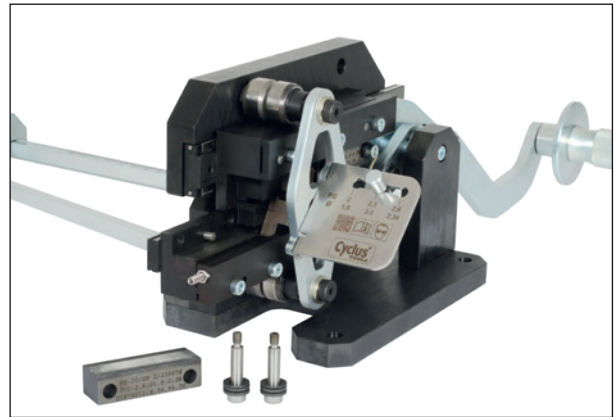
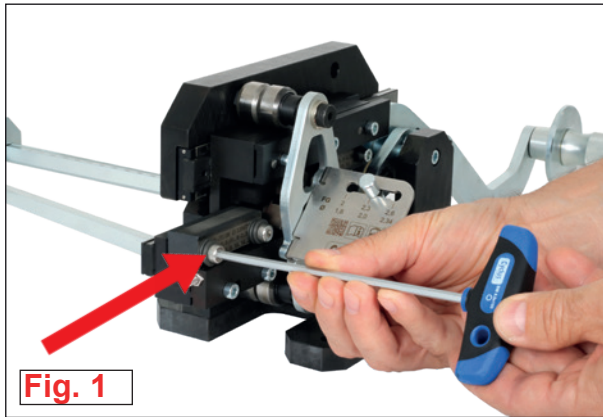
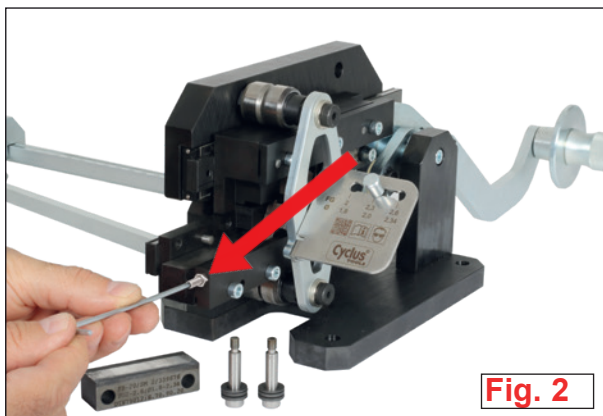


Removal and replacement of the rolling dies.

1. Put the handle back in starting position. Loosen and remove the 2 hexagon screws (HX 4) of the lower rolling die (fig. 1). Do not take the screws and spring washer apart! The order and direction of the cup springs is technically predetermined, see page 2. Remove the lower rolling die from the machine.



2. Loosen the locking nut (hexagonal 8mm) by turning counter-clockwise, and allow the wedge to come down (fig.2). The wedge will now protrude approx. 7 mm from the initial position.

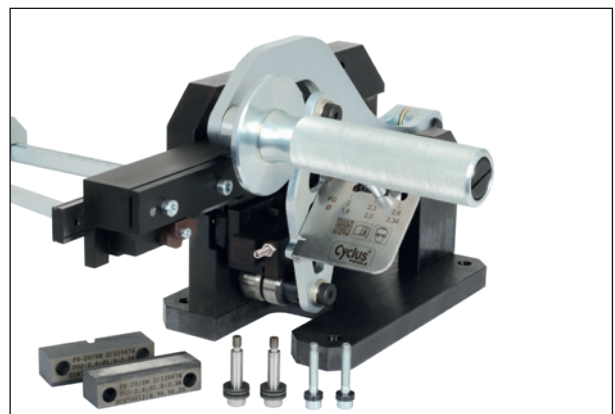
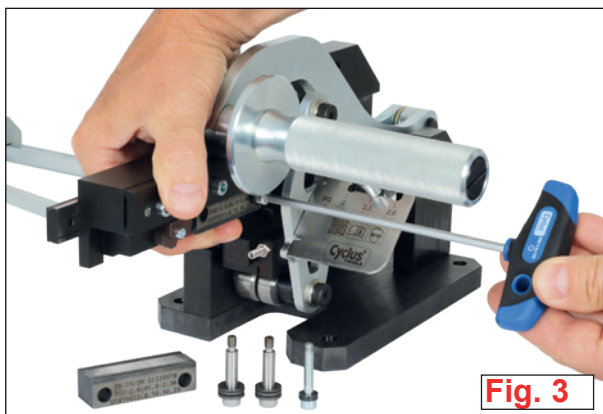


scan the QR code and get informations, manuals and tutorials about the product.



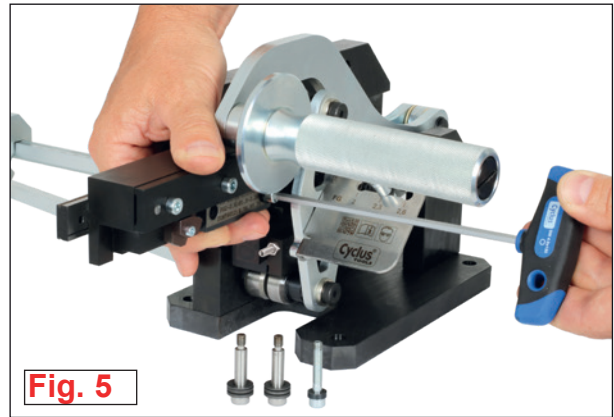
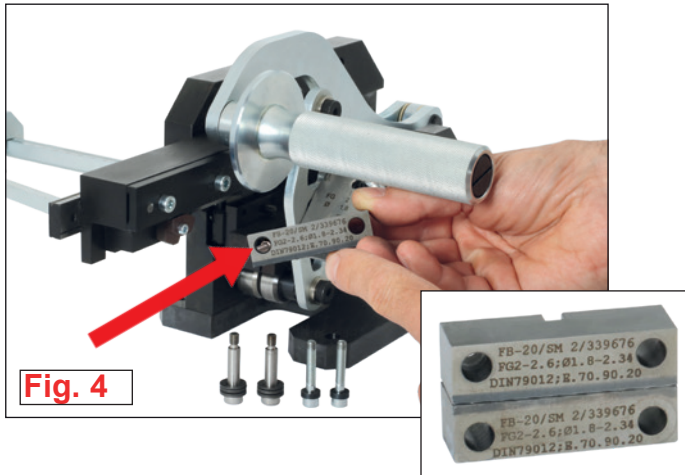
REPLACEMENT ROLLING DIES V.04
art. 720366

3. Put the handle in front position. Loosen and remove the 2 hexagon screws (HX 4) of the upper rolling die (fig. 3). Space washer will be used later again. Hold the upper rolling die secure to avoid damage and remove it from the machine.

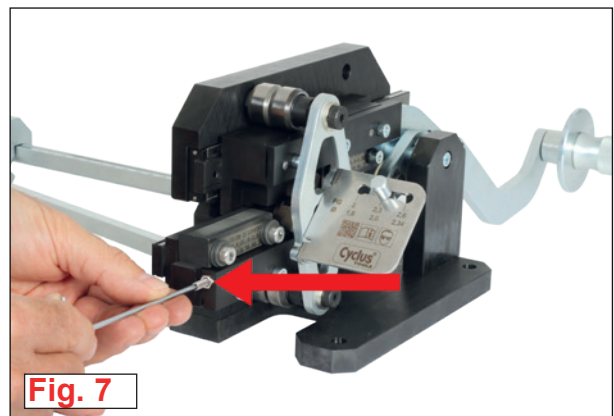
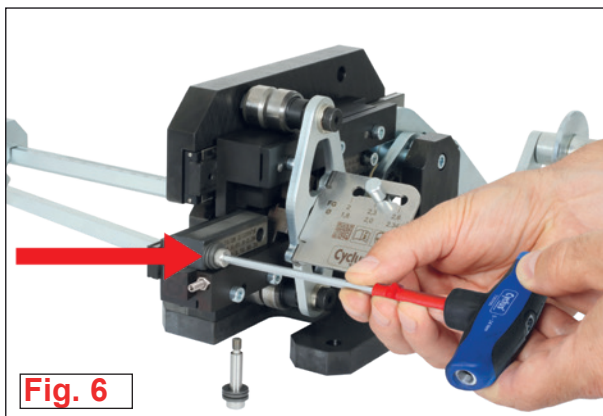


Make sure the work station is clean during installation. Replace both dies!

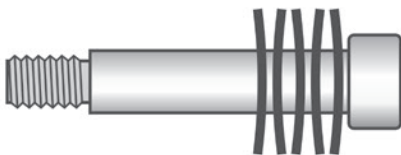
4. Put the handle in front position. Pay attention to the alignment of the rolling dies. The letters on the dies should be visible. Install only rolling dies with the same serial number (fig. 4). Mount the upper rolling die with 2 hexagon screws (HX 4) and spacer washers. The rolling die needs to seat solidly in its place. Tighten the screws with max. 3 Nm (fig. 5).



5. Put the handle back in starting position. Mount the lower rolling die with hexagon screws (HX 4) and cup springs. Pay attention to the correct mount of the cup springs. Press the die against the lower lay-on surface and tighten the screws with 3 Nm (fig. 6).



6. For adjustment of the spoke machine to a particular spoke diameter, please read the manual. Turn the front screw in right direction (clockwise) and move up the wedge in order to define the corresponding spoke thread diameter (fig. 7). Lastly, lightly re-tighten the 8 mm lock-nut. The exact and stepless adjustment of the spoke machine provides long durability of the rolling dies.



The combination of hexagon screws and cup springs provides the required initial tension of the lower rolling die. Make sure the cup springs are mounted absolutely correct in regard of the right sequence and direction of the springs.

Bicycle thread according to DIN 79012

Starting diameter spoke with rolled thread

FG 2	Ø 1,8 mm
FG 2,3	Ø 2,0 mm
FG 2,6	Ø 2,34 mm