

Instructions for using the Useful Tools 3-IN-ONE Hand Beading Tool.

1) Using the handle:

- **Clamp the beading tool in a vice.**
- **Attach the handle onto the hex end of the shaft and make sure the handle can be turned freely.**
- **Prepare pipe end to be swaged by squaring it off and de-burring.**
- **Apply a small drop of grease or oil to the tube/rollers.**
- **Release the adjusting knob and slide the tube end over the small spindle until it touches the tool body buffer plate.**
- **Turn the adjusting knob until the tube is lightly gripped between the rollers.**
- **Holding the tube lightly against the tool body, turn the handle until the tube has rotated at least one turn.**
(Note: It may pay to wear a pair of industrial gloves to avoid chaffing the hand holding the pipe if lots of beads are to be formed.)
- **Turn the adjusting knob down slightly – say 1/4 turn or so.**
- **Still holding the tube lightly against the tool body, turn the handle again until the tube has rotated at least one turn.**
- **Repeat until the bead has started to form.**
At this point, the tube should have formed enough of a 'track' to hold itself in position on the rollers.
- **Carry on turning the main crank - turning the adjusting knob 1/8 to 1/4 turn per turn of the crank - until you have formed a satisfactory bead.**
- **Release the adjusting knob to allow the tube to be removed from the tool rollers.**
- **Clean oil/grease from the tube end and dress with wire wool or lap mop material to burnish end.**
- **Finally, check the appearance of the bead formed. If you see stress/crack marks, check with your material supplier on the specification of material they supplied.**
Alternatively the tube may need annealing.

2) Using a drill:

- **Clamp the beading tool in a vice.**
- **Put a drill chuck onto the hex end of the shaft instead of the handle**
- **Follow the instructions in (1) above carefully.**

P.T.Q. for more →

3) Rolling the beading tool around the pipe to form a bead:

- Do ***not*** attach the handle or a drill.
- Clamp/hold the tube firmly.
- Prepare pipe end to be swaged by squaring it off and de-burring.
- Apply a drop of grease or oil to the tube/rollers.
- Release the adjusting knob and slide the beading tool over the tube end until it touches the tool body.
- Turn the adjusting knob until the tube is very lightly gripped between the rollers.
- Holding the beading tool lightly against the tube, rotate it around the tube circumference 1-2 times.
- Turn adjusting knob down very slightly – say 1/8 turn or so.
- Still pressing the beading tool lightly against the tube, slide the beading tool around the tube circumference 1-2 times
- Repeat until the bead has started to form.
At this point, the tube should have formed enough of a 'track' to hold itself in position on the rollers.
- Carry on sliding the beading tool around the tube - and turning the adjusting knob - until you have formed a satisfactory bead.
- Release adjusting knob to allow beading tool to be removed from the tube.
- If during the process you feel the tool "stall" against the tube ease the pressure on the adjuster slightly and rotate the tool as normal

To remove and re fit main shaft.

At the base of the bead tool there is a hole and deep inside this hole there is an M8 grub screw (for standard machine) and M10 for Bead ST machine.

Back the grub screw off 4-5 turns and main shaft will release.

To re assemble coat shaft with a thin layer of grease and slip into approximate position.

Gently screw the grub screw down until the pin in the end on the grub screw engages with the slot in the main shaft then turn the screw fully down and back of say ½ turn.

As you back the screw off you will notice the shaft "shuttlecocks" slightly. This is to allow you to centre the main shaft bead exactly on the centre line of the roller grooves and to avoid the grub screw becoming loose put a drop of Loctite thread loc on the thread.



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