



## ENGLISH WHEEL WITH STAND

### OWNER'S MANUAL



#### **WARNING:**

Read carefully and understand all ASSEMBLY AND OPERATION INSTRUCTIONS before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

**Item# 49703**



## ENGLISH WHEEL WITH STAND OWNER'S MANUAL

Thank you very much for choosing a Klutch product. For future reference, please complete the owner's record below:

Serial Number/Lot Date Code: \_\_\_\_\_ Purchase Date: \_\_\_\_\_

Save the receipt, warranty and these instructions. It is important that you read the entire manual to become familiar with this product before you begin using it.

This manual pipe bender, with or without the base, is designed for certain applications only. Northern Tool and Equipment cannot be responsible for issues arising from modification or use of this product in an application for which it was not designed. We strongly recommend that this product not be modified and/or used for any application other than that for which it was designed.

For technical questions please call 1-800-222-5381.

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### Intended Use

The English wheel is ideal for shaping, fabrication, smoothing dents or weld seams in fenders, hoods and trunk panels. It is also excellent for polishing aluminum, etc.

### Technical Specifications

| Property           | Specification                                                                    |
|--------------------|----------------------------------------------------------------------------------|
| Throat Depth (in.) | 28"                                                                              |
| Capacity           | Handles sheet metal to 16 gauge (1.2mm), copper and aluminum to 14 gauge (1.9mm) |
| Accessory          | 1pc 8in. dia. x 2in. W top anvil and<br>1pc 3in. dia. x 2in.                     |
| Overall            | radius bottom anvil                                                              |
| Dimension (in.)    | 35-1/2 x 34-5/8 x 60-1/4                                                         |
| Ship Weight (lbs.) | 180                                                                              |

**Important Safety Information****WARNING:**

- Read and understand all instructions. Failure to follow all instructions may result in serious injury.
- The warnings, cautions, and instructions in this manual cannot cover all possible conditions or situations that could occur. Exercise common sense and caution when using this tool. Always be aware of the environment and ensure that the tool is used in a safe and responsible manner.
- DO NOT allow persons to operate or assemble this product until they have read this manual and have developed a thorough understanding of how the product works.
- DO NOT modify the product in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the product. There are specific applications for which the product was designed.
- Use the right tool for the job. DO NOT attempt to force a small equipment to do the work of larger industrial equipment. There are certain applications for which this equipment was designed. It will do the job better and more safely at the capacity for which it was intended. DO NOT use this equipment for a purpose for which it was not intended.
- Industrial or commercial applications must follow OSHA requirements.

**WARNING:****WORK AREA SAFETY**

- Inspect the work area before each use. Keep work area clean, dry, free of clutter, and well lit. Cluttered, wet, or dark work areas can result in injury. Using the tool in confined work areas may put you dangerously close to other cutting tools and rotating parts.
- Do not use the tool where there is a risk of causing a fire or an explosion; e.g., in the presence of flammable liquids, gases, or dust. The tool can create sparks, which may ignite the dust or fumes.
- Do not allow the tool to come into contact with an electrical source. Contact will cause shock.
- Keep children and bystanders away from the work area while operating the tool. Do not allow children to handle the tool.
- Be aware of all power lines, electrical circuits, water pipes, and other mechanical hazards in your work area. Some of these hazards may be below the work surface hidden from your view and may cause personal harm or property damage if unintentionally contacted.

**PERSONAL SAFETY**

- Stay alert, watch what you are doing, and use common sense when operating the tool. Do not use the tool while you are tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating the tool may result in serious personal injury.
- Dress properly. Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts.
- Use ANSI-Z87.1 compliant safety goggles or safety glasses with side shields, or when needed, a face shield. Use a dust mask in dusty work conditions. Also use non-skid safety shoes, hardhat, gloves, dust collection systems, and hearing protection when appropriate. This applies to all persons in the work area.
- Do not overreach. Keep proper footing and balance at all times.

**CAUTION****ENGLISH WHEEL USE AND CARE**

- Do not force the tool. Tools do a better and safer job when used in the manner for which they are designed. Plan your work, and use the correct tool for the job.
- Check for damaged parts before each use. Carefully check that the tool will operate properly and perform its intended function. Replace damaged or worn parts immediately. Never operate the tool with a damaged part.
- Store the tool when it is not in use. Store it in a dry, secure place out of the reach of children. Inspect the tool for good working condition prior to storage and before re-use.
- Use only accessories that are recommended by the manufacturer for use with your tool. Accessories that may be suitable for one tool may create a risk of injury when used with another tool. Never use an accessory that has a lower operating speed or operating pressure than the tool itself.
- Inspect the wheel and components for damage or excessive wear before each use. If you find damage do not use the wheel.

**Specific Operation Warnings****WARNING:**

- Pinch point hazard. Keep hands clear from the roller while in use.
- Check that the English wheel is properly secured before each use.

**Assembly**

1. Attach the front leg (28) to the front leg seat (22) with bolts (23) and washers (26), then attach the back leg (27) to the front leg and seat through connecting pipe (24) with washers (26), bolts (25).
2. Attach the main frame (1) to the front leg (28) and back leg (27) with bolts (29), washers (26) and nuts (30).
3. Attach the upper wheel bracket (3) to the upper wheel (5) through shaft pin (2) with bearings (6) and washers (7), then covers (4) on both sides of the wheel (see the parts diagram).
4. Attach the upper wheel (5) and bracket (3) to the main frame (1) with bolts (9) and washers (8).
5. Place bearings (6) on both sides of the lower wheel (10) and connect them with shaft pin (12) then set this assembly in the notches of the lower wheel bracket (13). Other lower wheels 37, 38, 39, 40, or 41 are installed in the same way as above or are stored on the hanger (36). (These wheels must be purchased separately.)
6. Install the adjustable shaft (16) into the main frame (1) from the top hole then secure the shaft with guide bolt (31) and nut (32) so the shaft cannot rotate but only slide up and down. Install the oil cup (11) at the other side of the main frame than the bolt (see parts diagram).
7. Screw the adjustable threaded shaft (17) into the main frame (1) from the bottom hole and connect the handle seat (17) with the shaft's bottom end with the flat key (19) then secure it with washer (20) and bolt (21).
8. Place the lower wheel bracket (13) on the top of the adjustable shaft (16) and lock it with bolt (14). Screw a handle ball (15) on the end of the bolt.
9. Insert the ends of the handles (18) with the markings into the handle seat and screw a handle ball (15) on the end of each handle. You can turn the handle to adjust the distance between lower wheel and threaded shaft (17).
10. Attach the hanger (36) to the back leg (27) with spring washer (34), flat washer (35) and bolt (33).

### Before Each Use

- The English Wheel should be installed on a level surface, with proper lighting.
- The area around machine should be clear of scraps, oil or dirt.
- Apply a suitable non-skid material to floor.
- Be sure to keep hands clear of forming wheels when rotating the crank handle.
- Inspect the upper wheel (5) to make sure it is clean, free of dents or other defects, and ready for use.
- Ensure that the levers on the lower wheel bracket and handle seat operate properly.

### Operating Instructions

The workpiece is formed between the upper wheel (5) and the lower wheel (10). According to the work to do, choose as a lower wheel 37, 38, 39, 40, and 41 (which are sold separately and available from the distributor). Be sure to keep hands clear of the forming wheels when rotating the crank handle (14).

### After Each Use

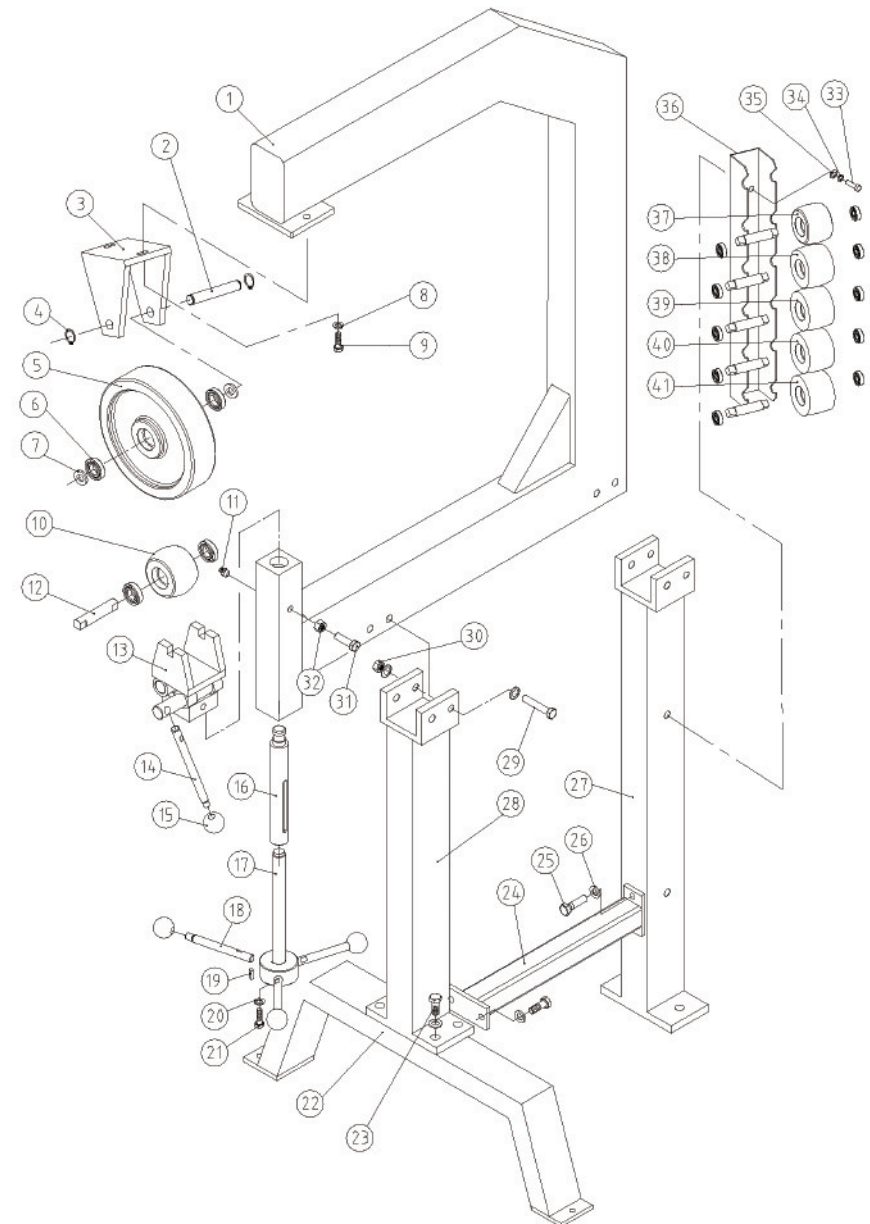
Clean up the area around the English wheel to clear it of scraps.

### Maintenance

Maintain the english wheel. Keep it in good repair by adopting a program of conscientious repair and maintenance in accordance with the recommended procedures found in this manual. Keep handles dry, clean, and free from oil and grease.

- All exposed iron surfaces should be coated with light oil to prevent rusting. Use a multi-purpose or bearing grease for lubrication.
- The adjusting block (13) should be greased.
- Oil the driving shaft (16 & 17) through the oil cup monthly.

### Parts Diagram





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### Parts List

| Part No. | Description               | Q'ty | Part No. | Description                    | Q'ty |
|----------|---------------------------|------|----------|--------------------------------|------|
| 1        | Main frame                | 1    | 22       | Front Leg seat                 | 1    |
| 2        | shaft pin                 | 1    | 23       | Hex. Bolt                      | 4    |
| 3        | Upper wheel bracket       | 1    | 24       | Connecting pipe                | 1    |
| 4        | Cover                     | 2    | 25       | Hex. Bolt                      | 4    |
| 5        | Upper wheel               | 1    | 26       | Flat washer                    | 16   |
| 6        | Bearing                   | 14   | 27       | Back leg                       | 1    |
| 7        | Washer                    | 2    | 28       | Front leg                      | 1    |
| 8        | Flat washer               | 2    | 29       | Hex. Bolt                      | 4    |
| 9        | Hex. Bolt                 | 2    | 30       | Nut                            | 4    |
| 10       | 3" Lower wheel            | 1    | 31       | Guide bolt                     | 1    |
| 11       | Oil cup                   | 1    | 32       | Nut                            | 1    |
| 12       | Shaft pin                 | 6    | 33       | Screw                          | 2    |
| 13       | Lower wheel bracket       | 1    | 34       | Spring washer                  | 2    |
| 14       | Handle                    | 1    | 35       | Flat washer                    | 2    |
| 15       | Handle ball               | 4    | 36       | Hanger                         | 1    |
| 16       | Adjustable shaft          | 1    | 37       | 4" Lower wheel (not included)  | 1    |
| 17       | Adjustable threaded shaft | 1    | 38       | 6" Lower wheel (not included)  | 1    |
| 18       | Handle                    | 3    | 39       | 8" Lower wheel (not included)  | 1    |
| 19       | Flat key                  | 1    | 40       | 10" Lower wheel (not included) | 1    |
| 20       | End cover                 | 1    | 41       | Flat wheel (not included)      | 1    |
| 21       | Hex. Bolt                 | 1    |          |                                |      |

### Replacement Parts

- For replacement parts and technical questions, please call Customer Service at 1-800-222-5381.
- Not all components are available for replacement. The illustrations provided are a convenient reference to the location and position of parts.
- The following are required when ordering parts: model number, serial number/lot date code, and description.
- The distributor reserves the rights to make design changes and/or improvements to product lines and manuals without notice.

### Limited Warranty

Northern Tool and Equipment Company, Inc. ("We" or "Us") warrants to the original purchaser only ("You" or "Your") that the Ironton Air Tool product purchased will be free from material defects in both materials and workmanship, normal wear and tear excepted, for a period of one year from date of purchase. The foregoing warranty is valid only if the installation and use of the product is strictly in accordance with product instructions. There are no other warranties, express or implied, including the warranty of merchantability or fitness for a particular purpose. If the product does not comply with this limited warranty, Your sole and exclusive remedy is that We will, at our sole option and within a commercially reasonable time, either replace the product without charge to You or refund the purchase price (less shipping). This limited warranty is not transferable.



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### Limitations on the Warranty

This limited warranty does not cover: (a) normal wear and tear; (b) accessories both consumable and durable; (c) damage through abuse, neglect, misuse, or as a result of any accident or in any other manner; (d) damage from misapplication, overloading, or improper installation; (e) improper maintenance and repair; and (f) product alteration in any manner by anyone other than Us, with the sole exception of alterations made pursuant to product instructions and in a workmanlike manner.

### Obligations of Purchaser

You must retain Your product purchase receipt to verify date of purchase and that You are the original purchaser. To make a warranty claim, contact Us at 1-800-222-5381, identify the product by make and model number, and follow the claim instructions that will be provided. The product and the purchase receipt must be provided to Us in order to process Your warranty claim. Any returned product that is replaced or refunded by Us becomes our property. You will be responsible for return shipping costs or costs related to Your return visit to a retail store.

### Remedy Limits

Product replacement or a refund of the purchase price is Your sole remedy under this limited warranty or any other warranty related to the product. We shall not be liable for: service or labor charges or damage to Your property incurred in removing or replacing the product; any damages, including, without limitation, damages to tangible personal property or personal injury, related to Your improper use, installation, or maintenance of the product; or any indirect, incidental or consequential damages of any kind for any reason.

### Assumption of Risk

You acknowledge and agree that any use of the product for any purpose other than the specified use(s) stated in the product instructions is at Your own risk.

### Governing Law

This limited warranty gives You specific legal rights, and You also may have other rights which vary from state to state. Some states do not allow limitations or exclusions on implied warranties or incidental or consequential damages, so the above limitations may not apply to You. This limited warranty is governed by the laws of the State of Minnesota, without regard to rules pertaining to conflicts of law. The state courts located in Dakota County, Minnesota shall have exclusive jurisdiction for any disputes relating to this warranty.



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