

BEADING TOOL INSTRUCTIONS

Bill of material:

- 1 pc 1/2" x 1/2" steel square stock 6" long
- 1 pc 5/8" x 1/16" wall square steel tube 1-3/4" long
- 1 pc 3/4" x 1/16" wall round steel tube 3" long
- 1 pc 1/2" steel round approx 3" long
- 1 pc 3/4" steel round approx 3" long
- 1 pc 1/4" x 1" truss head machine screw
- 2 pc AN 364-428A nut
- 2 pc AN 960-4 thin washer
- 2 pc AN 4-14A or longer bolt (cut to 1-5/16" long)
- 1 pc 1/4" socket head cap screw with approx 1/2" of grip length (cut to 1")

- Drill and tap the frame as required.
- Round off the corners of the outside end of the frame to allow handle to slide freely over the frame. (Only remove material from the outer 3".)
- Dress the frame and slide to allow for free movement but minimal play.
- Remove 11/16" of wall from one end of the slide. (This allows the outside rollers to lay tight against the frame.)
- Cut studs, position and weld to slide. (It is **critical** that the studs be welded square to the frame and each other.)
- Weld the truss head machine screw to the end of the handle.
- Machine the rollers. (For this operation, grind a 1/8" wide round nose tool bit. Machine the bead and grooves in the exact center of the rollers and do not exceed .045" for the height/depth of the cuts.)
- Assemble such that all parts move freely but have minimum "play".
- For the "professional" finish, dip the handle in plastic coating material.

This tool is to be used on soft materials only. Do not try to bead material with wall thicknesses greater than 1/6". The material should have a square end and be held firmly against the frame when starting the bead. Do not try to squeeze out a really tall bead as this will swage the tubing out to a larger diameter.

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