

BEAD FORM BOSS INSTRUCTIONS

Step 1: Fit the rollers

The Bead Form Boss rollers will fit both the Pexto 622 and Tennsmith R22 Rotary machines. The female roll should be mounted to the top shaft. Two male rolls are included, either of which can be used on the bottom shaft. The smallest male roller will allow tubing as small as 1.5" OD to be rolled, however will not allow for a deep bead. The larger of the two rolls will handle tubing sizes larger than 2" OD, and will allow the tubing to be slid over the lower shaft for deep beading or multiple bead applications. An included cap should be used to protect the lower shaft from damage (see photo). Each configuration of rolls is designed for a maximum of .065 wall (1.65mm) material. Always use soft or annealed tubing, never hardened tubing.

(Occasionally, a small interference between the roll set and the factory-installed alignment pin(s) may occur due to inconsistencies in pin height from the manufacturer. If this is the case, carefully file the roll pin(s) to allow for adequate clearance.)

Step 2: Check the alignment of the rolls

If the male portion of the bead does not fit in the center of the female top roller, adjust the alignment of the top and bottom shafts. Both the Tennsmith and Pexto units allow the shafts to be moved "forward" or "backward" to align the roll sets.

Step 3: Preparation prior to forming tube

Your tubing should be cut off square and the edge should be chamfered. It is highly recommended to remove the inner weld seam if one exists, either by using a file, grinder, lathe etc. Next, lubricate both rolls with Bead Form Lube. Standard engine oil is also an acceptable lube for this tool. Please follow manufacturer's recommended lubrication procedures to lube the rotary machine.

Step 4: Forming the bead

Insert the tube to the desired depth and lower the top roller using the top handle. Once the top roller lightly pinches the tubing to the lower roller, increase pressure by 1/8 turn, and roll the material through 2 to 3 times using the hand crank. Proceed in this matter, by turning the top handle 1/8 of a turn at a time and rotating the material through by turning the hand crank.

Step 5: Inspection

When finished forming the bead, remove the tube section by raising the the top roller via the top handle, wipe off excess lube, and inspect the inner and outer tube. Caution: It is possible to fracture or cut the tubing in the weld area or through the bead. If you see such cracking, consider using a softer material.

