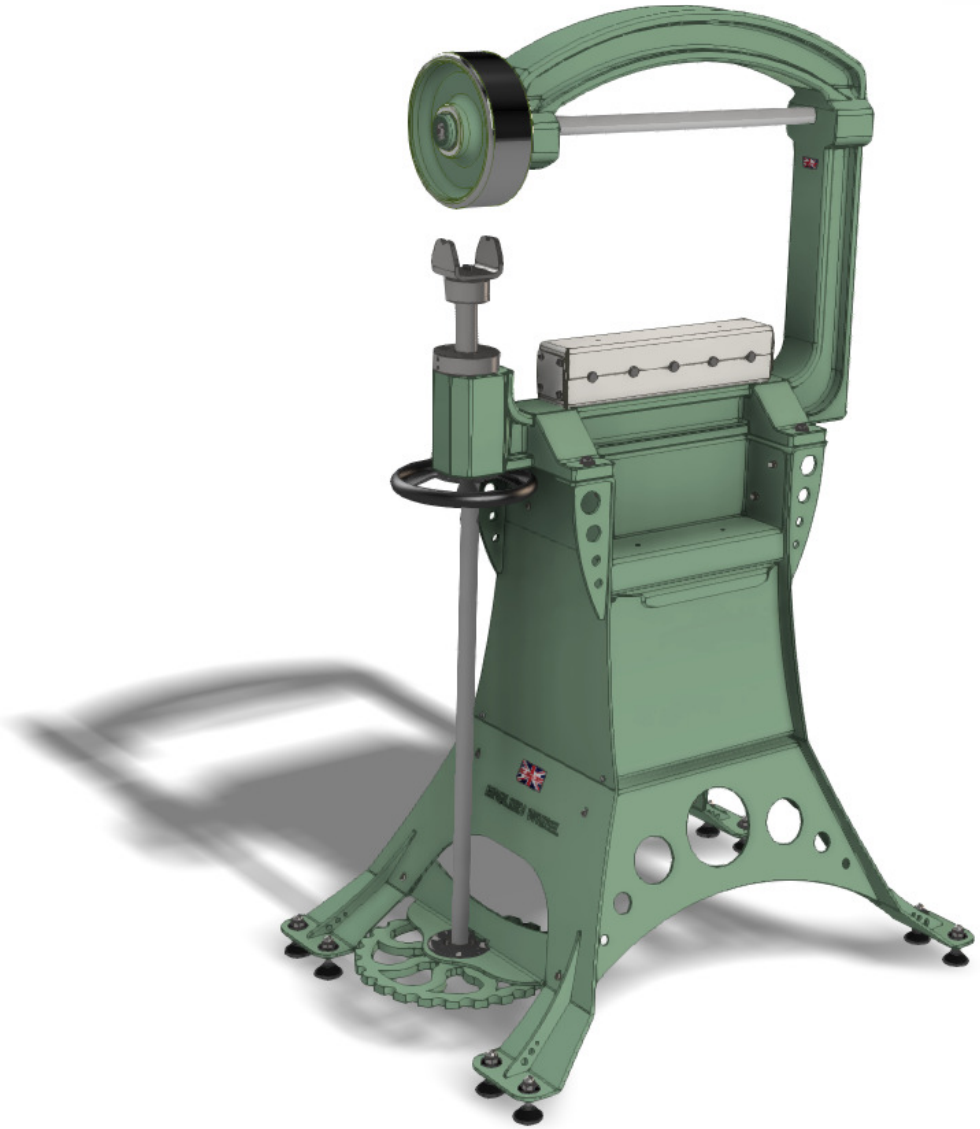

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ENGLISH WHEELING MACHINE

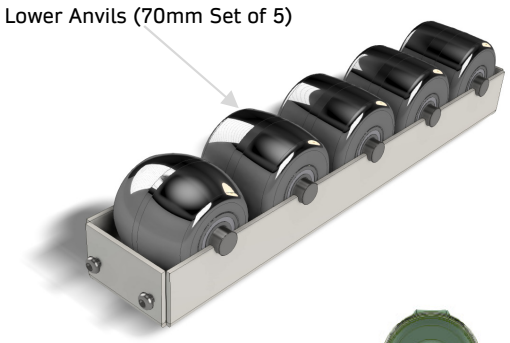
2020 - MACHINE

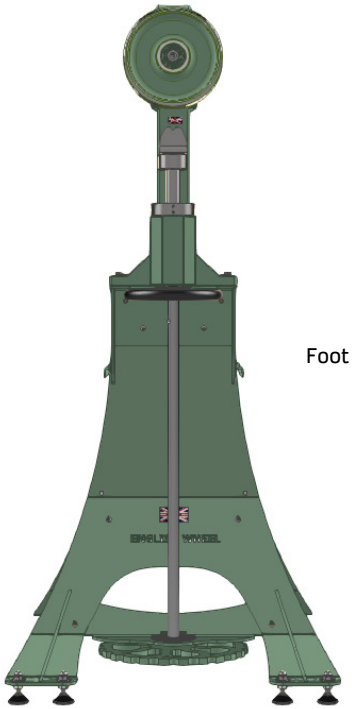
Contents

ALL ILLUSTRATIONS SHOWN THROUGHOUT THIS DOCUMENT ARE FOR ILLUSTRATIVE PURPOSES ONLY AND MAY DIFFER FROM ACTUAL MACHINE

1. Unit Overview

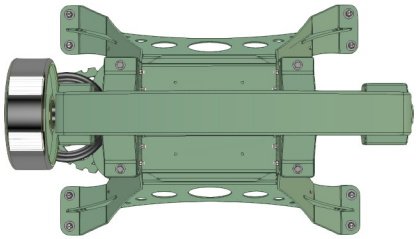
The English Wheel, or wheeling machine, is a metal working product for sheet metal, its unpowered, and solely operated by hand, it is designed to form compound curves in sheet metal type materials. It is operated via the hand wheel, and or by the foot wheel. The sheet material to be worked is drawn back and forth through various radial anvils of different profiles to create the desired shape.

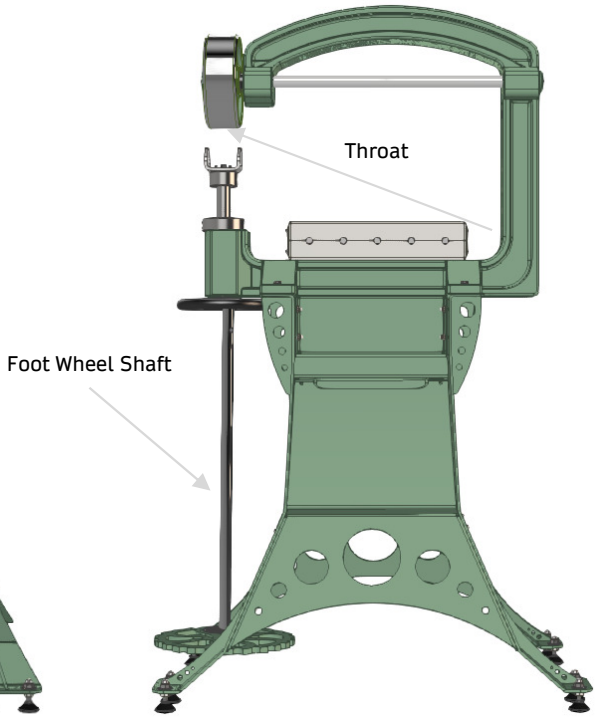




(Fig 1.)
Front View

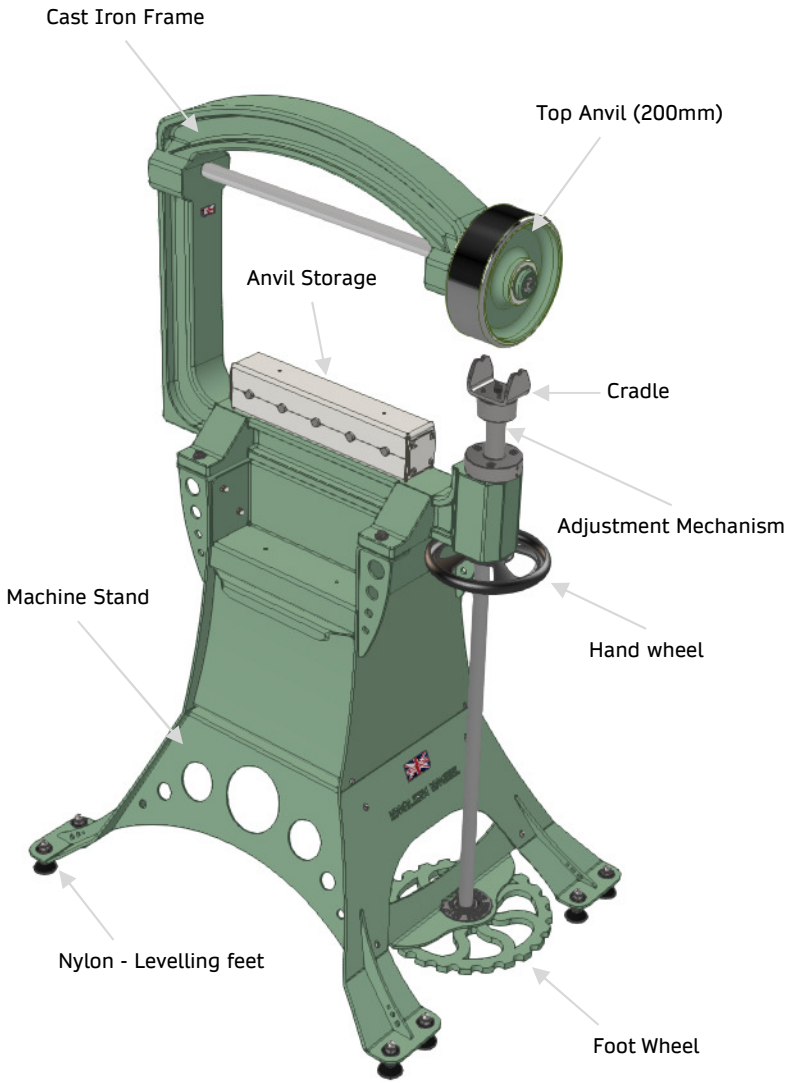
(Fig 2.)
Top View





(Fig 3.)
Side View

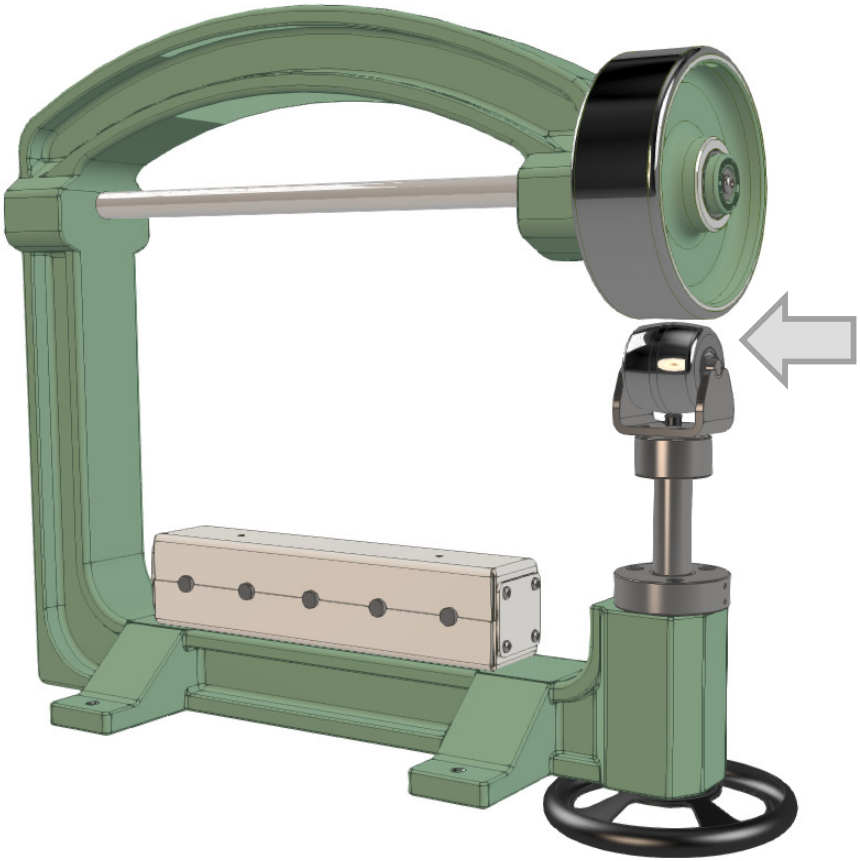
(Fig 4.)
Isometric View

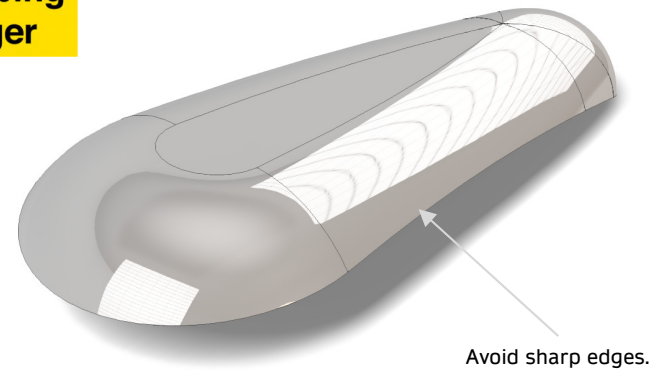


2. Health and Safety

2.1 General

- **Only skilled or trained people should use a wheeling machine.**
- **Heavy machine, ensure surfaces (if bench top), floor structures are adequate for its location. (128Kg)**
- Any damaged or broken parts should be removed and replaced accordingly
- **DO NOT** climb, stand, sit or lean on the machine.
- Ensure the unit is sited level, with all levelling feet in contact with floor surface at all times
- Machine should only be installed, moved, modified and removed by qualified & competent installation persons
- Unit should not protrude into or block emergency walkways, signage or exits
- Ensure workpieces are free from burrs and sharp edges if possible **– Wear protective gloves at all times.**



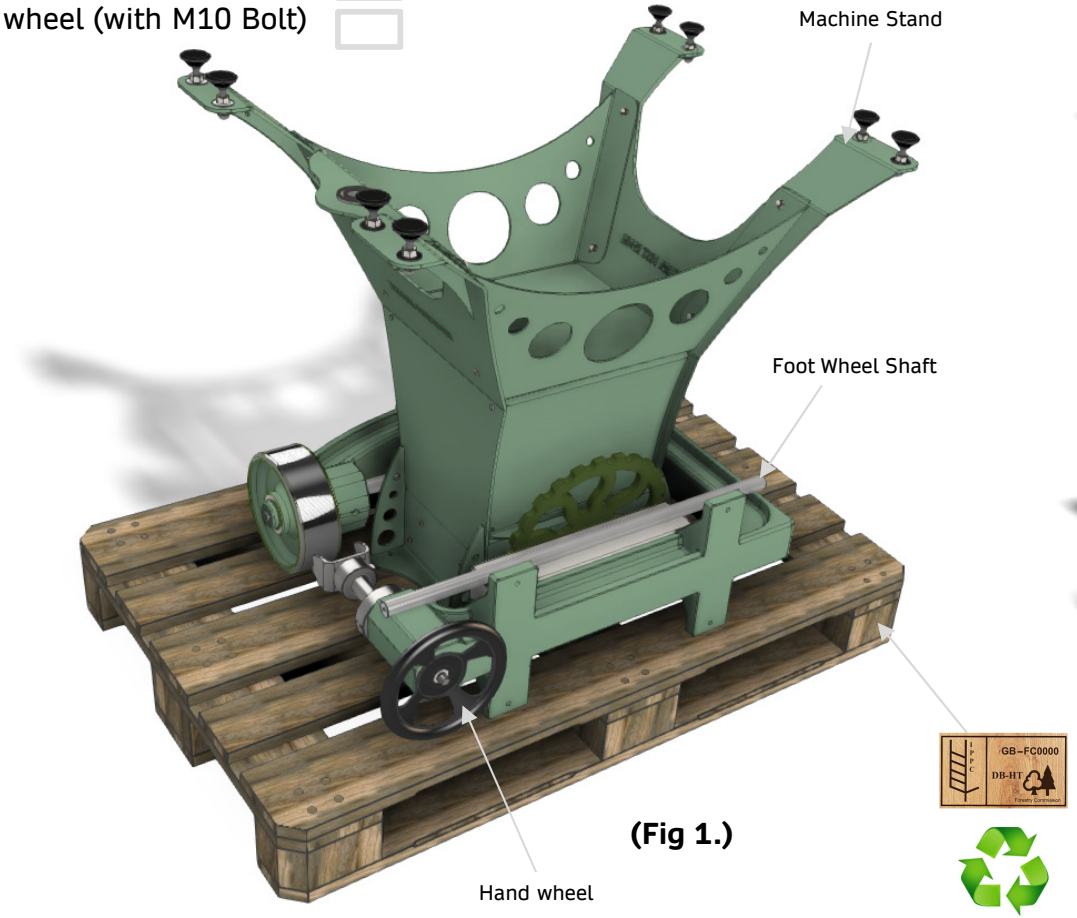


3. Setup

3.1 Unpacking

The machine will arrive on a Euro Style pallet with the correct markings for export & import, remove the other shrink wrapping and strapping, and locate the 4 main components.

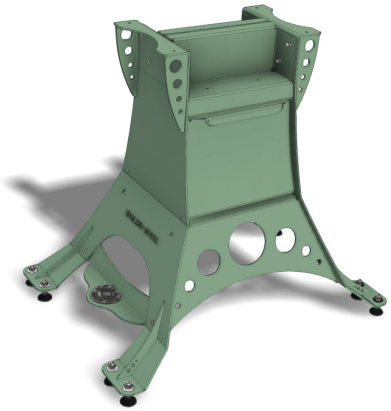
1. Machine Assembly ☐
2. Stand Assembly ☐
3. Foot wheel shaft ☐
4. Foot wheel (with M10 Bolt) ☐



(Fig 1.)

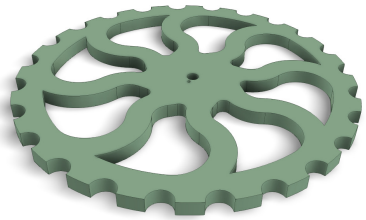
(1. Machine Assembly)

(3. Foot wheel Shaft)



(2. Stand Assembly)

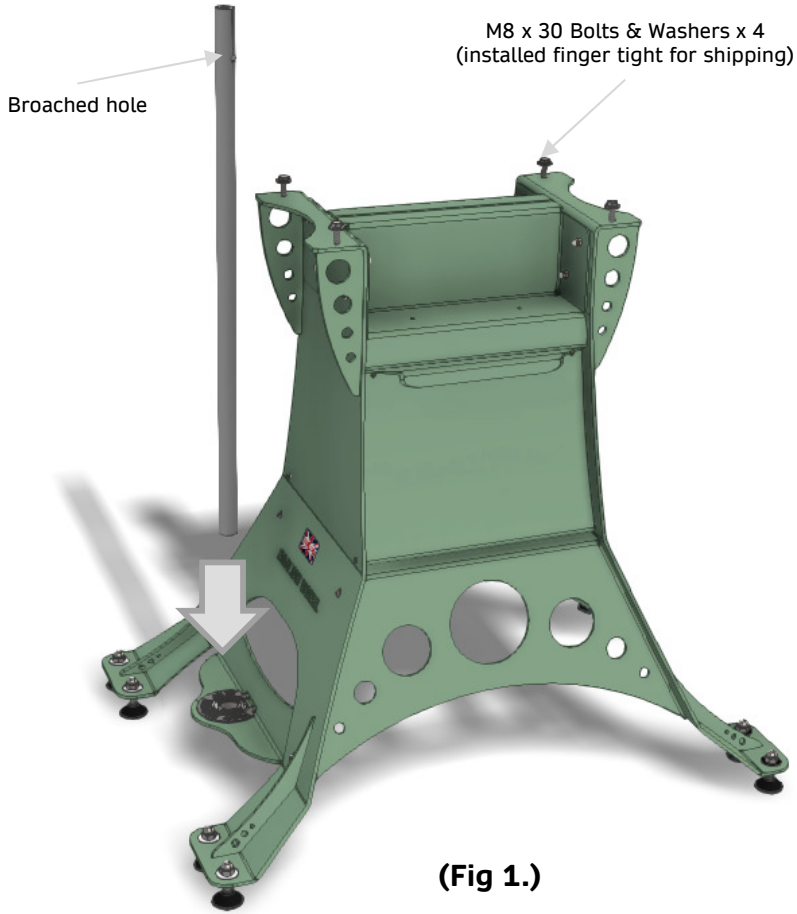
(4. Foot wheel)



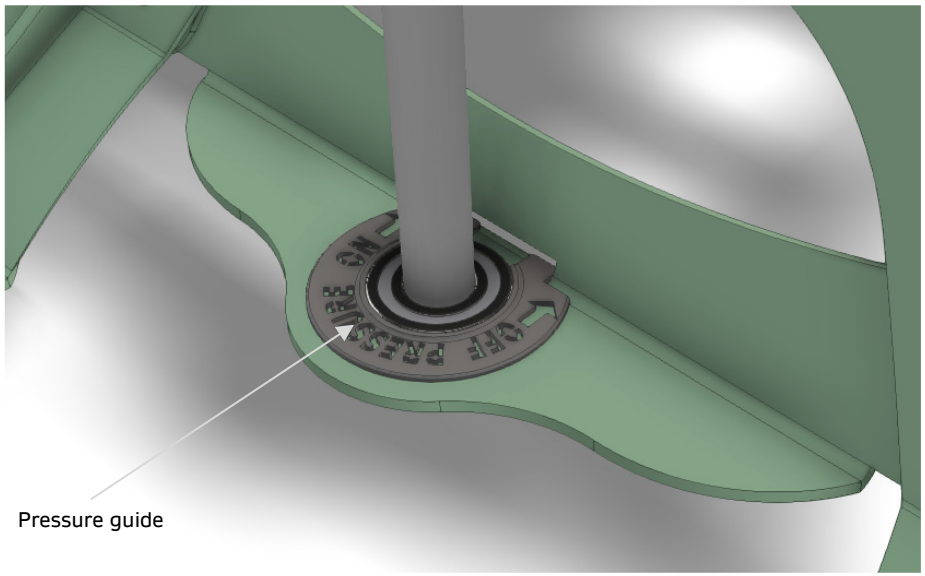
3. Setup

3.2 Assembly

Install the foot wheel shaft into the 25mm bearing, with the broached hole to the top of the shaft (Fig.1) lubricate if required.



(Fig 1.)

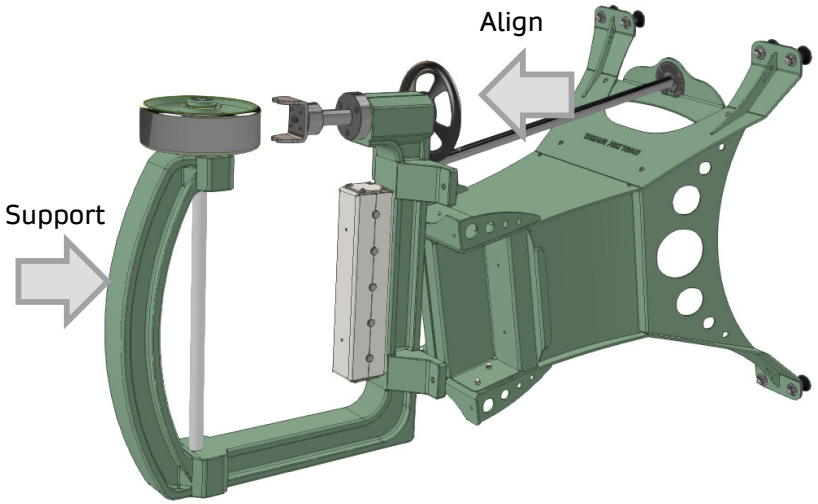


(Fig 2.)

3. Setup

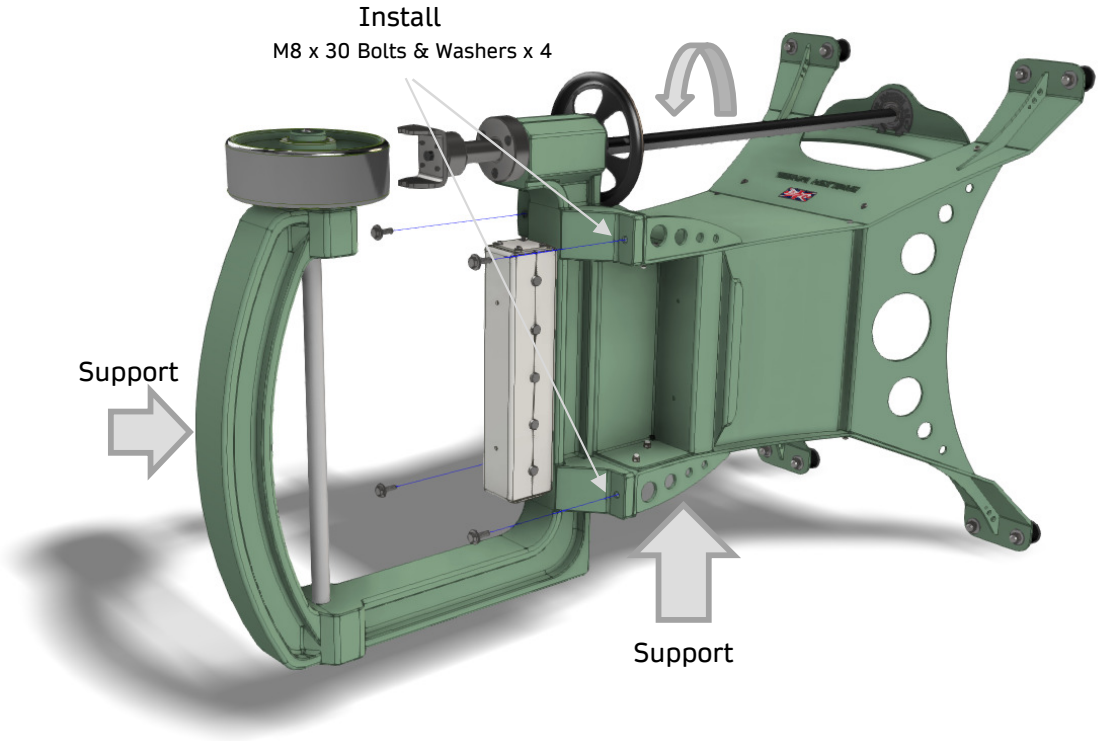
3.2 Assembly

If working without the assistance of a hoist, working from a flat floor level, lift up the base at its top supporting from below to install the 4 x M8 x 30 Bolts & Washers, then locate the shaft onto the base of the mechanism and screw into position (its not essential this is tight at this stage).



(Fig 1.)

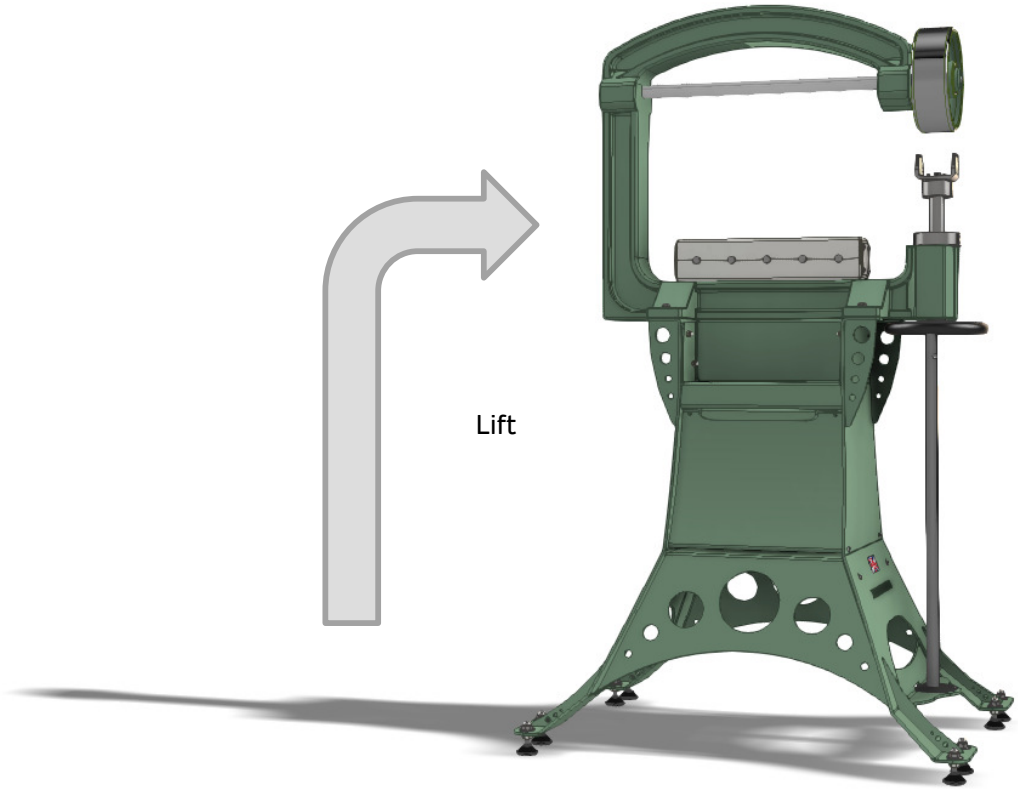
(Fig 2.)



3. Setup

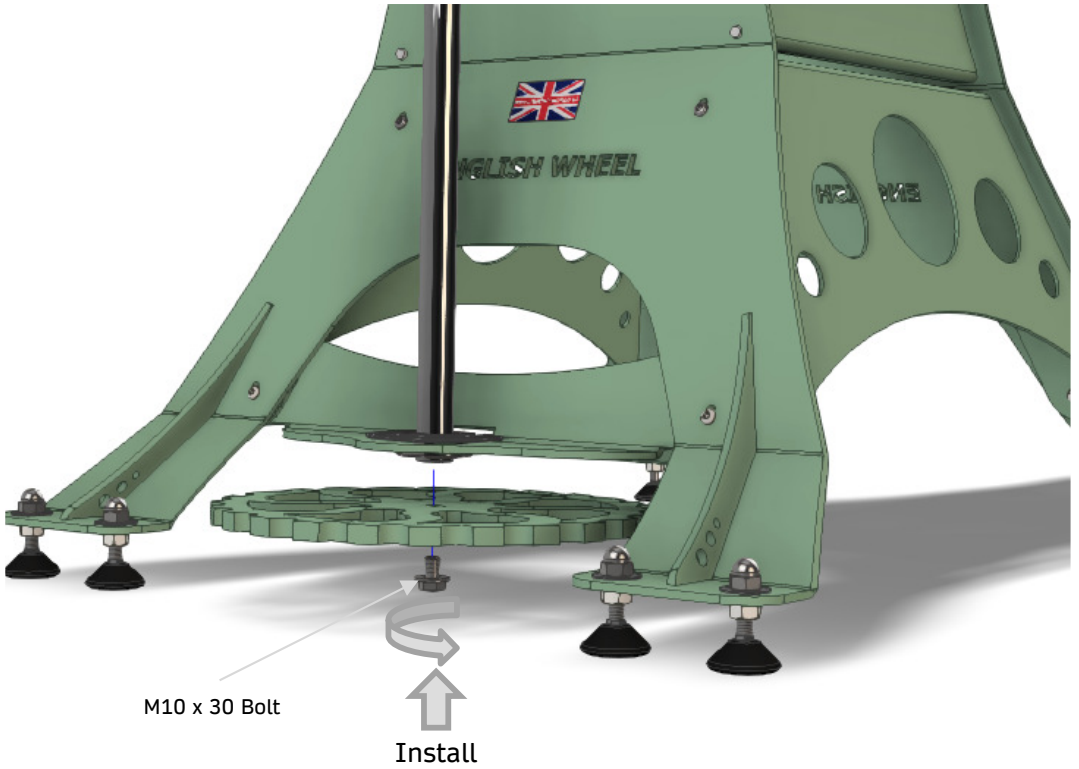
3.2 Assembly

With assistance, lift the machine sub-assembly into an upright position (Fig.1), and then install the foot wheel, securing it with the M10 Bolt (Fig.2). This assembly can now be fully tightened by rotating the foot wheel, and holding the hand wheel firmly.



(Fig 1.)

(Fig 2.)

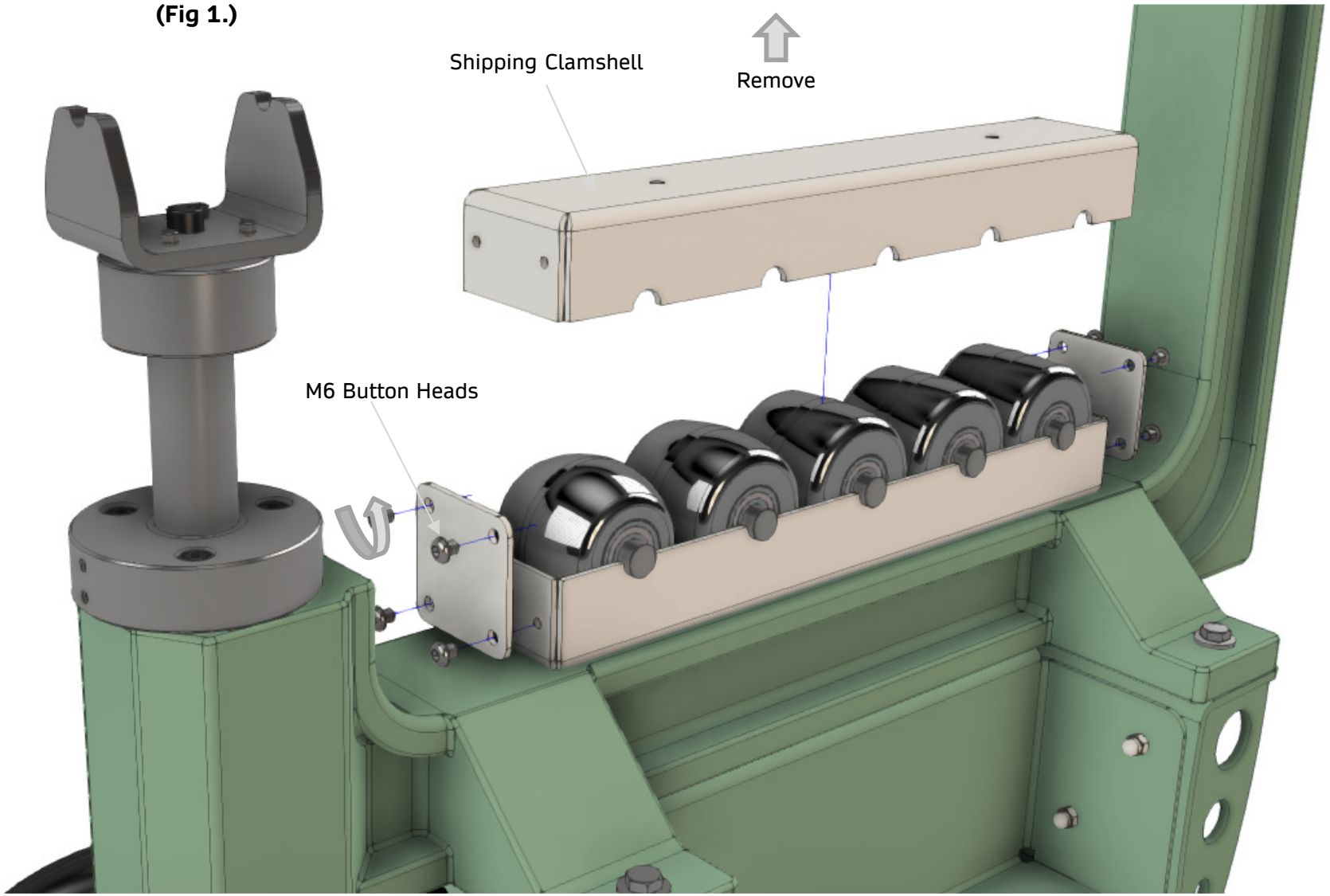


3. Setup

3.2 Assembly

Unscrew the 8-off M6 Button Heads, to reveal the anvils from the shipping clamshell (the top part can de discarded).

(Fig 1.)



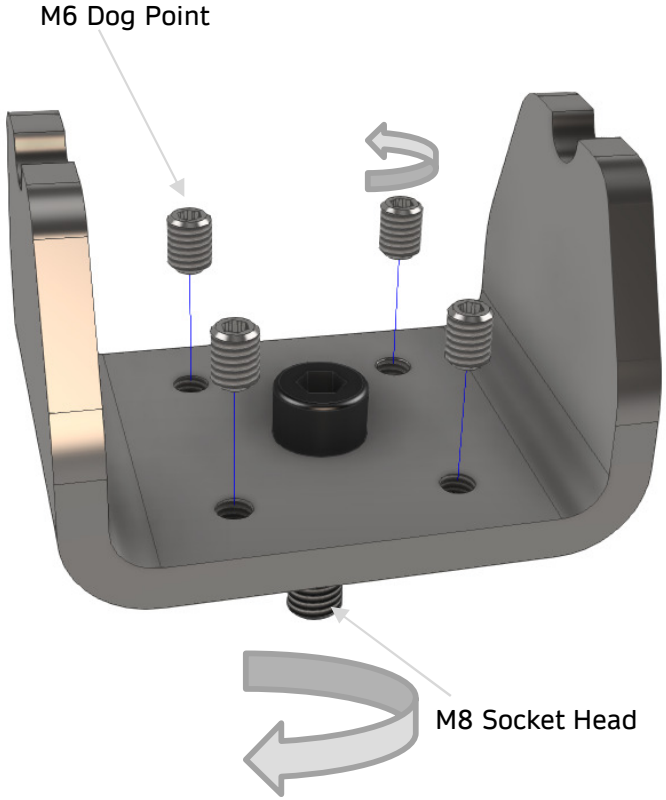
3. Setup

3.2 Assembly

Install and anvil into the cradle, and ensure the contact, or blow gap is even (Fig.1), adjust the level, with the M6 Dog point machine screws x 4, the tracking can also be adjusted with the M8 Socket head loosened.

(Fig 1.)

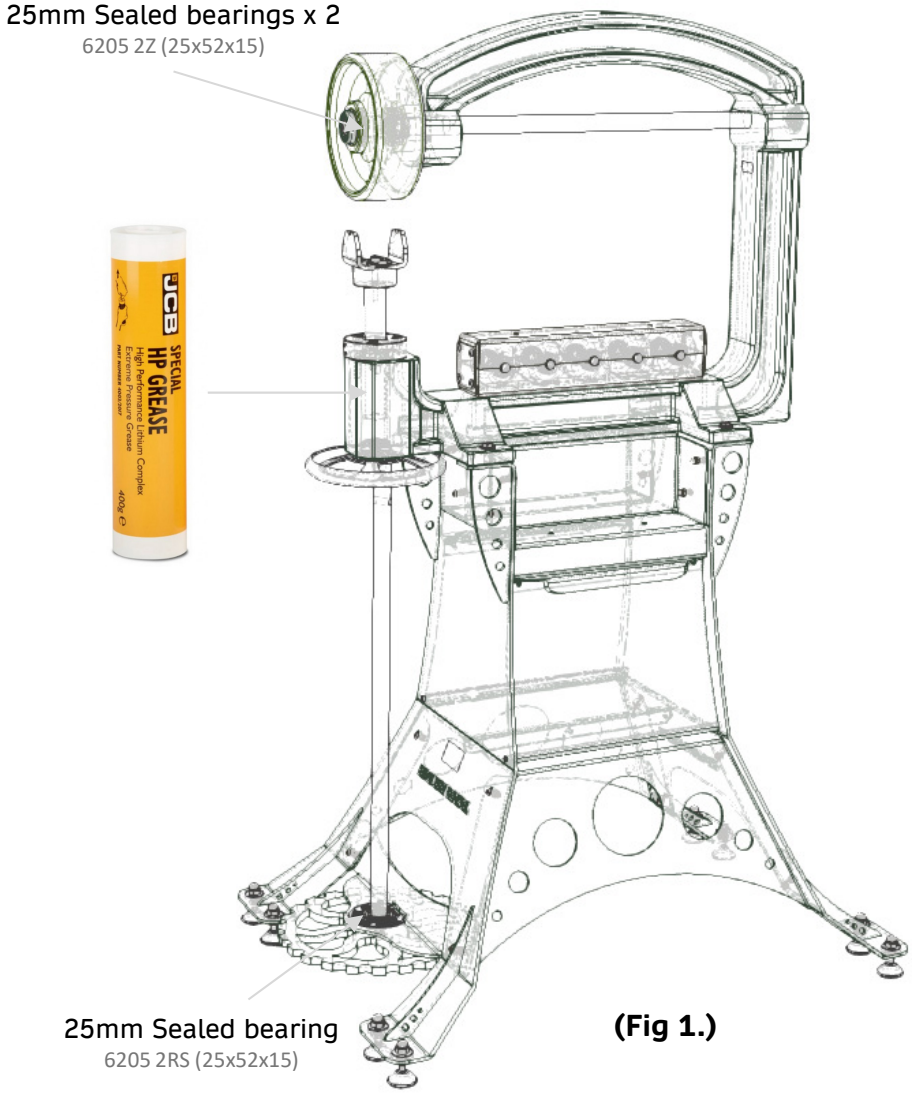
(Fig 2.)



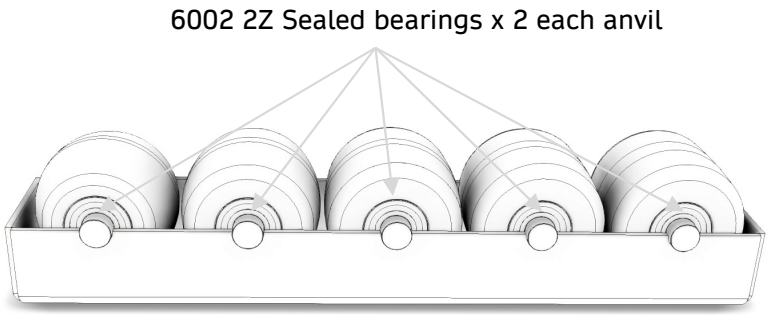
4. Maintenance

4.1 Lubrication - Cleaning & Maintenance

The wheeling machine features sealed bearings throughout, the mechanism or lifter has been packed with JCB high performance lithium based grease, and should not require any further maintenance over its lifetime.



(Fig 1.)



(Fig 2.)

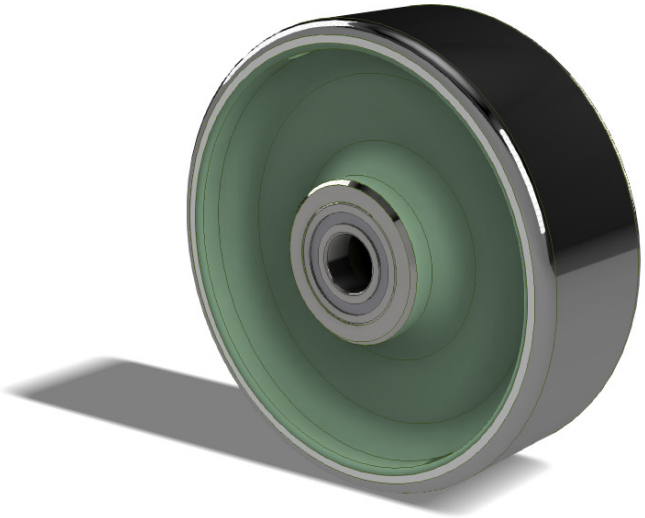
Cleaning & Maintenance

- Extreme care should be taken when cleaning the **machine steel** anvils, **keep moisture away from these at all times**, a light oil should be used after use, or for long term storage.
- If the anvils become tarnished, abrasive paper (400 Grit) should be used to restore surfaces, or use finer grades if possible.
- Do not attempt to use commercially available cleaning products as the may cause bleaching or staining.
- DO NOT use any abrasive pads on painted surfaces or any alkaline cleaning agents such as potassium hydroxide, sodium carbonate or caustic soda, or any powerful acidic products, heavily abrasive scouring agents or lacquer dissolving cleaning agents.

5. Spare Parts

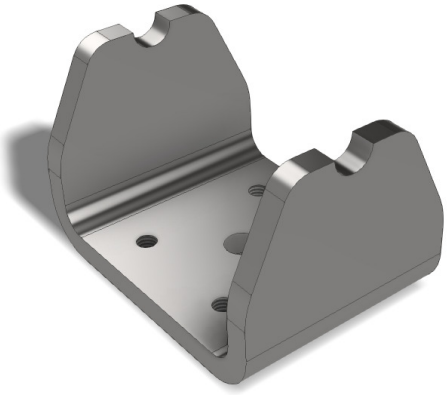
5.1 Anvils & Cradles

Top Anvil assembly (Fig.1), Lower Anvils set of 5 (Fig.2), Anvil Cradle (Fig.3)



(Fig 1.)

(Fig 2.)



(Fig 3.)