



## English Wheel

Item 68385

### INSTRUCTIONS AND PRECAUTIONS



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#### **!WARNING**

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

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-800-444-3353 as soon as possible.

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**For technical questions or replacement parts, please call 1-800-444-3353.**

REV 12a

### Specifications

Upper Wheel Size	8" radius x 2" W
Lower Wheel Included	3" curved radius x 2" W
Throat Size	27-3/4"
Stock Applications	16 gauge sheet metal, 14 (1/8") soft aluminum and copper
Features	Lower Wheel Rack Quick-Adjust Lower Bracket

### Important Safety Information

1. Wear ANSI-approved safety goggles and heavy-duty work gloves during setup and use. Wear a durable long-sleeved shirt or coat when working with large workpieces.
2. Wheel may crush and injure hands! Keep hands out of line of wheel during use. Do not use too tight a pinch, it will increase the amount of force used and increase the chance of accidentally crushing your finger.
3. Assemble only according to these instructions. Improper assembly can create hazards.
4. Keep assembly area clean and well lit.
5. Keep bystanders out of the area during assembly.
6. Do not assemble when tired or when under the influence of alcohol, drugs or medication.
7. This product is not a toy. Do not allow children to play with or near this item.
8. Use as intended only.
9. Inspect before every use; do not use if parts are loose or damaged.
10. To improve stability, bolt to floor before use. Verify that installation surface has no hidden utility lines before drilling or driving screws.
11. Maintain product labels and nameplates. These carry important safety information. If unreadable or missing, contact Harbor Freight Tools for a replacement.

## Assembly Instructions



Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this document including all text under subheadings therein before set up or use of this product.

**Note:** For additional information regarding the parts listed in the following pages, refer to the Assembly Diagram near the end of this manual.

Unpack the English Wheel components and lay out 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 work pieces.

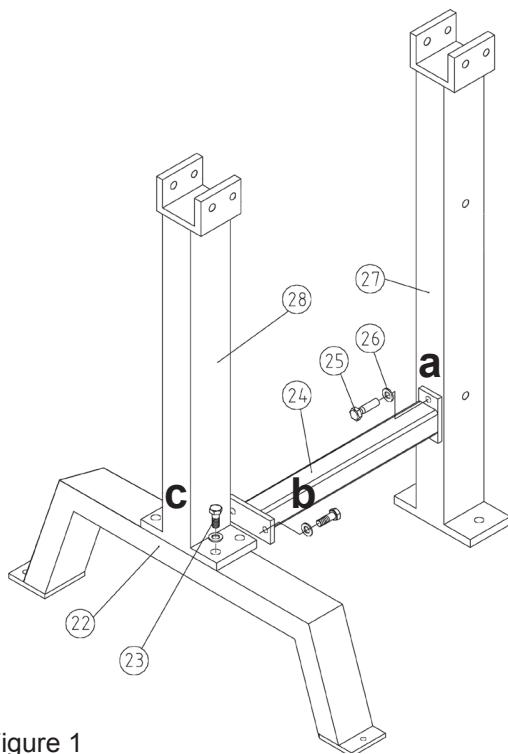


Figure 1

1. To attach the legs and footing:
  - a. Using two Bolts (25), and Washers (26) attach the Back Leg (27) to the Connecting Brace (24).
  - b. Attach the other end of the Connecting Brace (24) to the Front Footing (22) with the remaining two Bolts (25) and two of the Washers.
  - c. Attach the Front Leg (28) to the top of the Front Footing (22) with four Bolts (23) and Washers (26).

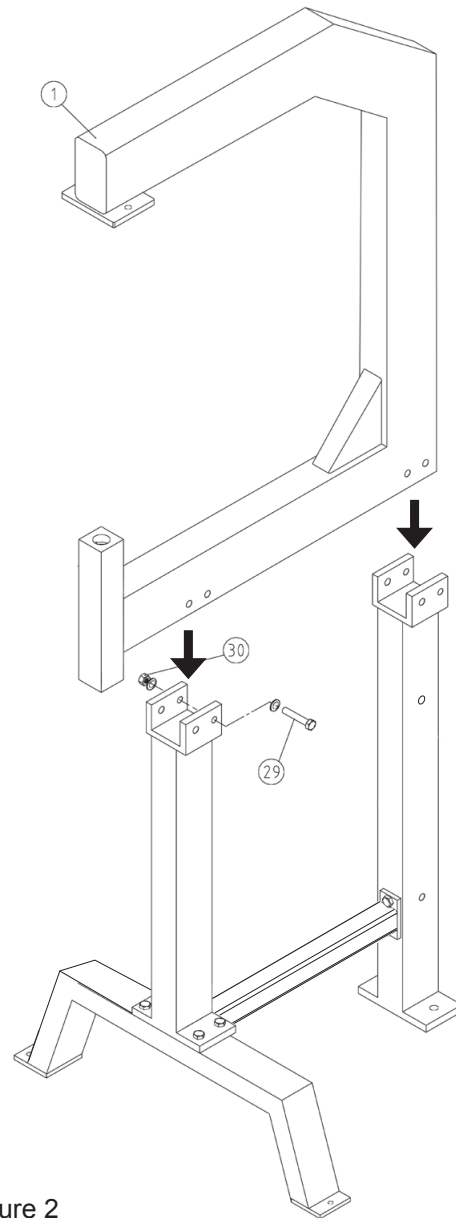


Figure 2

2. With the help of at least two other people, lift the Frame (1) and place it on the assembled legs and feet, aligning the bracket holes. Bolt in place with the four Bolts (29), eight Washers, and four Nuts (30). Check that the Frame is square, then securely tighten all bolts.

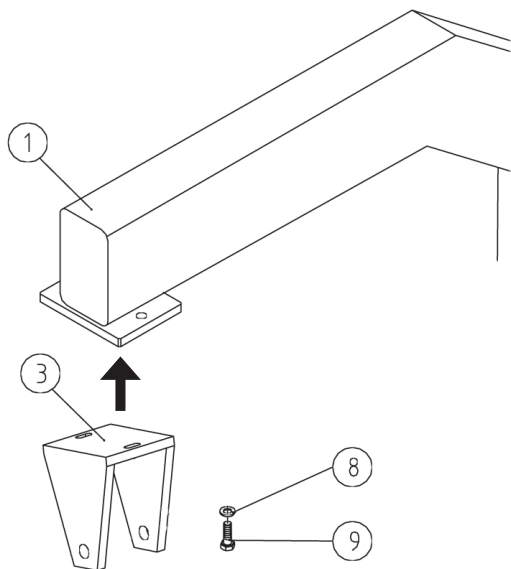


Figure 3

3. Bolt the Upper Wheel Bracket (3) to the Main Frame (1) using two Bolts (9) and Washers (8).

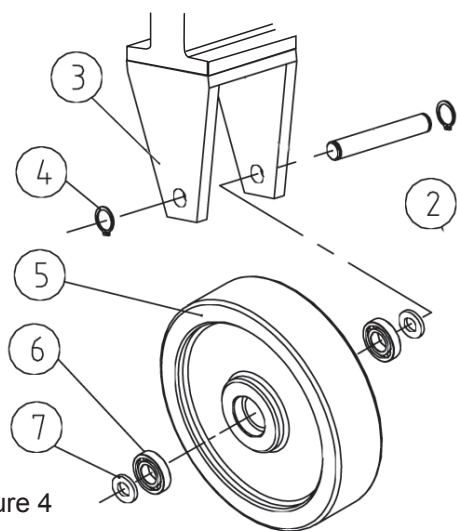
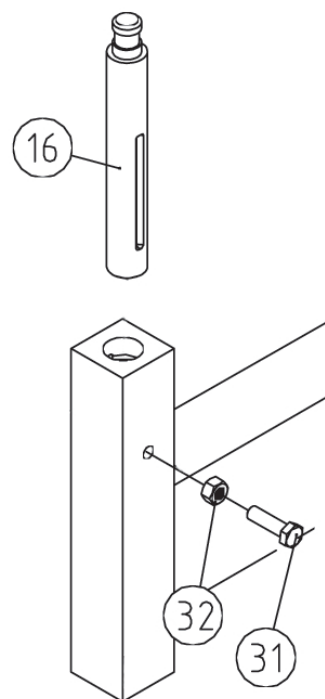
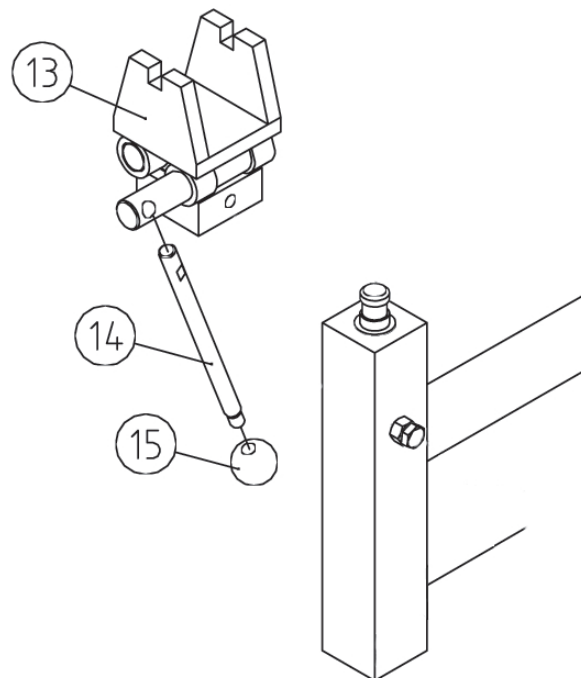


Figure 4

4. Slide the Upper Wheel Shaft (2) through one side of the Bracket (3), a Washer (7), Bearing (6), Upper Wheel (5), Bearing (6), Washer (7) and through the other side of the Bracket. Secure in place with the Circlips (4) at each end.



5. Slide the Adjustable Shaft (16) into the top of the channel of the Main Frame. Thread the Locking Nut (32) onto the Guide Bolt (31). Align the slot in the Shaft with the Bolt hole, and finger tighten the Bolt. Make sure the Shaft will not turn but can still slide up and down freely, then secure bolt in place with the Locking Nut.



6. Thread the Ball Handle (15) onto the Release Handle (14) and the Handle into the bar on the Lower Wheel Bracket (13). Place the Bracket on top of the Shaft (16).

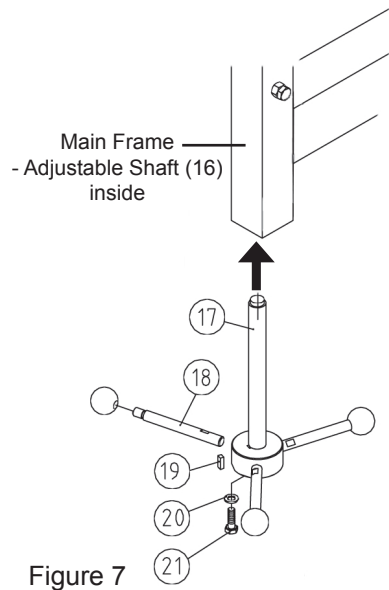


Figure 7

7. Thread the Ball Handles (15) into the three Height Handles (18) and the Handles into the bar on the Adjustable Threaded Shaft (17). Slide the Shaft into the bottom of the channel on the Main Frame (1) and secure to the Adjustable Shaft (16) inside the channel with the Key (19), Washer (20) and Bolt (21).

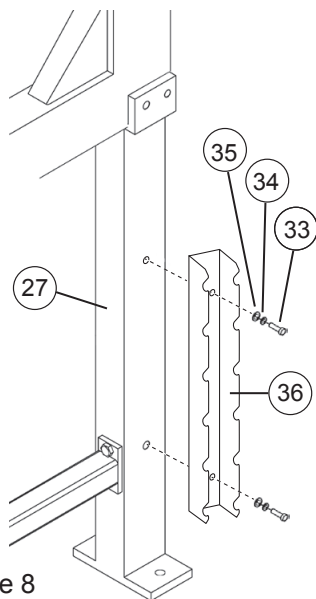


Figure 8

8. Attach the Rack (36) to the Back Leg (27) with the two Screws (33), Spring Washers (34) and Washers (35).

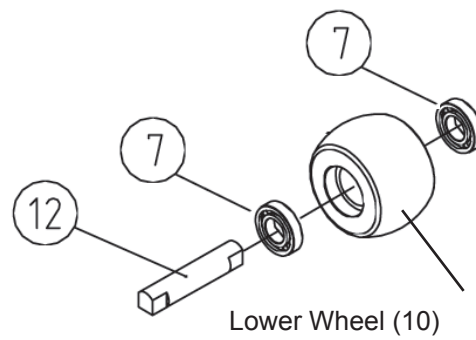


Figure 9

9. Assemble the Lower Wheel (10) by placing a Bearing (6) on either side of a wheel, then sliding a Shaft Pin (12) through the bearings and wheel. Place on the Bracket for the Lower Wheel.

## Operation Instructions



Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this document including all text under subheadings therein before set up or use of this product.

**WARNING!** Metal edges can be very sharp. Avoid injuries by wearing ANSI approved safety goggles and heavy duty work gloves whenever working, and wear a durable long-sleeved shirt or coat when working with large workpieces..

1. Use the included Lower Wheel or select a different lower wheel (sold separately) from the Rack, and place on the Bracket for the Lower Wheel. When selecting the Wheel, consider the type and hardness of the metal being formed, as well as the desired curvature of the metal.

**Note:** Measurements on lower wheels are the radius of their curvature. The smaller the measurement, the more severe the curve.

2. Insert the work piece in between the Upper and Lower Wheels.
3. Turn the Bracket Height Handle to raise or lower the Lower Wheel for appropriate clearance (or pinching) of the metal between the two wheels. It is recommended to have a looser pinch than a tighter one. A tighter pinch will make it harder to push the metal through (increasing the risk of crushing your finger) and may cause unwanted creasing. A looser pinch makes it easier to push the metal through, and with more accuracy. However, it may take more passes to form the metal.
4. Begin forming the metal by pushing and pulling it over the dies carefully. **KEEP YOUR HANDS CLEAR OF THE DIES.**
5. Use the Release Handle to separate the wheels for removal or repositioning of the workpiece.



## Maintenance Instructions



Read the **ENTIRE IMPORTANT SAFETY INFORMATION** section at the beginning of this document including all text under subheadings therein before servicing this product.

**Regularly lubricate all Shafts (2 and 12), all exposed metal surfaces and the inside of part 13.**

## Parts List and Assembly Diagram

Part	Description	Qty
1	Main Frame	1
2	Upper Wheel Shaft	1
3	Upper Wheel Bracket	1
4	Circlip	2
5	Upper Wheel	1
6	Bearing	4
7	Washer	2
8	Flat Washer	2
9	Hex Bolt	2
10	3" Lower Wheel	1
11	Grease Fitting	1
12	Lower Wheel Shaft	1
13	Lower Wheel Bracket	1
14	Release Handle	1
15	Handle Ball	4
16	Adjustable Shaft	1
17	Adjustable Threaded Shaft	1
18	Height Handle	3

Part	Description	Qty
19	Key	1
20	Washer	1
21	Hex Bolt	4
22	Front Footing	1
23	Hex Bolt	4
24	Connecting Brace	1
25	Hex Bolt	4
26	Flat Washer	16
27	Back Leg	1
28	Front Leg	1
29	Hex Bolt	4
30	Nut	4
31	Guide Bolt	1
32	Locking Nut	1
33	Screw	2
34	Spring Washer	2
35	Flat Washer	2
36	Rack	1

**Record Serial Number Here:**

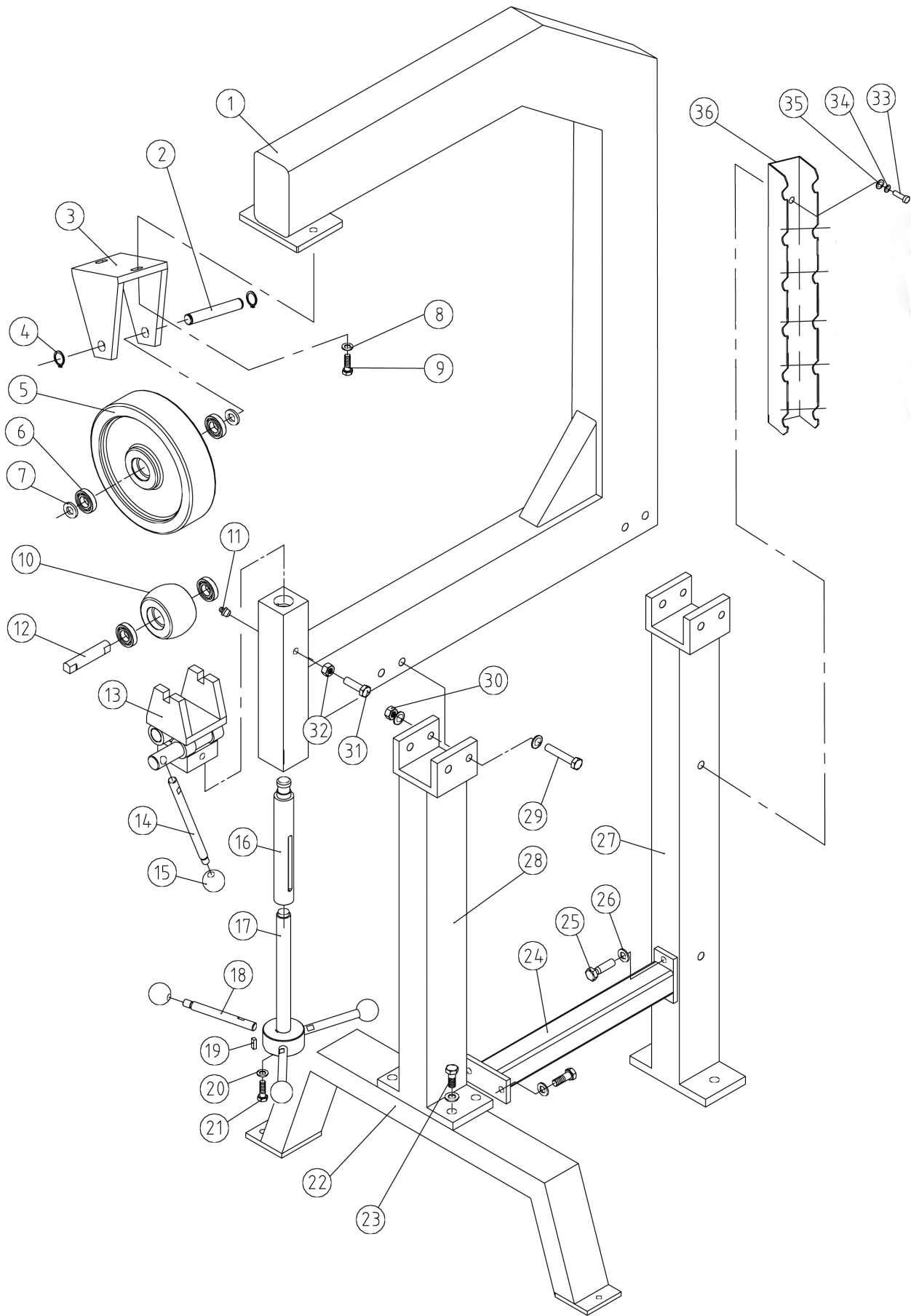
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**Note:** If product has no serial number, record month and year of purchase instead.

**Note:** Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts.

### PLEASE READ THE FOLLOWING CAREFULLY

THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS LIST AND ASSEMBLY DIAGRAM IN THIS DOCUMENT AS A REFERENCE TOOL ONLY. NEITHER THE MANUFACTURER OR 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.



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To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.



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