34	Bolt M8X95	1
35	Bolt M10X130	4
36	Screw M4X12	1
37	Washer 16mm	1
*Size of each Bottom Die stamped on end.		

MACHINERY HOUSE

PARTS DIAGRAM



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.