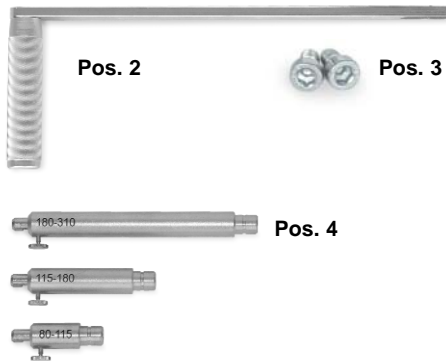


Spoke Thread Rolling Machine

Manual Instruction

A CONTENT

- Pos.1 Spoke thread rolling machine
- Pos.2 Crank
- Pos.3 Hexagon crank screws (2 pcs)
- Pos.4 Spoke guide, 3 different lengths



Pos. 1 Code: 720048



Image 1



Image 2



Image 3

B MACHINE INSTALLATION



1. NOTICE! The CYCLUS TOOLS spoke thread rolling machine must be safely fixed with M8 screws on a ground plate.
2. Put the crank (2) on the axle (image 1) and fix it with M5 hexagon screws (3).
3. NOTICE! The handle of the crank should be on the opposite side of the machine body (image 2)!
4. Insert the spoke guide (4) into the machine (image 3). You can choose between 3 different spoke guides, depending on the spoke length you want to work with.
5. The other 2 not needed spoke guides can be stored in the specified places in the machine ground plate.



C CUTTING AND ROLLING OF THE SPOKE



The machine is delivered with rolling die for 2 mm spoke diameter. It can be adjusted to 2,34 mm spoke diameter by replacing the rolling die (see section D). All spokes with length 80- 320 mm can be produced.



Working steps:



1. Install the spoke guide. Consider to choose the proper guide length.
2. Set up the length of the needed spoke on the scale and fix the screw.
3. Put the crank in starting position (image 3) and insert the spoke into the guide.
4. Rotate the crank in 180°. The spoke will be cut to the needed length and threaded in one working step.



NOTICE: to ensure a safe seating of the nipple, avoid rolling new thread on the old thread. For that, minimum spoke section having the old thread must be cut off.



D ROLLING DIE REPLACEMENT

1. Put the crank in starting position.
 2. Loosen the upper TX25 screw and extract the rolling die from machine body.
 3. Insert the new rolling die and fix with TX25 screw.
 4. Replace the lower rolling die in the same way as described above.
- NOTICE: rolling dies will be delivered in a pair, and have to be replaced as a pair only!

E IMPORTANT MAINTENANCE TIPS:



To avoid damage on the machine, please consider following tips:

1. DO NOT use any oil or grease for maintenance of the machine.
2. DO NOT use compressed air to remove metal chips remaining after the rolling. It is better to use a brush.