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INSTRUCTIONS AND MAINTENANCE FOR 22B WHEELING MACHINE

IMPORTANT: The tension adjuster is capable of producing in excess of 1,000 pounds of pressure. This is far more than you will ever require. GO EASY! Too much pressure can permanently distort the frame, or bend the axle in the top wheel. Very little pressure is required for the work for which this machine is intended.

SET UP AND USE: Install the upper wheel on the axle. Assembly order from frame side of axle is: 1.00" Dia. washer, upper wheel, 1.00" Dia. washer, 3/4" Dia. washer, then the 3/4-10 self locking nut. Tighten nut to the point that the wheel spins freely with no side movement. Install hand wheel on shaft at bottom of screw lift and tighten set screw. Slide anvil wheel axle into anvil wheel and place in the axle couches of the anvil yoke. If required, (For wide track anvil wheel) true anvil with upper wheel with the adjustment screws. Periodically remove the axle and grease these bearings using wheel bearing grease. You are now ready to mount the machine at a comfortable height, bolt it securely to a bench, stand, or clamp in a vise.

METAL PREPARATION: The capacity of this machine is 16 gauge mild steel. Whenever possible, use a low carbon, aluminum or silicon killed, drawing quality steel such as 1015 AKDQ. This type of steel is specially made for deep drawing and stretching. The time and money spent finding a local source for this material is worthwhile. Clean your metal carefully, removing all rust, paint, metal chips, dirt, and grit. Remove all burrs and sharp edges from the metal sheet. Tiny bits of grit left on the metal can damage your panel and the Wheels! If the machine will not be in service for a long time, a light coat of oil on the wheels will prevent rusting.

SAFETY: Gloves should be worn when operating the machine. Be careful not to pinch your fingers between the wheels when tracking the metal.

POINTERS ON USE: Remember, "Practice makes perfect". Start with a sample piece of metal the same gauge and alloy that you will be making your panels from. Place the metal between the wheels and adjust the tension so you can easily move the metal back and forth with only a slight amount of pressure on the metal, this is called tracking. Your technique of tracking across the metal is far more important than having lots of pressure on the wheels. Use very light pressure when you are learning technique. The simplest tracking pattern is like mowing a lawn: you start at one corner, work very evenly across the panel, keeping your tracks closely spaced. Once you have developed some skill in tracking, you can experiment with a little more pressure. Remember, the machine is designed to work with light to moderate pressure, and too much pressure will do more harm than good. As you are shaping the panel, you should frequently check it against a pattern, form, buck or part you are shaping it to match. To retain the pressure setting, gently roll metal from between the wheels, make your check, then grasp the upper wheel and roll it toward you as you enter the piece between the wheels. Don't be easily discouraged! It will take time and patience to build your skill with this tool.

RECOMMENDED READING: [Metal Fabricators Handbook](#) and [Sheet Metal Handbook](#) by Ron & Sue Fournier.