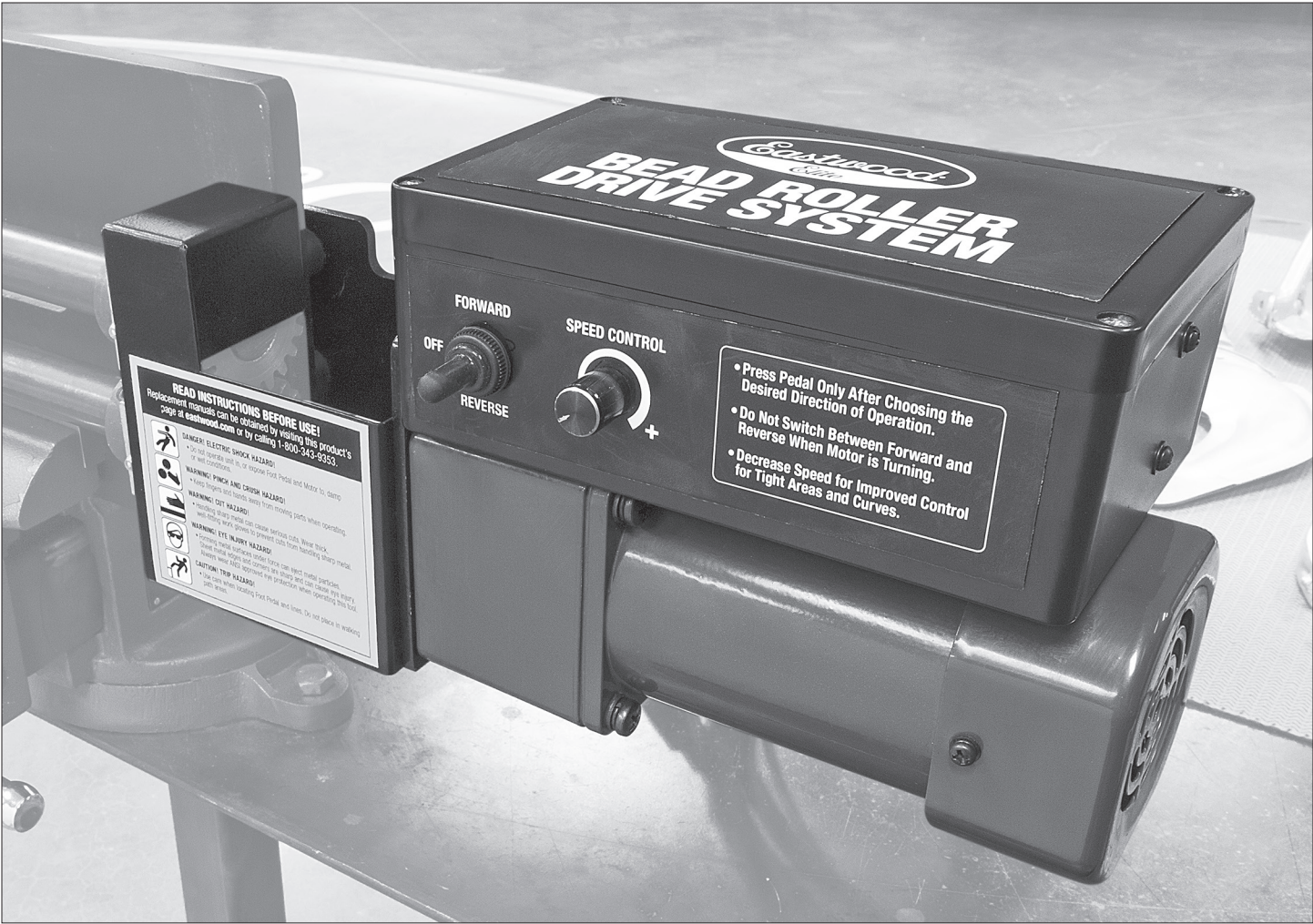




DO THE JOB RIGHT.®

Item #21111

# BEAD ROLLER DRIVE SYSTEM INSTRUCTIONS



The **EASTWOOD BEAD ROLLER DRIVE SYSTEM KIT** features a powerful 1.65-amp motor with an integral 75:1 gear reduction. A 3 Position Toggle Switch with an infinitely variable Speed Control and Foot Switch provide much greater convenience and one-person operation. Fits all Eastwood Bead Rollers and others with a plate steel frame and 50mm bearing block bolt pattern.

Visit the Bead Roller Drive Systems product page at [Eastwood.com](http://Eastwood.com) for video instructions.

## CONTENTS

- (1) Motor/Controller/Bracket Assembly with Foot Switch - [A]
- (1) Shaft Coupling - [B]
- (1) Gear Guard - [C]
- (2) M12X1.75 – 55mm Bracket Mounting Bolts - [D]
- (2) Mounting Spacers - [E]
- (6) Washers (Used in addition to the Mounting Spacers for use on 27" Eastwood Elite Bead Roller and others) - [F]



## TOOLS REQUIRED (Not Included)

- 18mm wrench
- 3mm Hex Key
- 4mm Hex Key



# SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

## **⚠ DANGER**

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

## **⚠ WARNING**

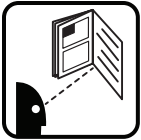
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

## **⚠ CAUTION**

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

## **⚠ NOTICE**

NOTICE is used to address practices not related to personal injury.



### **⚠ READ INSTRUCTIONS**

- Thoroughly read and understand these product instructions before using this tool. Failure to follow all warnings can result in tool damage or serious physical injury.
- Keep these product instructions for future reference.



### **⚠ WARNING PINCH AND CRUSH HAZARD!**

- This Bead Roller Drive System has rotating components that generates crushing and bending forces when in use which can quickly cause severe injury! Keep fingers and hands away from moving parts when operating.



### **⚠ WARNING CUT HAZARD!**

- Handling sharp metal can cause serious cuts. Wear thick, well-fitting work gloves to prevent cuts from handling sharp metal.



### **⚠ WARNING EYE INJURY HAZARD!**

- Metal particles can be ejected from the metal surface when bending. Sheet metal edges and corners are sharp and can injure eyes. Always wear ANSI approved eye protection when operating this tool.



### **⚠ WARNING**

- Before beginning ANY work with this tool, it is absolutely necessary that the base bead roller be installed in a vise properly secured to a sturdy workbench anchored to the floor or wall.

# SET-UP

## ⚠ NOTICE

It is strongly recommended that for greater ease of installation and safety, the Bead Roller (not included) be securely mounted in a vise. Follow instructions included with the specific Bead Roller being used for proper mounting procedures and safety warnings.

1. Remove existing Hand crank from bead roller and file any burrs remaining on shaft.
2. Back out the set screws on both bores of the Shaft Coupling [B] with a 3mm hex key (Not Included) so that they are not protruding into the I.D (FIG 1).
3. Loosen and remove the crank/gear-side bearing block retaining bolts of the existing Bead Roller. The Bead Roller should resemble the following figure (FIG 2) at this point with the longer shaft located at the bottom of the bead roller. (If necessary, unbolt the upper and lower shafts from the Bead Roller frame and re-install them with the longer shaft at the bottom).
4. Slide the smaller I.D of the Shaft Coupling [B] 1/2" to 5/8" [13-16mm] over the motor shaft with the keyway aligned with the shaft key. 3mm Hex Key (not included) to tighten the set-screws (FIG 3).

FIG. 1

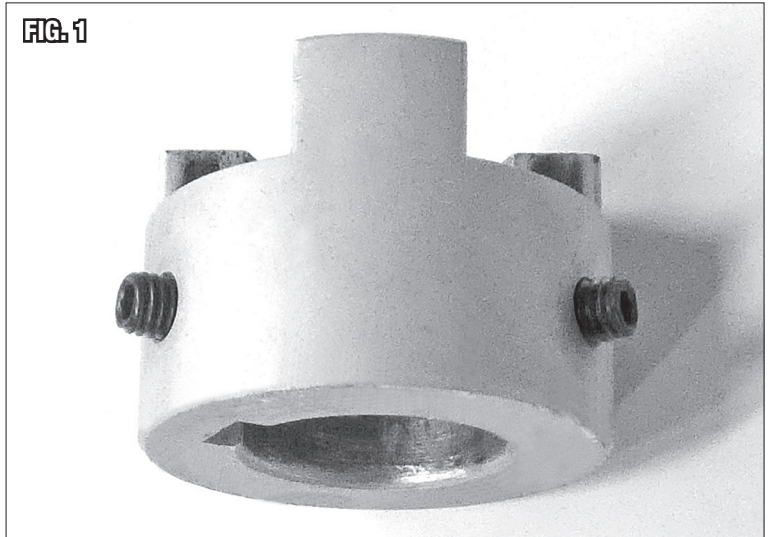
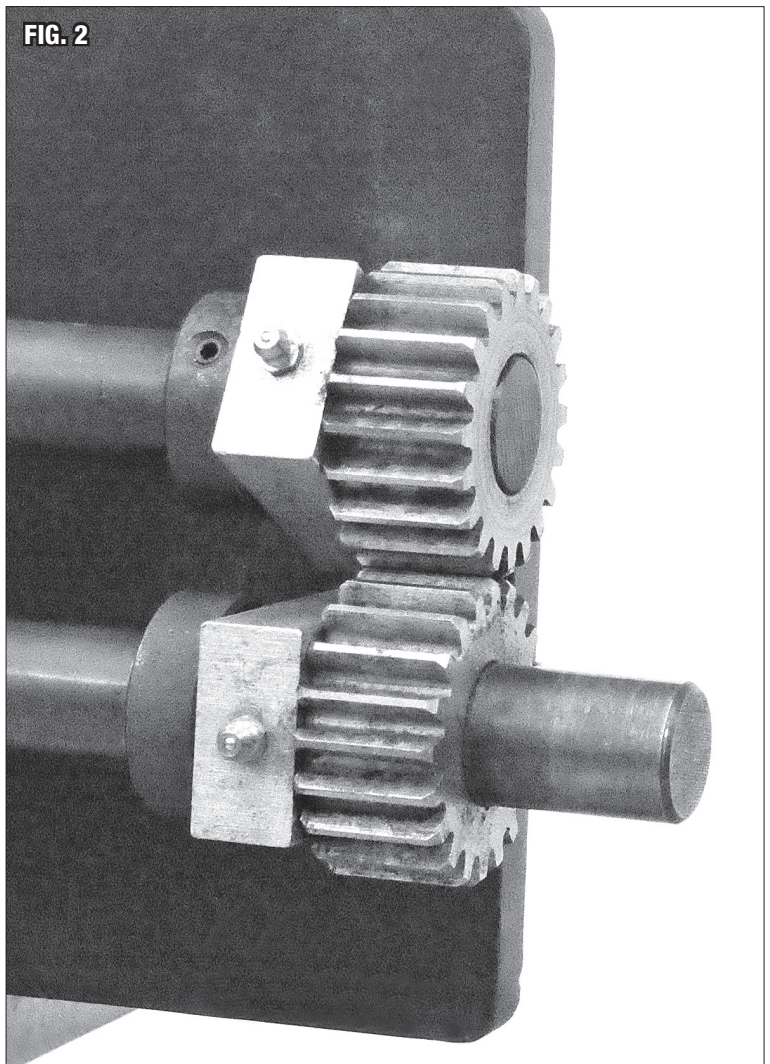


FIG. 2





# ASSEMBLY

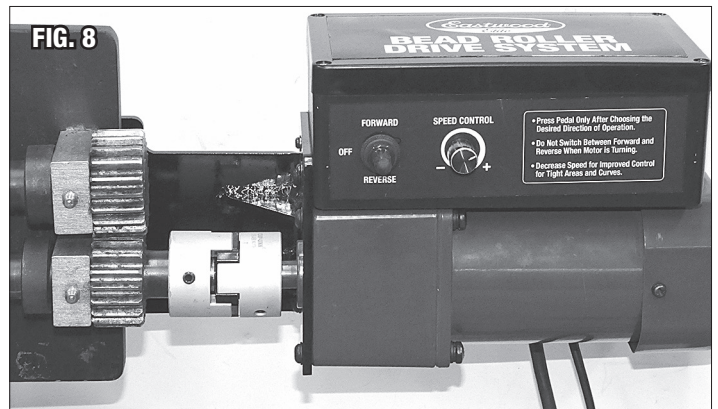
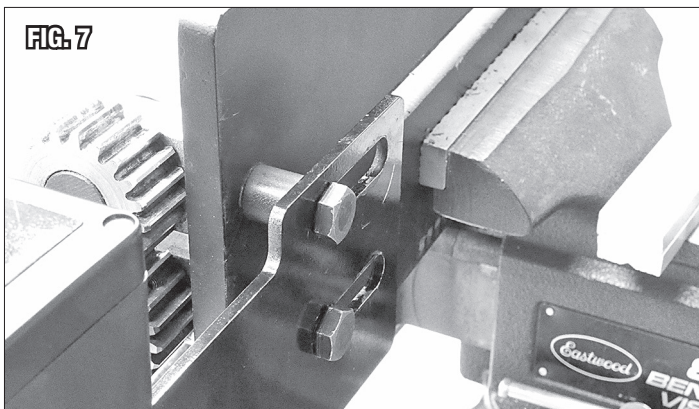
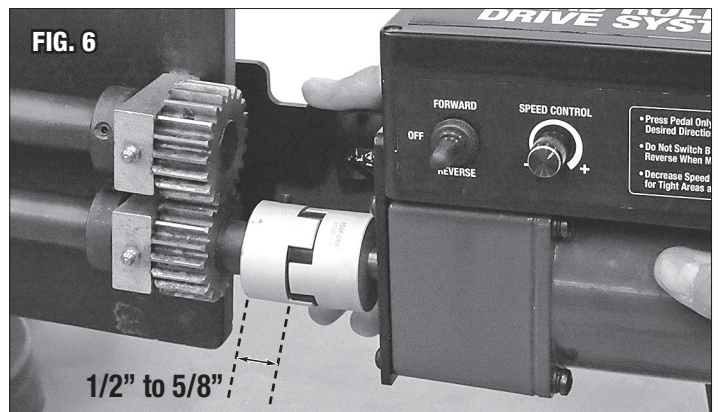
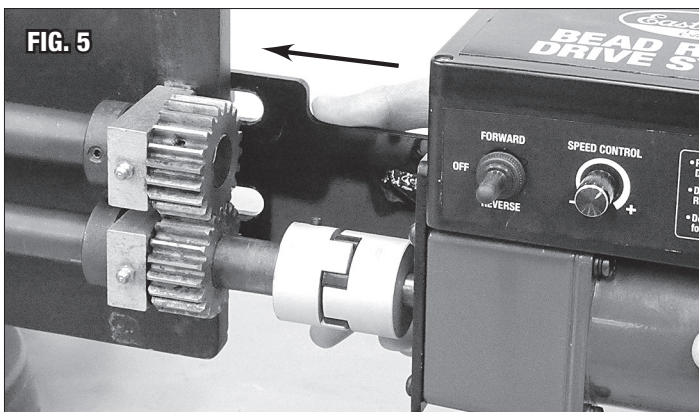
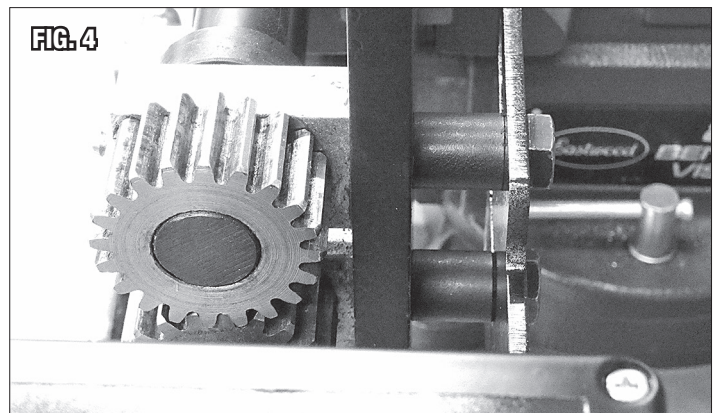
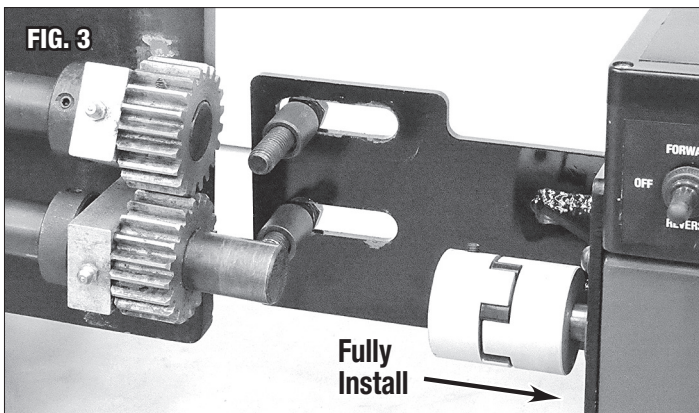
## ⚠ NOTICE

The following steps will require performing three actions at the same time. It is strongly advised to obtain the assistance of a helper while performing these following steps.

1. While holding the Motor/Controller/Bracket Assembly [A] in place behind the bead roller frame, insert the two M12X1.75 – 55mm Bracket Mounting Bolts [D] into the slotted mounting holes of the Bracket then slip the two Mounting Spacers [E] over the bolt threads (if installing on 21327 Eastwood Elite 27" Bead Roller, use each Mounting Spacer with 3 Washers [F]) (FIG 3).

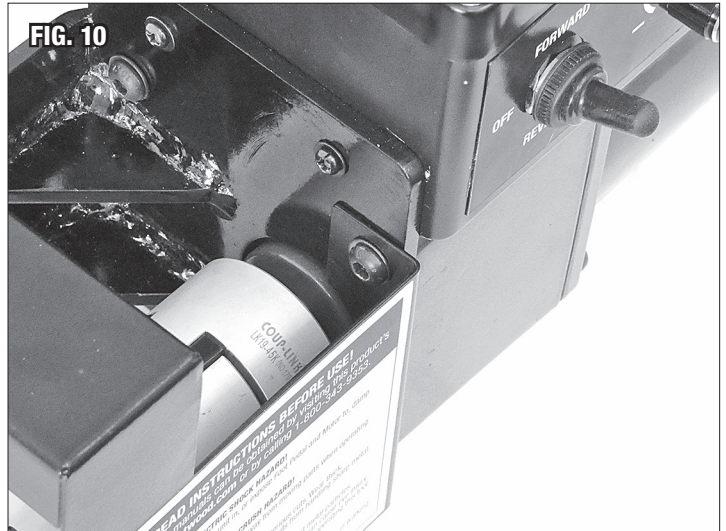
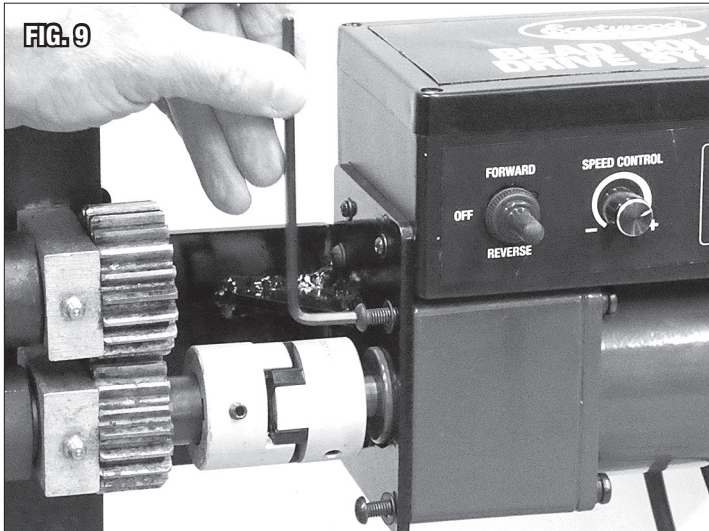
**NOTE:** Additional Washers (included) may be required as spacers in some Bead Roller applications.

2. Pass the Bolts [D] through the holes in the Bead Roller frame then thread them into the bearing blocks (FIG 4). At the same time, align the Set-Screw of the Coupling [B] to the flat of the shaft and slip the larger 25mm bore of the Shaft Coupling [B] over the lower Bead Roller shaft (FIG 5).
3. The Shaft Coupling must extend over the Bead Roller shaft by 1/2" to 5/8" [13-16mm] to allow sufficient engagement of the set screws (FIG 6). The elongated holes of the Bracket will accommodate "in-and out" horizontal adjustment (FIG 7). **NOTE:** The Motor/Controller/Bracket Assembly must be in exact horizontal alignment with the Bead Roller to prevent any mis-alignment in the Shaft Coupling. Once this is accomplished, use an 18mm wrench (not included) to tighten the Bracket Mounting Bolts and a 3mm Hex Key (not included) to tighten the set-screws. At this point, the assembly should appear as in (FIG 8).



## INSTALL GEAR GUARD

1. With a 4mm hex key (not included) loosen and remove the two outer Motor Mounting Screws (**FIG 9**).
2. Position the Gear Guard [C] so that it covers the gears and the two holes are aligned with the Bracket to Motor mounting holes and reinstall the previously removed Motor Mounting Screws (**FIG 10**).
3. The bead roller is now motorized and ready for use.







## MAINTENANCE

- Keep the bead roller with mounted Motor Drive System in a clean and dry environment. DO NOT store it in or expose it to a damp or wet environment.
- Check all mounting hardware for tightness and all components for signs of fatigue or other damage before each use.

## ADDITIONAL ITEMS

- #11797 Eastwood Throatless Bench Shear
- #20198 Eastwood 8" Straight Shear
- #14042 Eastwood Versa-Bend Sheet Metal Brake
- #20257 Eastwood Sheet Metal Layout Kit – 5 Piece Set

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**If you have any questions about the use of this product, please contact**

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: [techelp@eastwood.com](mailto:techelp@eastwood.com)

PDF version of this manual is available at [eastwood.com](http://eastwood.com)

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