

~ FABRICATION ~



METALWORK

OPERATING INSTRUCTIONS



METALWORK

INTRODUCING

the



EDGING ROLLER / BEAD ROLLER



Access Level 1 (see Metal Workshop induction Guide on Access Levels)

Used to roll edges of metal or add patterns to flat surfaces using a clamping die roller mechanism
Rolls sheet metal up to a thickness of 1mm (Steel)

PPE Basic

- Work coat or overalls (provided)
- Leather gloves (provided)
- Stout footwear – steel toe cage preferred

What to do before use

- **VISUAL CHECK** of the rollers/folder for signs of damage
- **IF STUDENT**, report any faults to any member of workshop academic/technical staff
- **IF STAFF**, log in the Fault Reporting Log Book by machine – then email technical team to report if machine requires maintenance or servicing and whether it will be out of operation and for how long
- **AREA AROUND** the rollers/folder is clear and tidy and free from obstructions?
- **ADEQUATE** overhead/machine lighting?

How to Use This Edging Folder / Bead Roller machine

- **ENSURE** the die-punching screw is **LOCKED BEFORE** adding dies and putting fingers under the die stocks
- **SELECT** an appropriate set of upper and lower dies for the application. Technical staff can advise on which set is best
- Dies **DO NOT** have to match; different effects can be created by mixing the upper and lower die

- **CAREFULLY** slide the die into the upper and lower die stock vice
- **MARK** your metal with the path that you wish to follow, do not use a scribe as this will spoil the metal surface. Use a **MARKER PEN** or a **CHINAGRAPH** tile marking pencil
- Some dies effects require the upper and lower die set to be **IN-LINE**, others require a slight **OFFSET**. Adjust these die locations **NOW**
- Place the sheet **CAREFULLY** between the two die
- **TIGHTEN** the clamp so that the metal is being lightly bent, until the desired effect is being achieved – use a test piece before working on your project stock
- Turn the roller handle **SLOWLY**, taking care to follow your **MARK**
- Once an **INITIAL PATH** has been completed, subsequently retraced rolls becomes easier
- Increasing the **ROLLING PRESSURE** after each run will **INCREASE** the effect of the dies
- **TO HELP** form nicely rolled edges - after forming 90 degrees of a roll - a piece of wire can be added and the roll finished off with a planishing hammer and stake on an anvil, setting block or vice
- Once you have finished your work, **LOCK** the die-punching screw in the raised position and remove the upper and lower dies carefully and return them back to the die holder block

Date

I verify that I have read and understood the information detailed within this document

Name

Signature