



"General" Duct Bearer

Instruction Manual



Manual covers the following models:

Model 520 5FT 20GA General Duct Bearer

Model 516 5FT 16GA General Duct Bearer

EMPIRE MACHINERY & TOOLS
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Manufactured In Canada Exclusively for Empire Machinery & Tools Ltd.

DUCT BEADER SAFETY RULES

The Duct Beader should be DISCONNECTED from power source before servicing.

Never place any part of the body including loose clothing near or onto the rotating rolls. (KEEP HANDS AWAY). Failure to follow this procedure will lead to personal body injury.

Never clean forming rolls while they are rotating.

Do not exceed specified material capacity of the machine.

Machine must be operated by authorized personal who have been trained in regards to working and safety features of the machine.

Please read and understand the Operators Manual.

Never operate machine with any guards removed.

Do not use machine if service is required.

Use safety glasses and required protective equipment.

Keep work areas clean and in proper order.

Operating Instructions For “General” 5’ Duct Beader

- ✚ Machine is wired 110 volt single phase. Plug into any standard 110 volt receptacle. (To wire 220 volt single phase consult motor cover for wiring instructions)
- ✚ Turn machine on and feed material against either left or right hand stainless steel gauge bars. Standard SMACNA measurements state that beads should be placed on 12” centers meaning the first bead will be 6” from the end of the duct and 12” thereafter.
- ✚ To adjust spacing of collars top cover must be removed. The bead collars are held in place by (2) setscrews located on either side of the male and female bead. Loosen the setscrews for the upper and lower collars and adjust accordingly. To measure distance from gaugebar lay a straight edge against the bar and extend it through the upper and lower horizontal shafts. Measure from the outside of the gaugebar to the center of the bead roll to get exact bead spacing. Once you have located your required position then lock both upper and lower bead collars in place.
- ✚ Adjust bead depth using the adjustment wheel located on the right hand side of the beader.
- ✚ Check lubrication in gearbox every three months
- ✚ Grease bearings weekly using the two grease nipples located next to the electrical switch on the right hand side of the beader.

Enclosures:

1. Assembly Drawings
2. Copy of Leeson Electric Corp. installation, lubrication and maintenance instructions