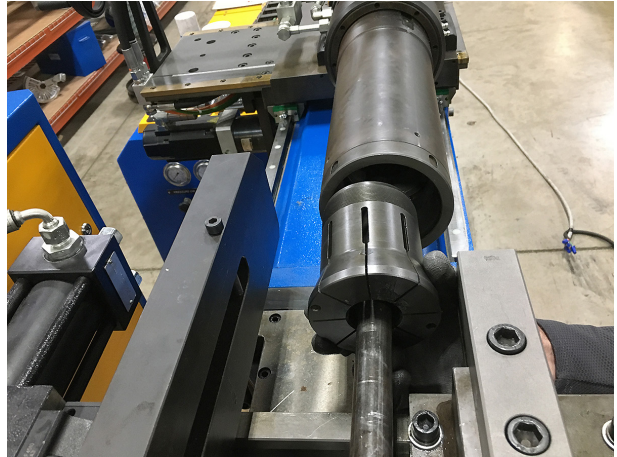
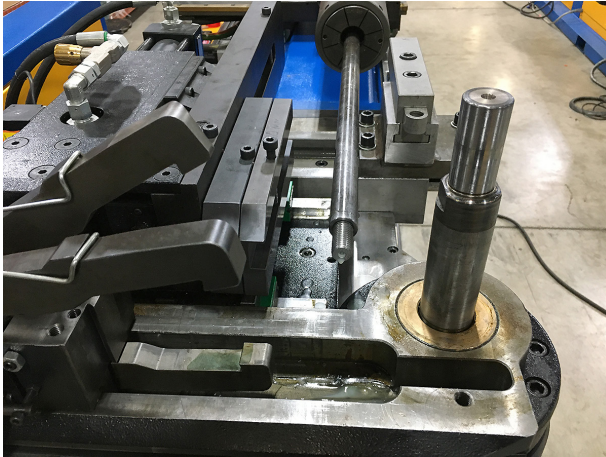




Tool Mounting Instructions EB76/EB65

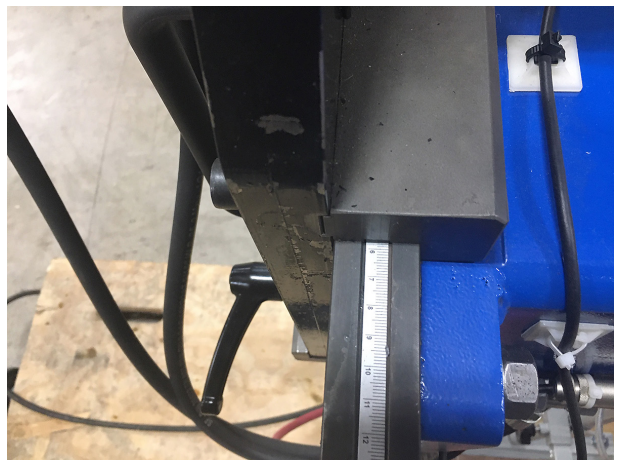
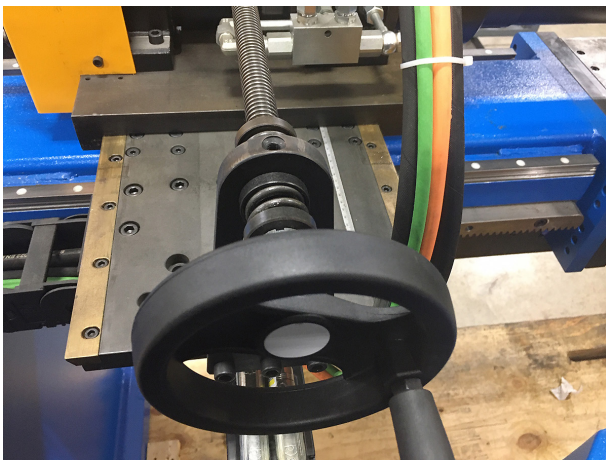
1. With all previous tooling removed, slide the collet over the draw bar and thread into the carriage.



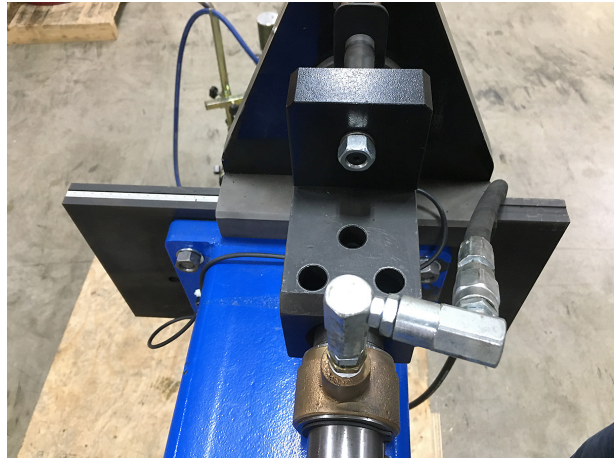
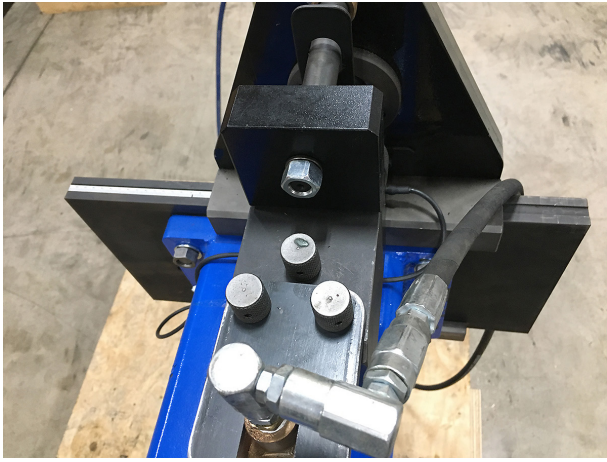
2. Tighten the collet with the spanner wrench provided. The EB65 utilizes a one-piece collet that threads into the nose of the carriage. The EB76 machine has an eight piece, segmented collet where each piece bolts into the carriage.



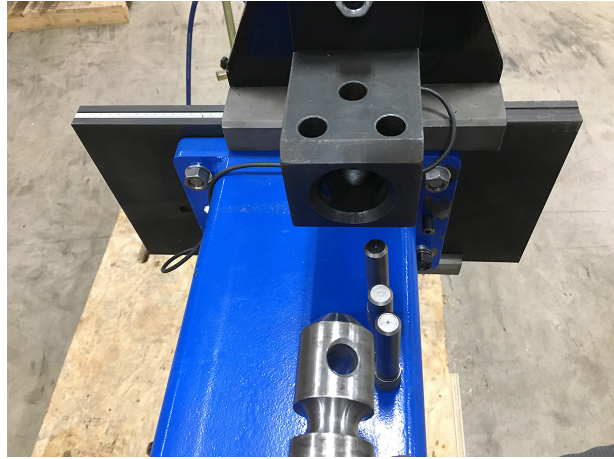
3. Adjust the centerline of the carriage and the tailstock to match the radius of the tooling.



4. Locate the draw bar retaining pins and remove.



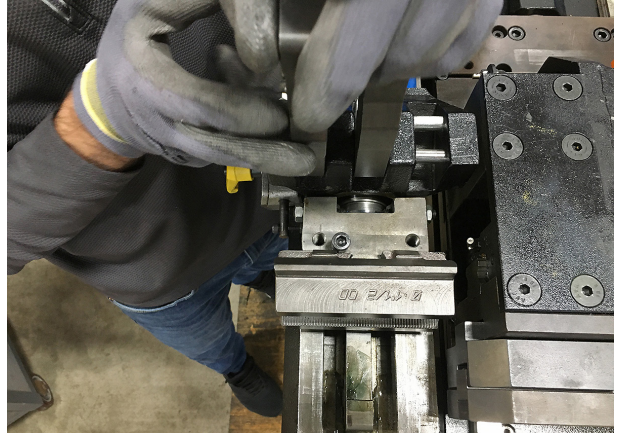
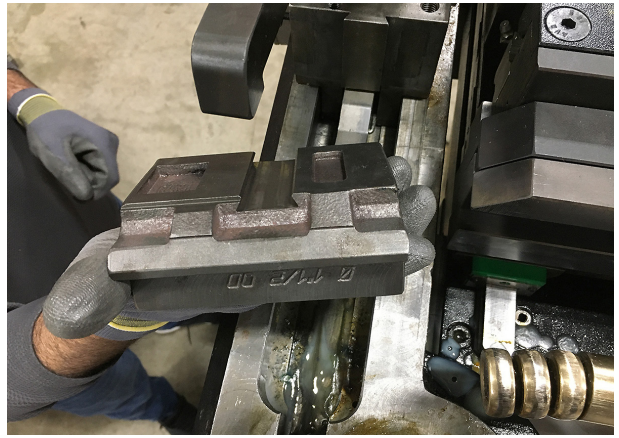
5. Slide the draw bar forward and extend the draw bar past the bending head of the machine.



6. Thread the mandrel onto the draw bar and securely tighten to the bar using the flats on the mandrel body and flats on the draw bar.



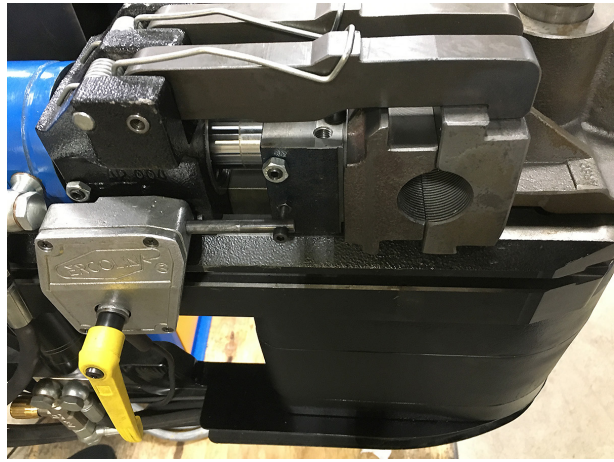
7. Slide the clamp die onto the clamp die cylinder with the dovetail mount. Always mount with the numbers facing up. Secure with screw provided.



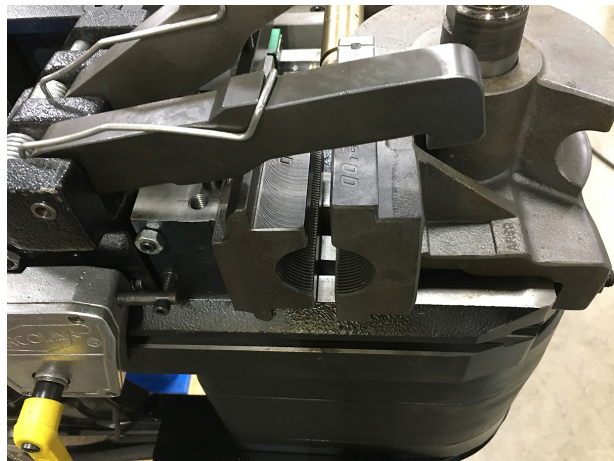
8. The center former slides over the main tooling shaft. Be sure to locate the former on the return screw as shown.



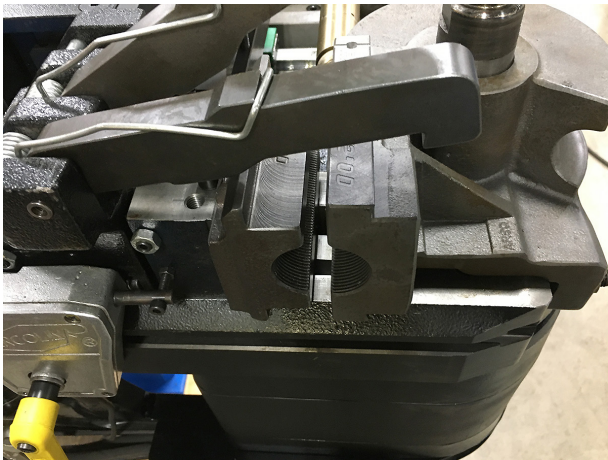
9. Loosen the handle of the clamp die switch box.



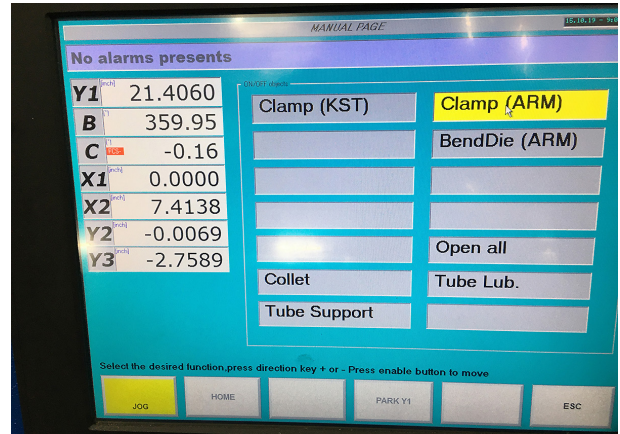
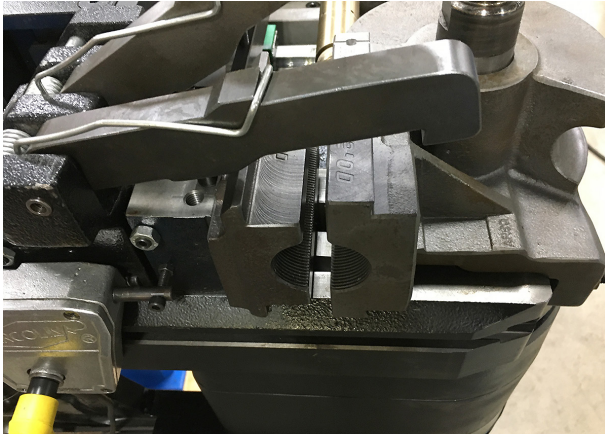
10. Lift the clamping fingers until the springs catch on the retaining notches and slide the entire clamp die cylinder forward until it is 3/16" away from the clamp face of the former.



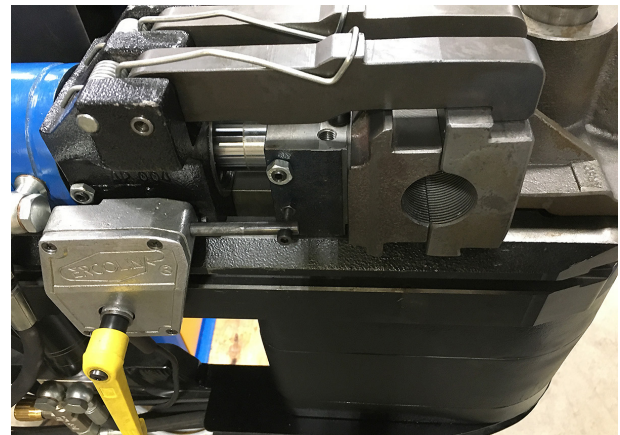
11. Ensure that the face of the clamp die and the face of the former are parallel. If not, adjust the former face using the jackscrew on the rear of the former. Tighten the jam nut when finished.



12. Release the springs on the clamping fingers. From the MANUAL page on the touch screen, double click CLAMP ARM.



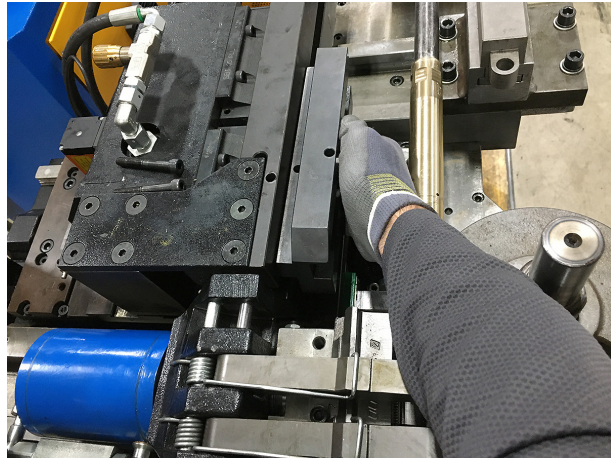
13. Press the "+" button on the handheld control, and then depress the center button half way down to close the clamp fingers.



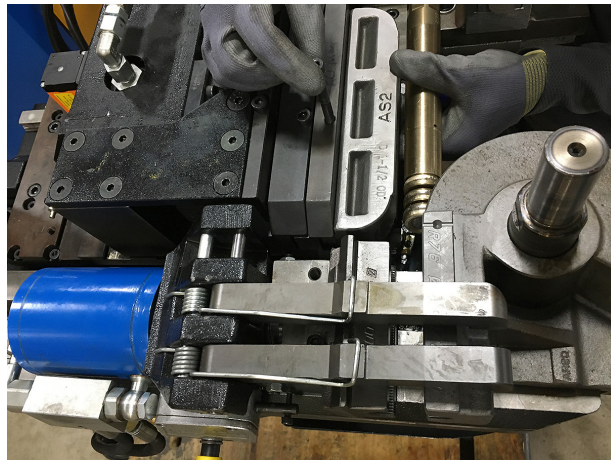
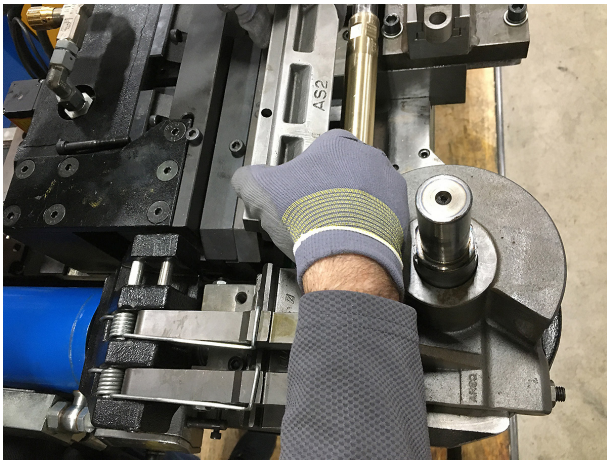
14. Push the clamp die cylinder switch box forward 3/16" and tighten the handle.



15. At this time, the clamp pressure may also be adjusted to suitable pressure according to material size. The clamping pressure should be adequate to hold the material without slippage and excessive marking.
16. The machine is shipped with two differing size spacer plates designed to allow the mounting bracket to sit further away from the carriage. This allows the carriage to pass closer to the main tooling shaft and minimize the last leg of the production piece. It is not necessary to use the spacers.



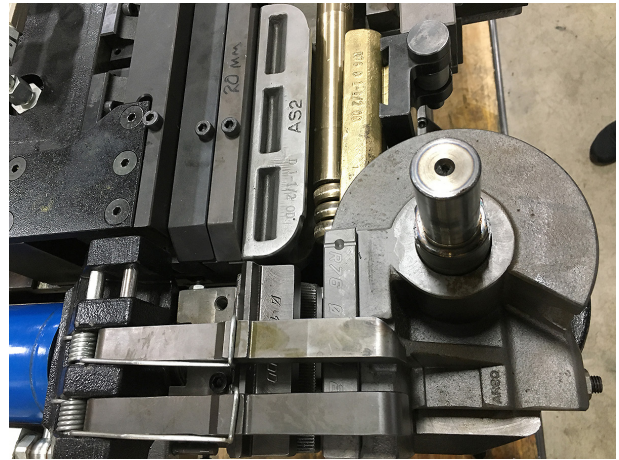
17. Place the pressure die in the mounting bracket and secure with the screw provided. Ensure the die is oriented correctly and the right side is even with the mounting bracket and not protruding into the clamp area.



18. Affix the wiper die mounting bracket to the back of the wiper die with the dovetail mount and secure with screw provided.



19. Mount the wiper die on the bracket and adjust to the former. The wiper die is size and radius specific. The wiper die should be parallel with the pressure die and the front tip will meet the tangent mark on the forming die. The radius of the wiper will be a smooth transition to the groove of the former and no daylight will be visible from the back when correctly positioned.



20. Replace the tie bar and tighten in position.

