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Item #74126

# **RAPIDFORM 16GA. SHRINKER STRETCHER WITH STAND**

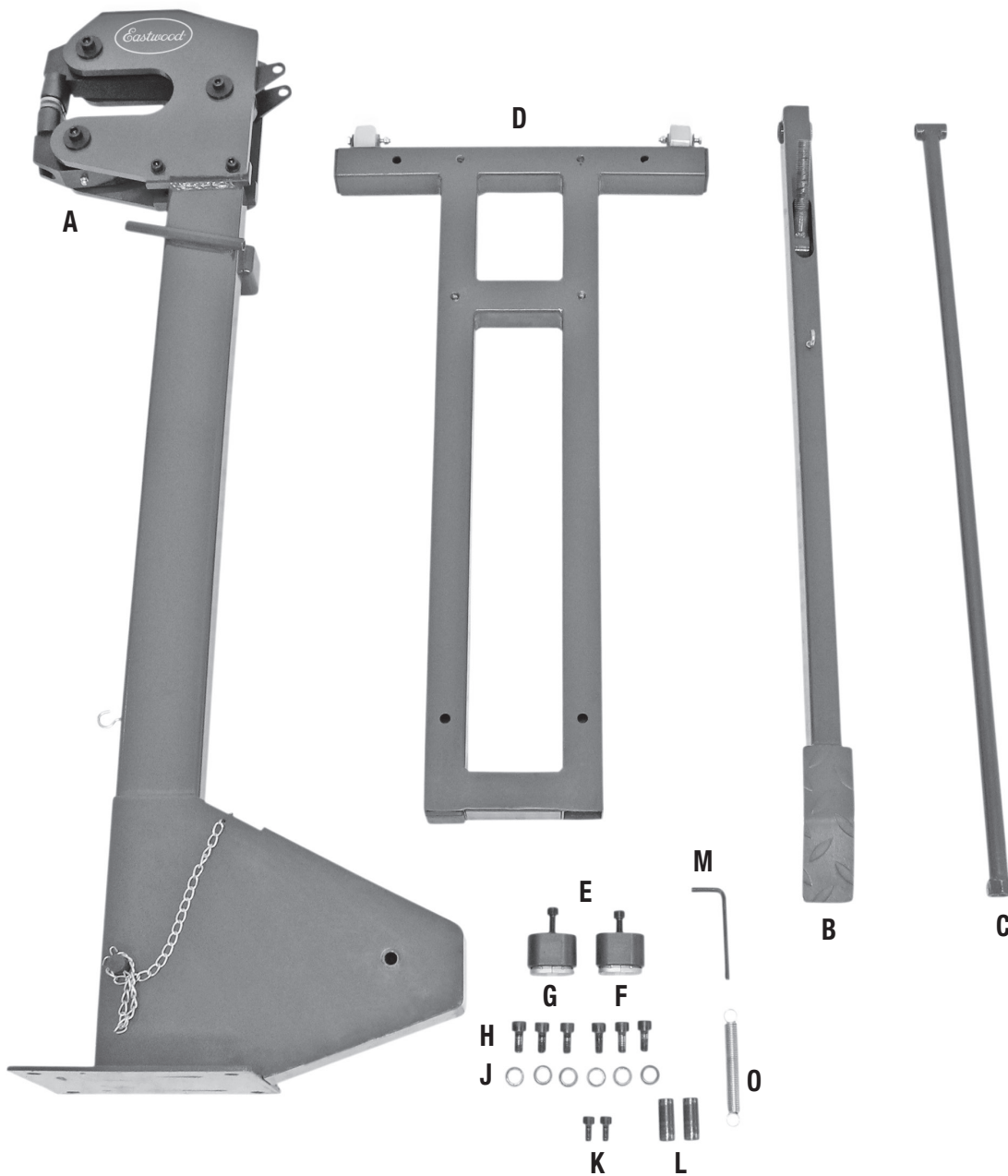
## **ASSEMBLY & OPERATING INSTRUCTIONS**



The **EASTWOOD RAPIDFORM 16GA. SHRINKER STRETCHER WITH STAND** is a heavy-duty sheet metal forming tool for the serious hobbyist or professional fabricator. The included stand and foot pedal mechanism provide stability and leverage for rapid shrinking and stretching. Mild steel up to 0.059" thick can be shrunk down to a minimum 1" radius. Create perfect fender lips, dog legs, headlamp flanges, body braces and more. The oversized 6" throat depth enables you to create larger automotive panels faster and more efficiently.

## INCLUDES

- (1) Shrinker/Stretcher Assembly (Shrinker Jaw Set installed) **[A]**
- (1) Foot Lever **[B]**
- (1) Foot Lever Link **[C]**
- (1) Base **[D]**
- (1) Stretcher Jaw Set **[E]**
- (2) M10x16 Socket Head Cap Screws **[F]**
- (4) M10x20 Socket Head Cap Screws **[G]**
- (6) M10 Washers **[H]**
- (2) M8x16 Socket Head Cap Screws **[J]**
- (1) Small Pin **[K]**
- (1) Large Pin **[L]**
- (1) 6mm Hex Key **[M]**
- (1) Oiler Bottle **[N]**
- (1) Spring **[O]**



# SPECIFICATIONS

Throat Depth:	6" (152mm)
Max. Material Thickness, Mild Carbon Steel:	0.059" (1.5mm)
Max. Material Thickness, Aluminum:	0.063" (1.6mm)
Max. Material Thickness, Stainless Steel:	0.031" (0.8mm)
Min. Shrinking Radius, Mild Carbon Steel:	1" (25.4mm)
Overall Assembled Dimensions (L x W x H):	36.22" x 16.14" x 46.26"
Overall Assembled Weight:	83.8 lbs.

# 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

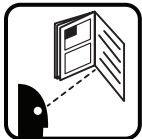
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

## 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 this manual before using.
- Save for future reference.



### WARNING INJURY HAZARD!

- This tool has leveraged components that generate amplified crushing and bending forces which can quickly cause severe injury! Keep fingers and hands away from moving parts when operating.
- Tremendous torque loads are placed on this Shrinker Stretcher during operation. This tool cannot be operated without adequate support or severe personal injury or property damage can occur if it should suddenly become dislodged or moves while in use. Before beginning ANY work with this tool, it is absolutely necessary that it be securely bolted to a solid work surface or mounted to the included Base.
- Strenuous physical force may need to be applied to the Shrinker Stretcher during use. Failure to ensure proper footing can quickly result in a fall which could inflict serious personal injury or property damage. Always work in a clean, uncluttered environment.
- Be sure there is sufficient working room around the tool to allow for safe handling of various lengths of material.
- The Shrinker Stretcher is equipped with a foot lever of the proper length to provide adequate bending force. DO NOT add pipe, bars or any other devices which would add additional length to the lever to increase bending force. This will exceed the design limits of the tool and can result in serious injury and/or component failure.



### CAUTION CUT HAZARD!

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



**⚠ CAUTION EYE INJURY HAZARD!**

- Pieces of mill scale, rust and other debris may be ejected from the workpiece during operation. Wear ANSI approved eye protection while operating.



**⚠ CAUTION INJURY HAZARD!**

- The Shrinker Stretcher consists of heavy metal components which can present a hand/finger pinch hazard and cause potentially serious injuries if dropped on feet. Avoid pinching hands while handling parts during assembly and wear thick, well-fitting work gloves to prevent cuts from handling sharp metal. The use of safety shoes is strongly recommended.

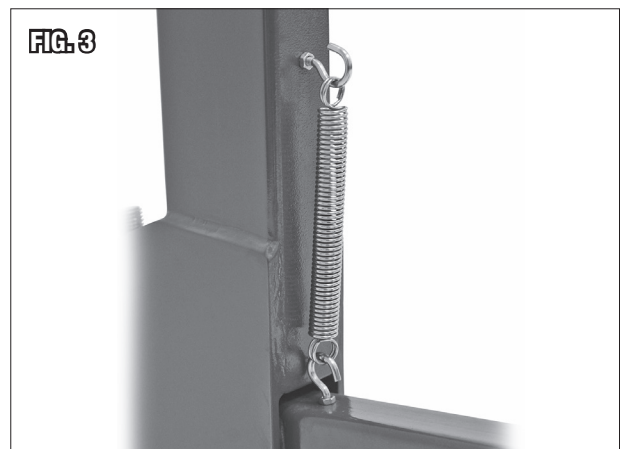
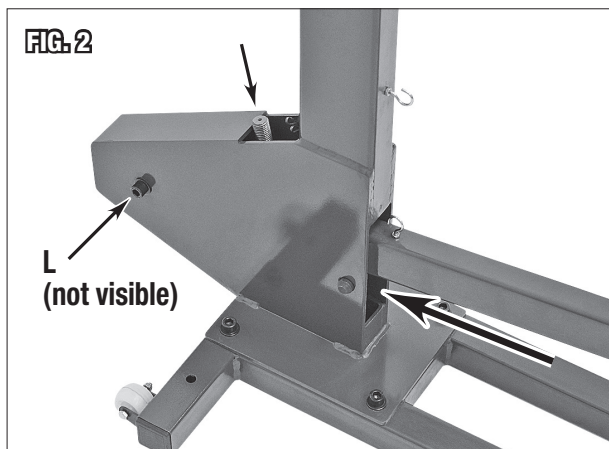
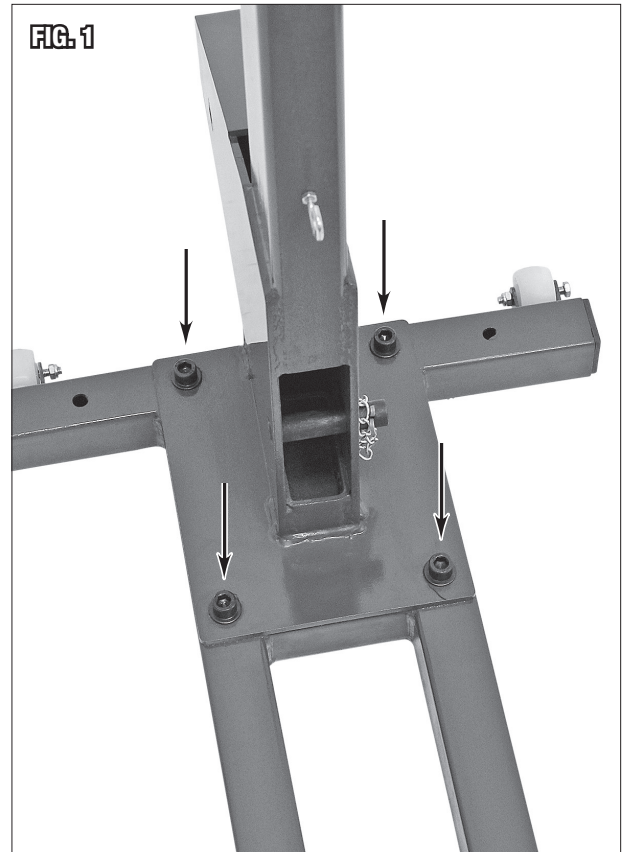


**⚠ NOTICE**

- **DO NOT** operate the jaws without a workpiece in between them. This will damage the jaws.
- Excessive resistance while operating could indicate a defect with the workpiece material or broken or damaged Shrinker Stretcher components. To avoid injury, stop work immediately and inspect workpiece material for nicks, dents, welds, excessive scale or remaining coatings. Clean or repair as necessary or discard and begin with a new piece. Also inspect Shrinker Stretcher components for looseness or damage.

## ASSEMBLY

- Rest the Shrinker/Stretcher Assembly [A] on the Base [D] and fasten it with the M10x20 Socket Head Cap Screws [G] and M10 Washers [H] (FIG 1).  
**NOTE:** Optionally, you may install the Shrinker Stretcher to a strong and level floor, preferably concrete, suitable for floor anchoring. Utilize four 3/8" (M10) Bolts to anchor it via the mounting holes.
- Install the Foot Lever [B] to the assembly with the Large Pin [L] slipped in place. Grease the pin before installation, then insert lever into the assembly. Make sure the linkage screw is pointing upward, out at the rear of the unit (FIG 2). Locate and secure the axle with the M10x16 Socket Head Cap Screws [F] and M10 Washers [H].
- Connect the Spring [O] to main upright and the foot lever (FIG 3).

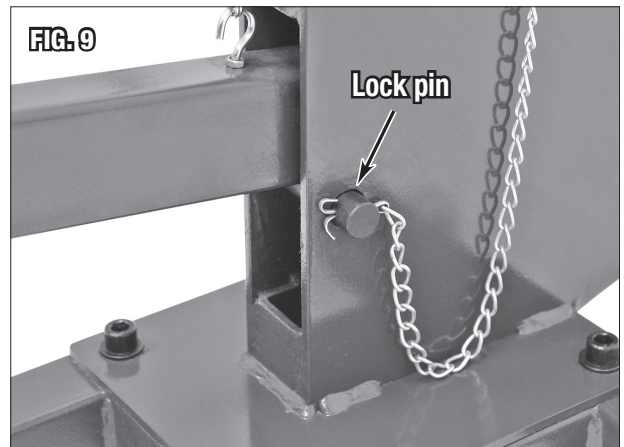
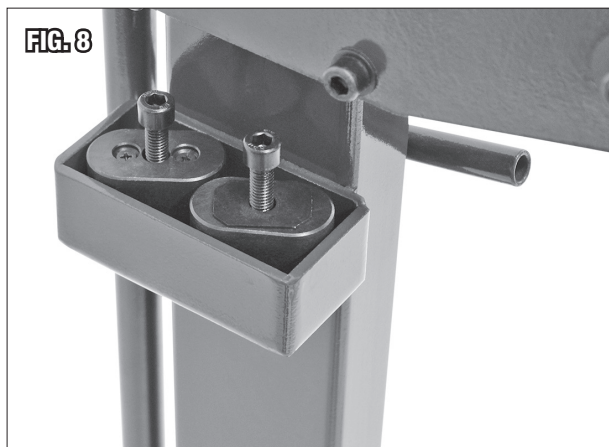
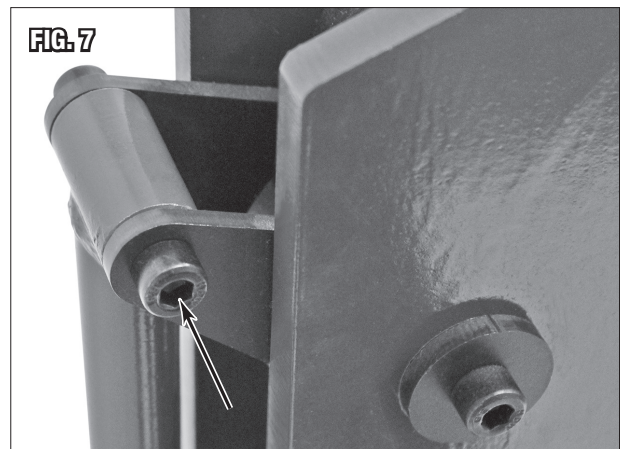
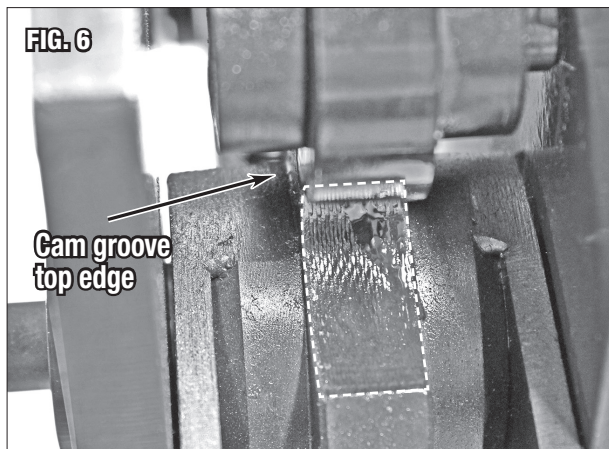
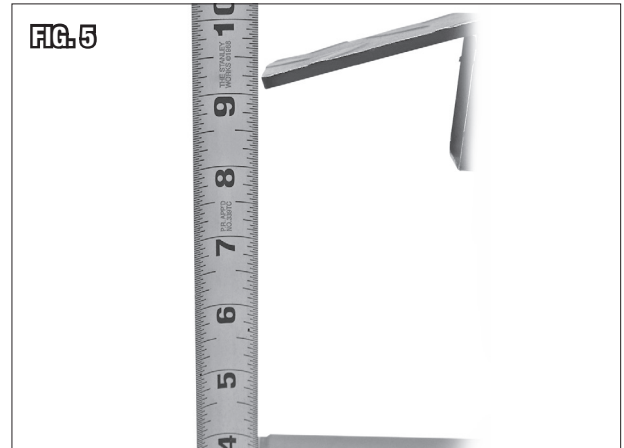
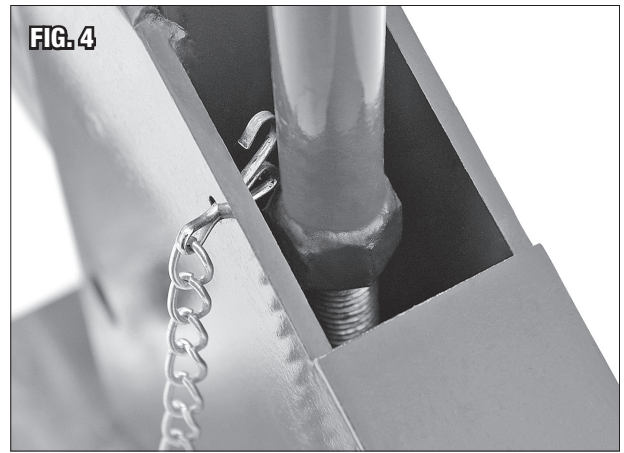


- Thread the Foot Lever Link [C] onto the linkage screw and (FIG 4) adjust the height such that when installed the height of the foot pedal is approximately 9" from the floor (FIG 5).

**NOTE:** This height is somewhat subjective depending on user preference and material thickness. Threading the link shorter (clockwise) will result in more travel of the jaws and therefore more material moved, but if adjusted too far the mechanism will cam out before bottoming out (FIG 6). It also could move too much material at once and cause excessive distortion in the workpiece.

Threading the link out too far (counterclockwise) will result in too little travel and make the shrink/stretch process much slower.

- Once satisfactorily adjusted, grease and install the Small Pin [K] with the M8x16 Socket Head Cap Screws [J] (FIG 7).
- Store the unused Jaw Set in the tray (FIG 8). When not in use, install the foot lever lock pin to reduce accidental injury risk (FIG 9).



# OPERATION

## CHANGING JAWS

- The shrinker jaw set is preinstalled from the factory. To swap jaws, loosen the screws at the top/bottom of the jaws. Remove the jaws (**FIG 10**).
- Install the other set and retighten the screws. Never mismatch the shrink/stretch jaws. There is some adjustment to the jaw position for user preference, but generally it is recommended to bottom them out and tighten securely in place.

**NOTE:** The shrinker jaws are offset and can be used with the offset jaws aligned or flipped (**FIG 11**). When aligned, the jaws shrink material faster, but they may distort the material unevenly. When flipped, they will shrink less but the result is a more uniform shrink.

## FORMING METAL

### **⚠ WARNING** INJURY HAZARD!

- This tool has leveraged components that generate amplified crushing and bending forces which can quickly cause severe injury! Keep fingers and hands away from moving parts when operating.
- Strenuous physical force may need to be applied to the Shrinker Stretcher during use. Failure to ensure proper footing can quickly result in a fall which could inflict serious personal injury or property damage. Always work in a clean, uncluttered environment.

### **⚠ CAUTION** CUT HAZARD!

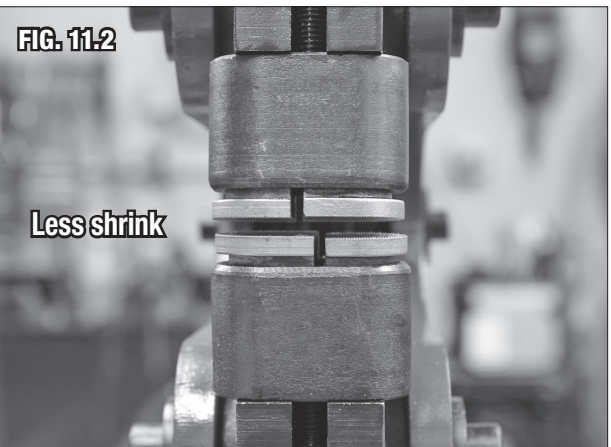
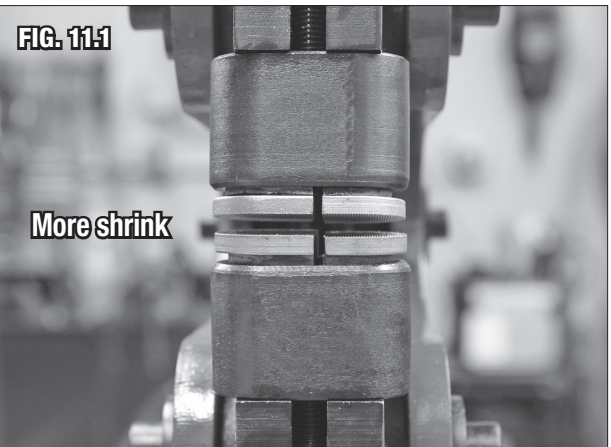
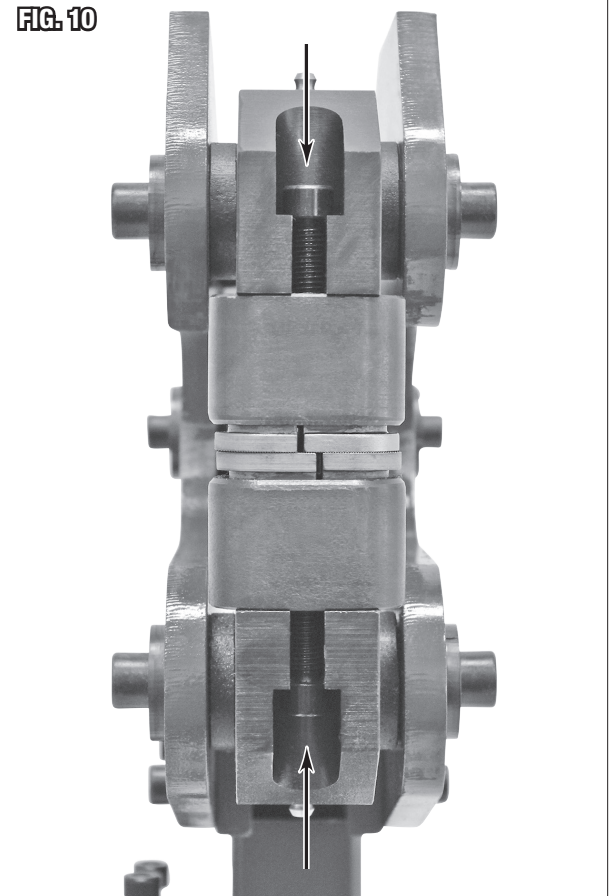
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### **⚠ CAUTION** EYE INJURY HAZARD!

- Pieces of mill scale, rust and other debris may be ejected from the workpiece during operation. Wear ANSI approved eye protection while operating.

### **⚠ NOTICE**

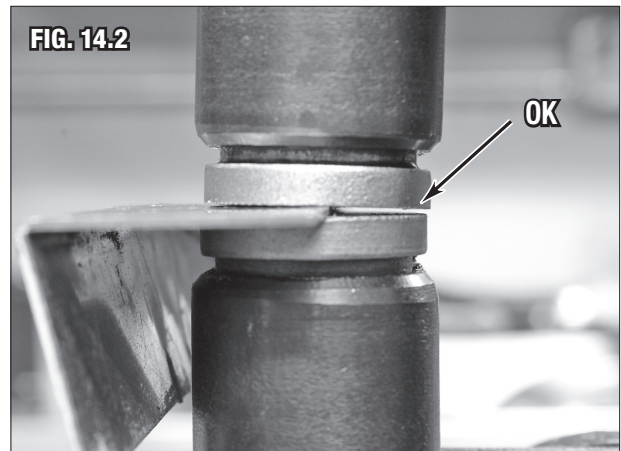
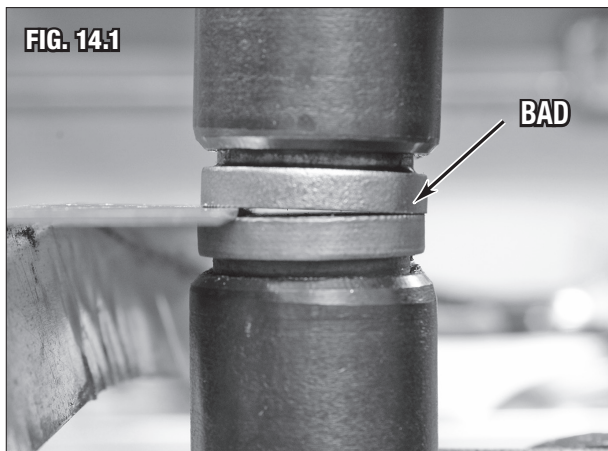
DO NOT operate the jaws without a workpiece in between them. This will damage the jaws.



- Before fabricating with the Shrinker Stretcher, pre-bend the metal to be formed to a 90° angle along its length on a sheet metal brake, creating a maximum flange depth that is no greater than 7" (FIG 12).
  - Make a template of the piece to be formed out of medium bodied cardboard or manila folder material. Tracing the outline of the piece you want to form is critical to achieving a good fit with minimal filler use.
  - Work the leading edge of the metal piece first. This “breaks down” the maximum resistance and permits easy and accurate working thereafter (FIG 13). With an even curve the leading edge will need to bend the most, and base of the flange will bend the least.
- NOTE:** Insert the edge about halfway into the jaws when doing this. Less than halfway may result in the jaws deflecting and grinding against each other on the backside (FIG 14). This will cause damage to the jaw teeth.
- Always work the piece a little at a time moving the piece through the Jaws along its entire planned length so that each area is exposed to the Jaws numerous times rather than trying to shrink or stretch “all in one bite” (FIG 15).

**▲ NOTICE**

For best results and maximum edge forming power, insert metal only halfway into the Jaws.



- The “bunching” or “pocketing” that typically occurs when shrinking can be quickly hammered out, smoothed by inserting the metal deeper into the jaws, or with an english wheel.
- Maximum control is achieved with the pressure exerted on the foot lever and number of strokes used while forming the metal. Move the metal back and forth along its length until the desired radius is obtained (**FIG 16**).  
**NOTE:** The Shrinker and the Stretcher Jaws are “serrated” to allow them to grip and “push” or “pull” the metal. These teeth leave slight markings which, depending on the hardness of the metal, can be removed with an abrasive cloth or wheel, or english wheel.
- At this point, the basic operating instructions have been described and practice using the Shrinker Stretcher on scrap material is highly recommended. As with many metal working tools, a period of “trial and error” is needed to achieve a degree of proficiency in their use. Remember, a little time and material wasted at this step will avoid disappointing results on an actual project.



## MAINTENANCE

- Clean dirt and debris from jaw’s teeth. Brushing with a brass or stainless-steel wire brush is highly recommended.  
**NOTE:** Forming aluminum will quickly cause a buildup of aluminum in the jaw teeth. They must be cleaned with a wire brush periodically when working with aluminum.
- Check tightness of all hardware.
- Check operation for binding. Lubricate sliding parts and pivot points periodically with medium bodied oil.  
**NOTE:** Avoid getting oil on the jaw’s teeth. This will reduce their effectiveness.

## ADDITIONAL ITEMS

### R&D MUST-HAVE ACCESSORIES



**#54830**  
Eastwood Elite  
Mini English Wheel



**#67517**  
Eastwood 52”  
Stomp Shear



**#20665**  
Eastwood 24” Box and Pan  
Sheet Metal Brake

### REPLACEMENT ITEMS

- #74125** Shrinker Jaw Set
- #74124** Stretcher Jaw Set

Visit [eastwood.com](http://eastwood.com) for complete info and pricing.

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

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

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

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