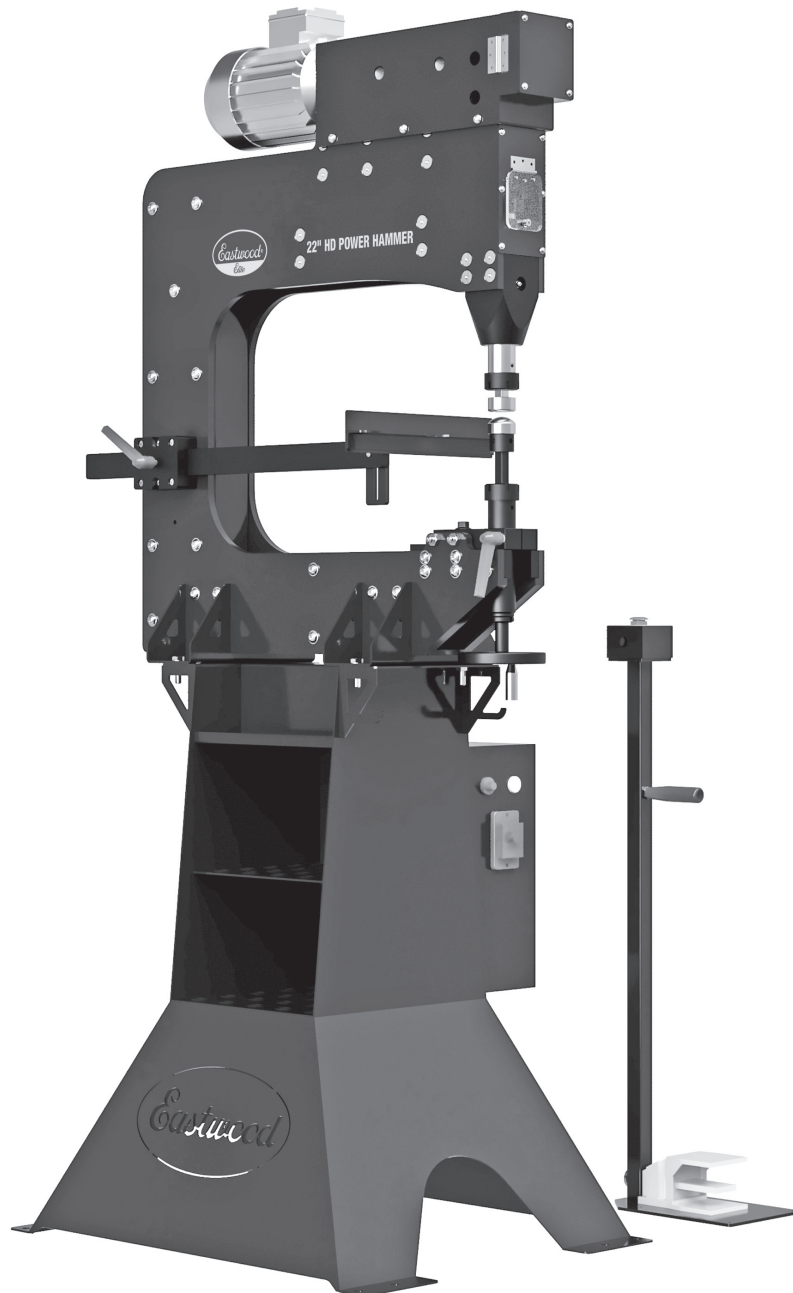




Item #74217

22" HD POWER HAMMER

INSTRUCTIONS



The **EASTWOOD ELITE HD 22" POWER HAMMER** is a game-changing tool for serious hobbyists or small shops creating custom-formed sheet metal from scratch. Solid, steel-framed construction will stand the test of time and a generous 22" throat depth makes this unit suitable for most automotive metal working projects on 18 gauge steel or 16 gauge aluminum. The included stand is built to withstand vibrational stress and also provides safe locations to hold all included tooling. To provide fine adjustment up to 960BPM with 120VAC household power, a variable frequency drive is used to control the 1.5HP motor. The 1/4" stroke, dual-mode sprung/rigid mechanism can quickly be switched to provide dampening for stretching and shrinking or a rigid action for operations that require a hard punch, such as beading forming. Two additional springs are included for adjusting the sprung mode softer or harder.

Our unique anvil tool post design and handwheel position make anvil & hammer positioning, swapping, and repeatable indexing a breeze. For an even faster anvil change, we offer the anvil tool post as an accessory to pre-configured multiple. This power hammer includes a wide range of tooling in both hardened steel and nylon that will be suitable for most metal shaping needs. Universal tooling holders are included for jobs that require purpose-built, homemade tooling. Stop forming sheet the hard way and let the power hammer do the work for you with greater precision and speed than possible with other forming tools.

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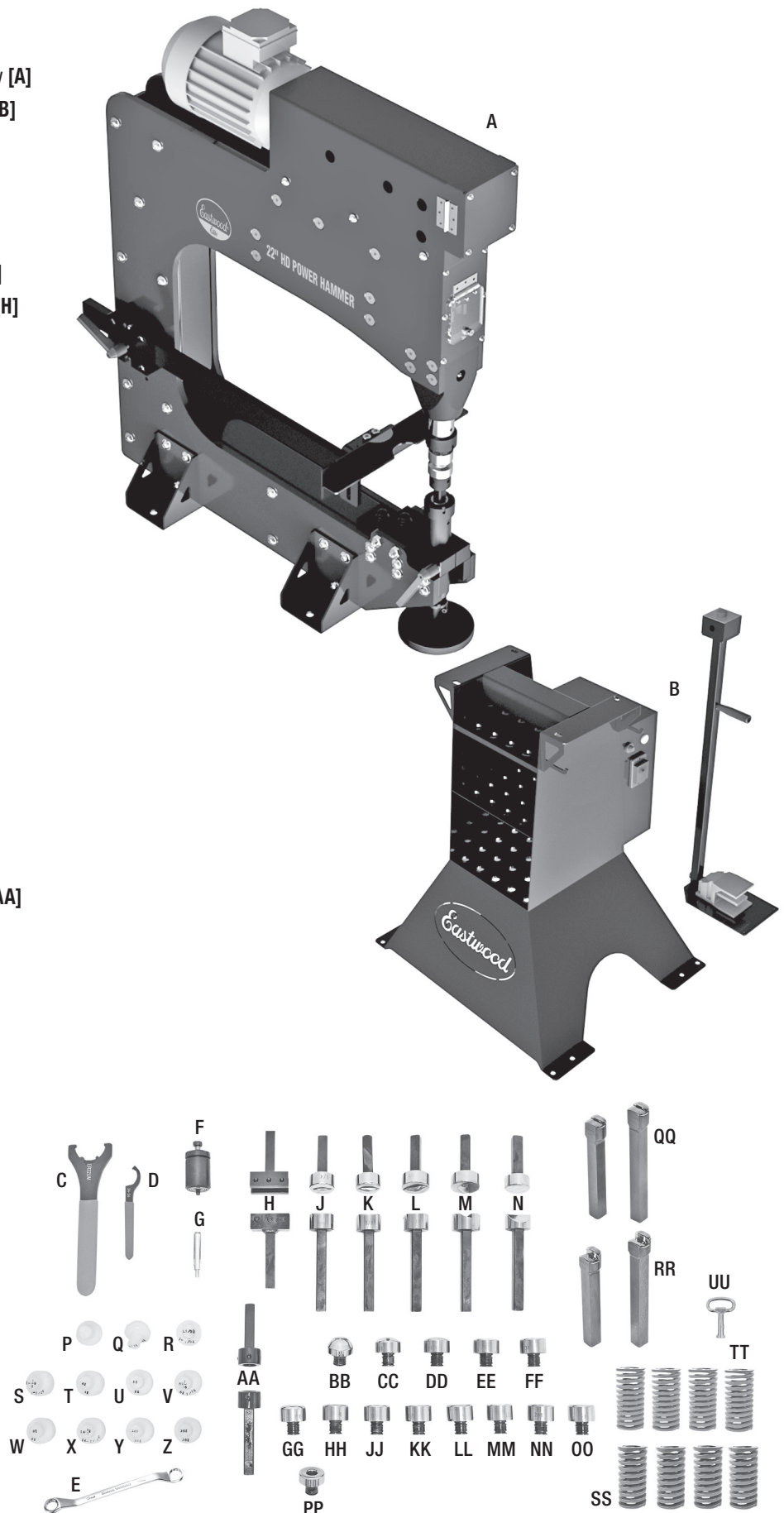
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SPECIFICATIONS

Power Input:	110-120 VAC, 50/60Hz, 13A
Motor Power Output:	1.5 HP
Motor Speed (No Load):	940 RPM
Throat Height:	15.5"
Throat Depth:	22"
Maximum Material Working Thickness:	18 gauge (1.2mm) steel 16 gauge (1.6mm) aluminum
Hammer Speed:	0 - 960 BPM
Stroke Length:	1/4" (6.35mm)
Spring Specifications:	Brown, 20% compression ratio Green (installed) 24% compression ratio Red, 32% compression ratio
Fence Width:	12" (305mm)
Hand Wheel Position:	Front mounted with latched sheet metal cover box.
Power Cord Length:	8' (2.5m)
Base Footprint:	32" x 18.5" (0.81 x 0.47m)
Overall Assembled Dimensions (W x D x H):	21.5" x 29.5" x 71" (0.55 x 0.75 x 1.80m)
Overall Assembled Weight:	460 lbs. (209kg)

INCLUDES

- (1) Eastwood Elite 22" HD Power Hammer Assembly [A]
- (1) Stand Assembly with Foot Pedal & E-Stop Post [B]
- (1) Collet Wrench (ER32UM) [C]
- (1) Spanner Wrench (34-36mm) [D]
- (1) 13/15mm Boxed Wrench [E]
- (1) Fence Roller with M8x80 Shoulder Bolt [F]
- (1) Handwheel Handle with M8x74 Shoulder Bolt [G]
- (1) Universal 5/8" Slot Mount Hammer & Anvil Pair [H]
- (1) 1/4" Bead Hammer & Anvil Pair [J]
- (1) 3/8" Bead Hammer & Anvil Pair [K]
- (1) 1/2" Bead Hammer & Anvil Pair [L]
- (1) Louver Hammer & Anvil Pair [M]
- (1) Linear Stretching Anvil [N]
- (1) Flat Hammer [O]
- (1) Nylon Flat Hammer [P]
- (1) 3/4" Nylon Radius Die [Q]
- (1) 1-1/8" Nylon Radius Die [R]
- (1) 1-1/2" Nylon Radius Die [S]
- (1) 4" Nylon Radius Die [T]
- (1) 5" Nylon Radius Die [U]
- (1) 6" Nylon Radius Die (1/16" edge) [V]
- (1) 8" Nylon Radius Die [W]
- (1) 14-1/2" Nylon Radius Die [X]
- (1) 24" Nylon Radius Die [Y]
- (1) 36" Nylon Radius Die [Z]
- (1) Universal Ø20mm Mount Hammer & Anvil Pair [AA]
- (1) 3/4" Radius Die [BB]
- (1) 1-1/8" Radius Die [CC]
- (1) 1-1/2" Radius Die [DD]
- (1) 2" Radius Die [EE]
- (1) 3" Radius Die [FF]
- (1) 3.1" Doming Anvil [GG]
- (1) 4" Radius Die [HH]
- (1) 5" Radius Die [JJ]
- (1) 6" Radius Die (1/16" edge) [KK]
- (1) 8" Radius Die [LL]
- (1) 14-1/2" Radius Die [MM]
- (1) 24" Radius Die [NN]
- (1) 36" Radius Die [OO]
- (1) Doming Hammer Die [PP]
- (1) 1/16" Offset Step Hammer & Anvil Pair [QQ]
- (1) 1/4" Offset Step Hammer & Anvil Pair [RR]
- (4) Heavy Springs (Brown) [SS]
- (4) Light Springs (Red) [TT]
- (1) Electrical Box Key [UU]



SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION

CAUTION indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE

NOTICE is used to address practices not related to personal injury.



READ INSTRUCTIONS

- Thoroughly read and understand this manual before using.
- Save for future reference.



DANGER **ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!**

- Always operate in a clean, dry area. Do not operate in wet or rainy areas. Wet electrical components and connections can cause electric shock, resulting in death or serious injury.



WARNING **EYE INJURY HAZARD!**

- Metal particles can be ejected from the metal surface when planishing. Sheet metal edges and corners are sharp and can injure eyes. Always wear ANSI approved eye protection when operating this tool.



WARNING **PINCH AND CRUSH HAZARD!**

- This power hammer rapidly delivers blows that can crush hands and fingers. To prevent injury, keep fingers away from the hammer and anvil while operating.



WARNING **HEAVY WEIGHT!**

- The assembly consists of several large, heavy metal components. The use of a suitable lifting device rated for at least 400 lbs. (181kg) is required and safety toe shoes are strongly recommended when assembling.



WARNING **INJURY HAZARD!**

- Handling sharp metal can cause serious cuts. Wear thick, well-fitting work gloves to prevent cuts from handling sharp metal.
- Using the power hammer generates excessive noise. Wear appropriate hearing protection while operating.
- Some minor physical force and awkward positions may be applied to the workpiece while using The power hammer. Failure to ensure proper footing can quickly result in a fall which could inflict serious personal injury or property damage. Always work in a clean, uncluttered environment.
- Do not operate the power hammer without all machine guards and covers in place. Missing or unsecured guards and covers could result in serious injury. Always verify the handwheel cover is closed and latched before operating.



WARNING **FIRE HAZARD!**

- Hammering can eject sparks and hot metal which may cause fire. Always ensure the work area does not contain flammable objects or fire hazards.



⚠ CAUTION TIPPING HAZARD!

- Before beginning ANY work with the power hammer, it is necessary that it be anchored to the floor. The power hammer stand and frame are unstable and could tip before they are secured. Exercise caution while handling before anchoring.



⚠ CAUTION EXCESSIVE VIBRATION RISK!

- This tool vibrates excessively during use. Prolonged, repeated exposure to vibration may cause physical injury.
- Verify all lower tool post hardware is tight before each use. Regularly inspect all hardware for tightness. Excessive vibrations made while operating can loosen hardware.
- Using wooden cribbing to dampen vibrations delivered to the floor is highly recommended.



⚠ CAUTION INJURY HAZARD!

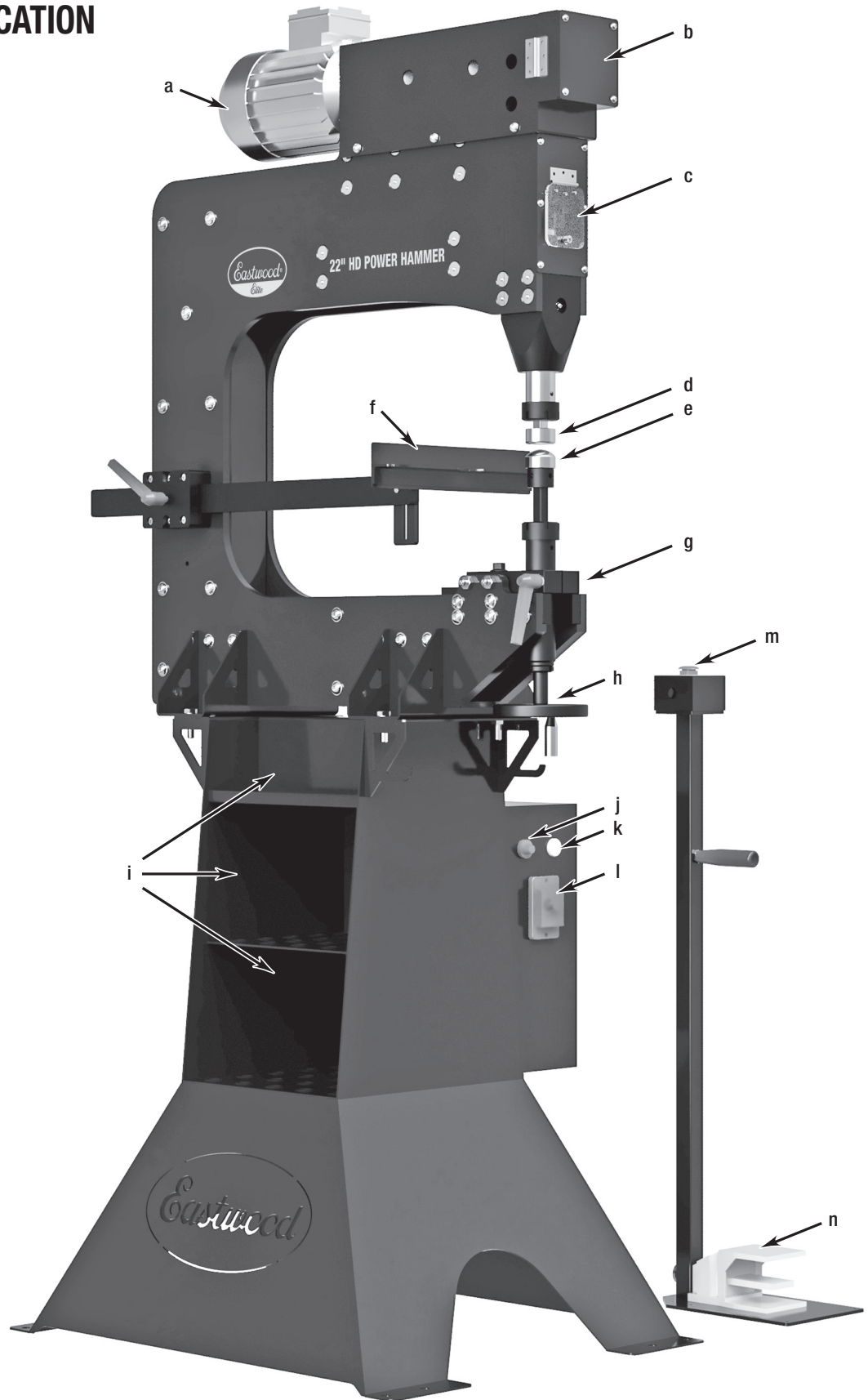
- The power hammer includes changeable tooling and components which can cause injuries if dropped. Avoid pinching hands while handling parts and during assembly. The use of thick, well-fitting work gloves and safety toe shoes is strongly recommended.
- If accidentally triggered while connected to a power supply, this tool can quickly start up and cause personal injury. Always disconnect the tool from the power supply or activate emergency stop before changing anvils, sprung/rigid mode, or performing maintenance.
- The rotating components of this power hammer can quickly catch loose clothing, long hair or jewelry causing serious personal injury. Keep all loose clothing, long hair and jewelry away from the power hammer during operation.
- Keep children and bystanders away from the machine and tooling. Small hardware components pose a choking risk to children. Disconnect from power when not in use.
- The power hammer was designed to be operated by only one person. Never have two people operate the power hammer, or serious injury could occur.

⚠ NOTICE

- This power hammer is intended only for use for forming sheet metal. Do not use for forging or other hammering operations.
- To prevent premature bushing wear, keep rotating and sliding surfaces coated with fresh grease.

COMPONENT IDENTIFICATION

- [a] Motor
- [b] Hammer Handwheel Cover
- [c] Spring Setting Window
- [d] Hammer
- [e] Anvil
- [f] Fence
- [g] Anvil Tool Post
- [h] Anvil Height Handwheel
- [i] Die Storage
- [j] Speed Adjustment
- [k] Power Indicator
- [l] ON/OFF/Emergency Stop Button
- [m] Emergency Stop Button
- [n] Foot Pedal



ASSEMBLY

- Unpackage and remove all items from the crate. Verify all components are present. Keep the nuts and bolts used to hold the stand and the power hammer to the crate floor. You may re-use these to bolt the power hammer to the stand.
- Pre-position the Stand Assembly with Foot Pedal & E-Stop Post [B] where you want to mount the power hammer. Verify there will be adequate room on all sides to access the power hammer, electrical box, and form the largest sheet metal panel you may encounter.
- Floor anchoring is required. The power hammer vibrates strongly during use and will “walk” around a shop floor, additionally, the unit is top heavy and poses a tipping risk. It is recommended to build a “crib” for the stand to rest on with 2x4 lumber to provide vibration dampening.
- With a suitable lifting device and straps capable of hoisting at least 400 lbs. (181kg), use a strap around the top of the Eastwood Elite 22” HD Power Hammer Assembly [A] frame, near the motor to balance it (FIG 1).
- Carefully hoist into position with the throat opening on the controls side of the electrical box. Securely bolt the power hammer to the stand with the crate hardware set aside earlier (FIG 2).
- Plug the motor cable of the power hammer into the back of the electrical box (FIG 3).
- Install the Handwheel Handle with M8x74 Shoulder Bolt [G] to the anvil handwheel (FIG 4).

FIG. 1

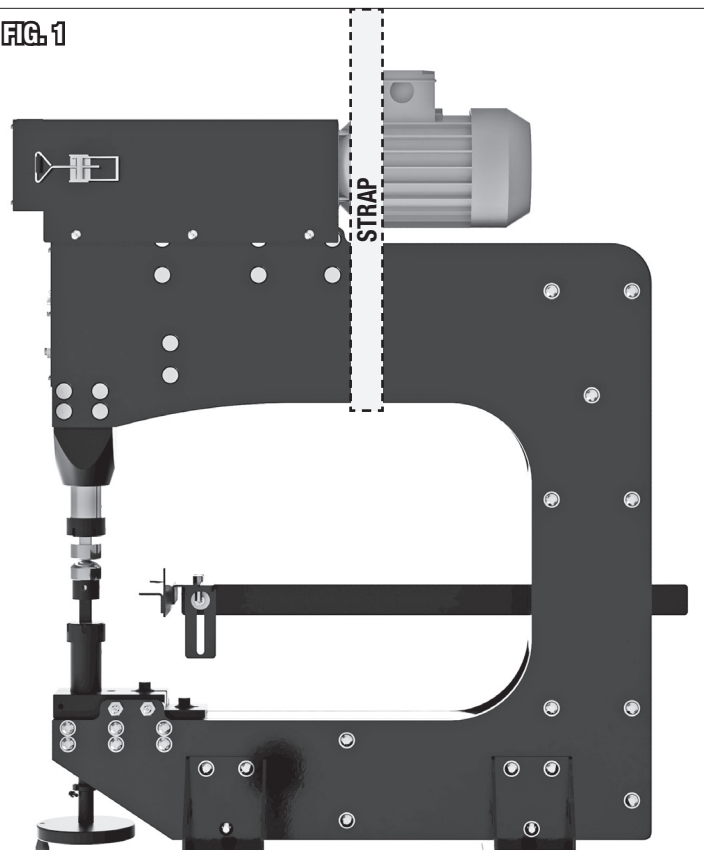


FIG. 2

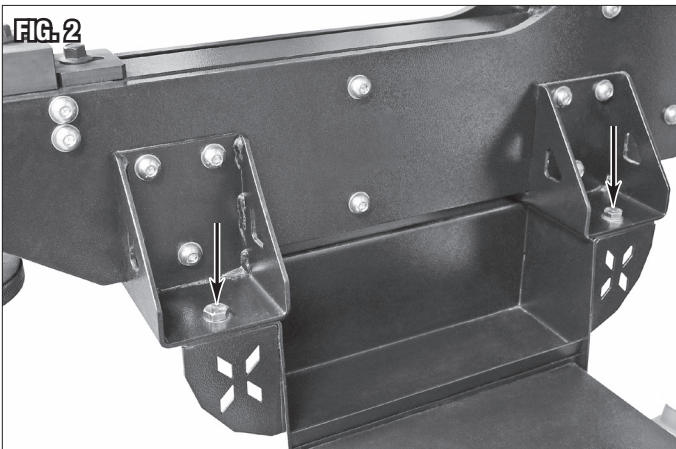


FIG. 4

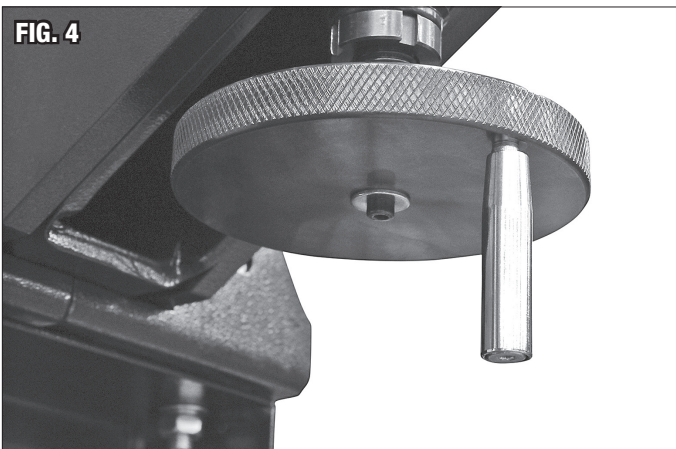
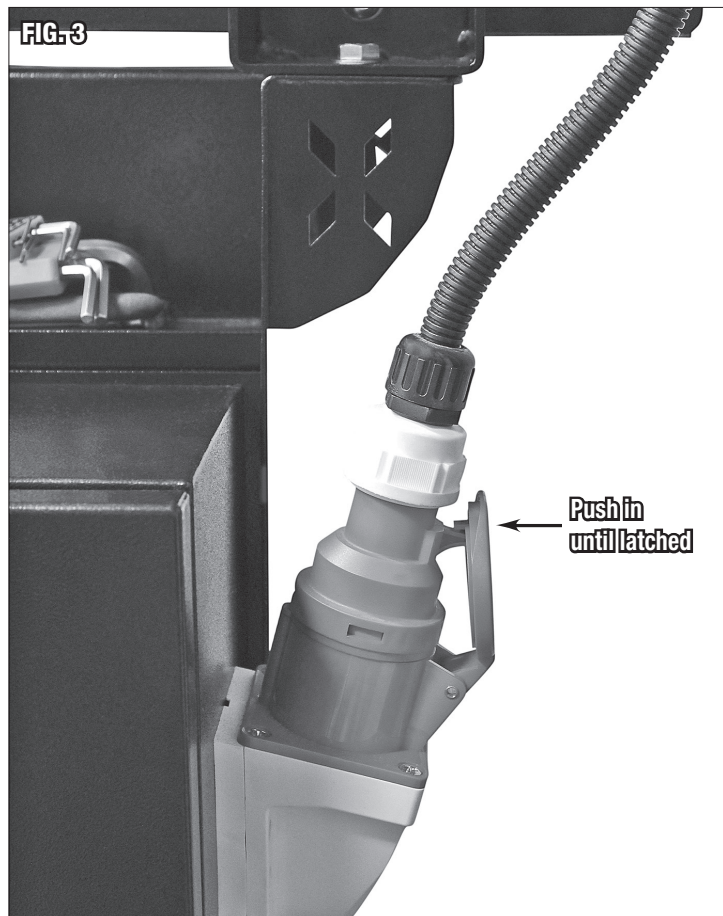


FIG. 3



SET-UP

CONNECTING THE POWER HAMMER TO A POWER SOURCE

The Eastwood Eastwood Elite 22" HD Power Hammer requires a dedicated 120 VAC, 15 AMP, circuit breaker protected outlet. The plug installed on the Welder is a NEMA 1-15P and should be used with a NEMA 1-15R receptacle. If unsure about your electrical setup contact a licensed electrician.

If using an extension cord is required, utilize a minimum 12 AWG cord at a maximum of 50 ft. We recommend using our welder extension cords for optimal performance: Eastwood item #31739 25ft Heavy Duty 110V Extension Cord.

HAMMER SWAPPING

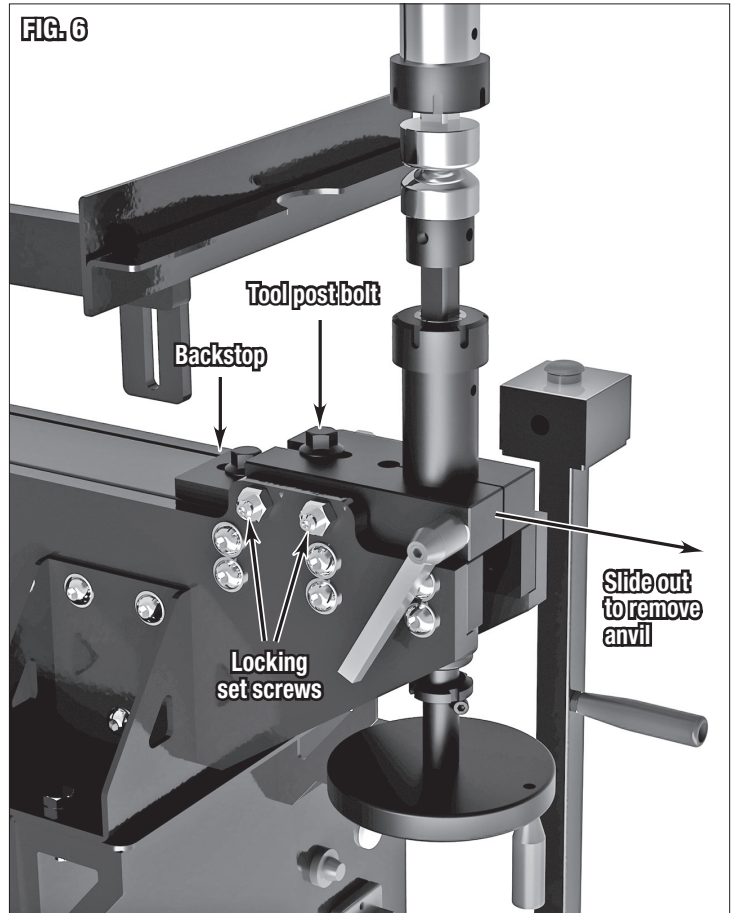
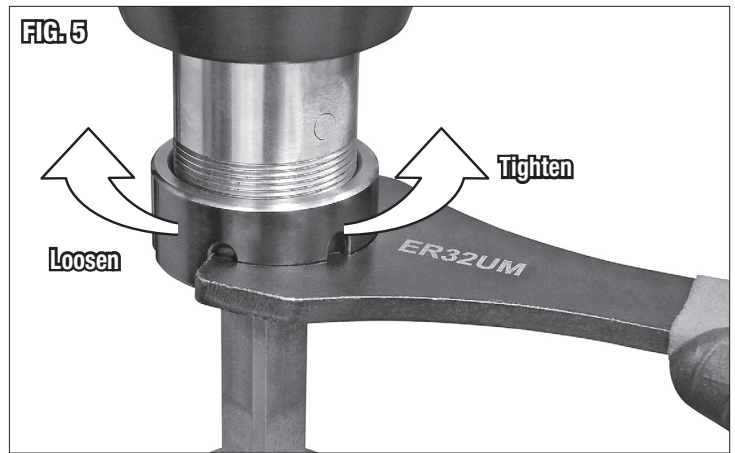
- Remove the anvil tool post via the single rear bolt for clearance when dropping the hammer.
- Loosen the hammer collet with the Collet Wrench (ER32UM) [C] (FIG 5). Only a half turn (180°) should be required to unlock it, but you will likely need to softly strike it to break it loose from the collet. Be ready to catch the hammer; it will drop free.
- Insert the new hammer (in a paired set, the hammer has a shorter shank).
- Fully bottom out the hammer in the collet before tightening it.
- Reinstall anvil tool post.

ANVIL SWAPPING AND TOOL POST ADJUSTMENT

The anvil tool post of the Eastwood Eastwood Elite 22" HD Power Hammer has been redesigned for ease of adjustment and repeatable quick-swap reindexing. If you wish to have multiple anvils configured at once, spare tool posts can be purchased (#74218).

ANVIL SWAPPING

- Loosen the anvil collet with the Collet Wrench (ER32UM) [C]. Only a half turn (180°) should be required to unlock it, but you will likely need to softly strike it to break it loose from the collet.
- For clearance, loosen the tool post bolt and partially slide the tool post out to remove the anvil (FIG 6).
- Insert the new anvil (in a paired set, the anvil has a longer shank). Reinstall the tool post and tighten the bolt. Tighten the anvil collet if no further adjustment is required. If adjustment is required, continue below.



TOOL POST ALIGNMENT AND HEIGHT SETTING

- The anvil tool post features locking set screws on the sides and a backstop behind the tool post (**FIG 6**). These are used to precisely tune the anvil position to be perfectly aligned with the hammer in both directions (**FIG 7**). Adjust the hammer to the bottom of its stroke with the hand wheel located behind the Hammer Handwheel Cover [b].
- Loosen the anvil collet and anvil height handwheel lock (**FIG 8**). Crank the anvil height up, close to the hammer for easy alignment (**FIG 7**).
- When aligned, lock the set screws and tighten backstop to provide a repeatable position. Lock in tool post in position with the tool post bolt.
- For most operations, set the anvil to hammer clearance to near zero, or material thickness. Adjust by loosening the anvil collet and lock collar on the Anvil Height Handwheel [h] (**FIG 8**). Turn handwheel to raise the anvil. When in position, relock the handwheel collar. Rotate hammer handwheel to verify clearance.
- In the case of thumbnail dies or beading dies, you should also align the anvil rotationally (**FIG 9**). These dies are typically laser marked to assist with this.
- When satisfied with alignment, lock anvil height adjustments and collet tight.

FIG. 7A

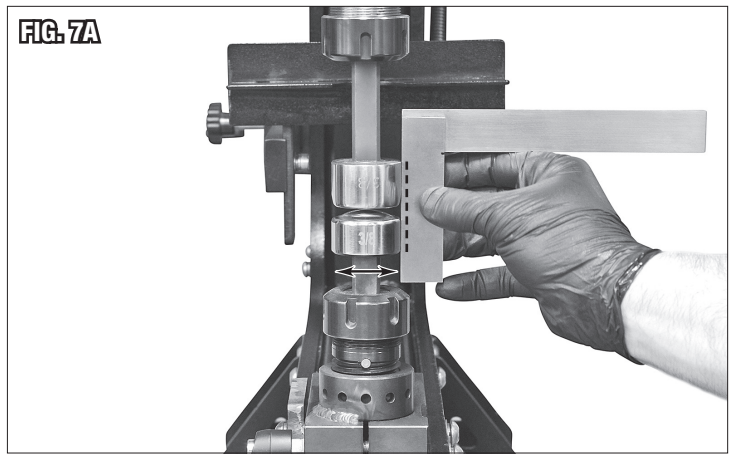


FIG. 7B

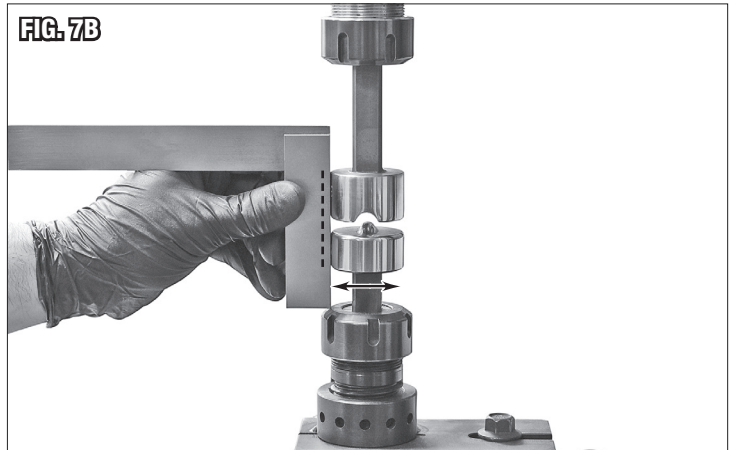


FIG. 8

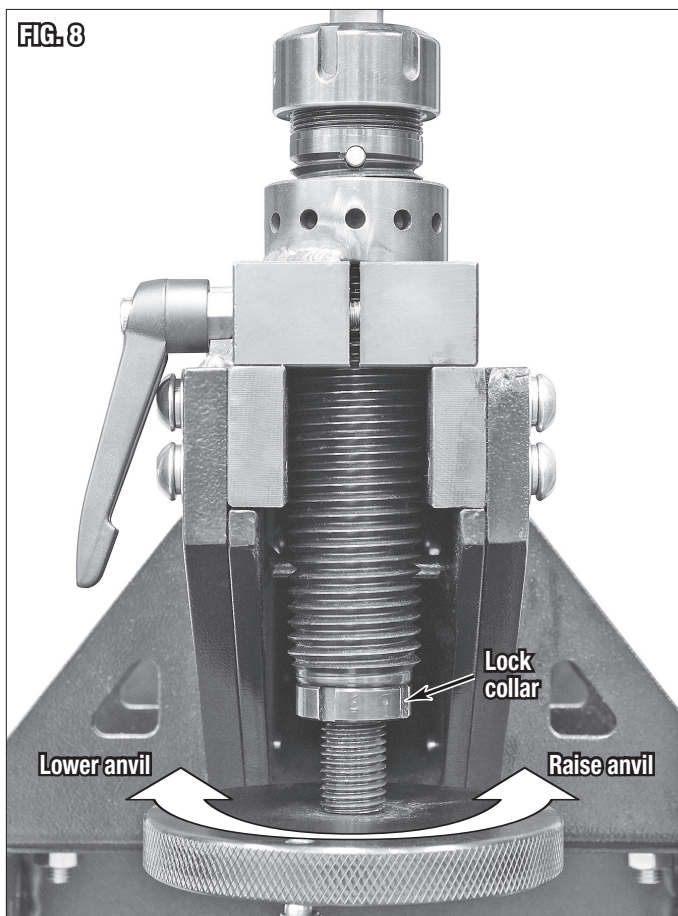
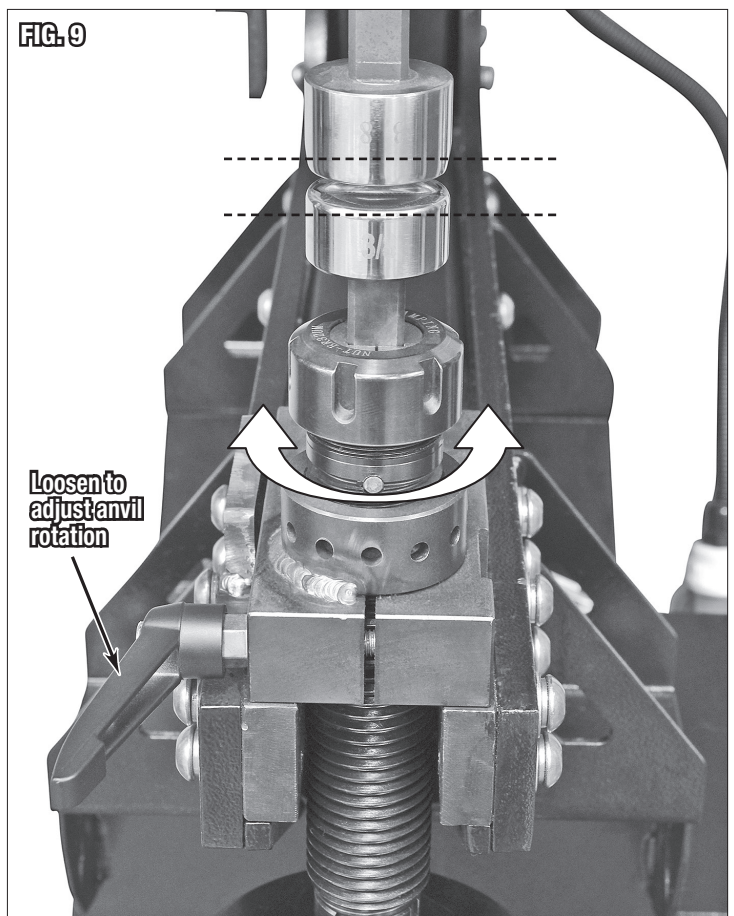


FIG. 9



SPRUNG/RIGID MODE

The blow of the Power Hammer can be switched between a sprung mode that provides dampening for stretching and shrinking and a rigid mode for operations that require a hard, fixed punch, such as beading forming or planishing. The hammer can be swapped between these modes in seconds by following the instructions below.

Furthermore, two additional spring sets are included for adjusting the sprung mode stiffness. The power hammer ships with a medium stiffness spring set installed. The included red spring set is lighter (for thin gauge steel) and the brown spring set is heavier (for thicker gauge steel).

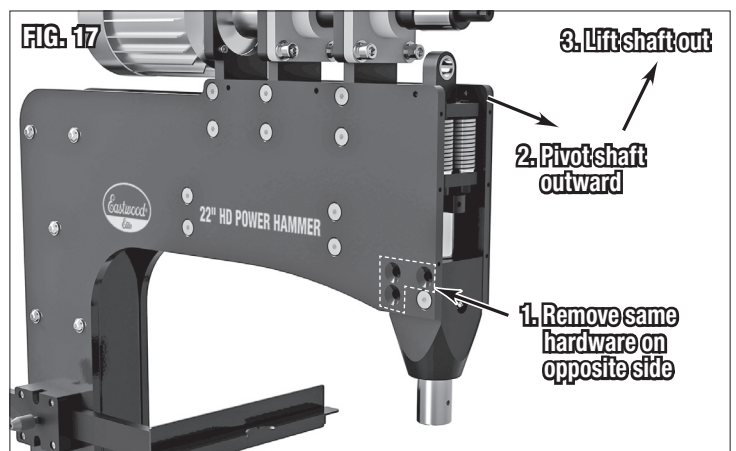
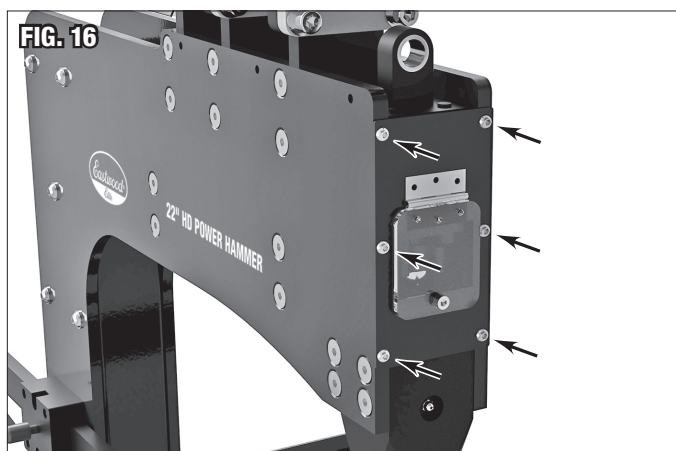
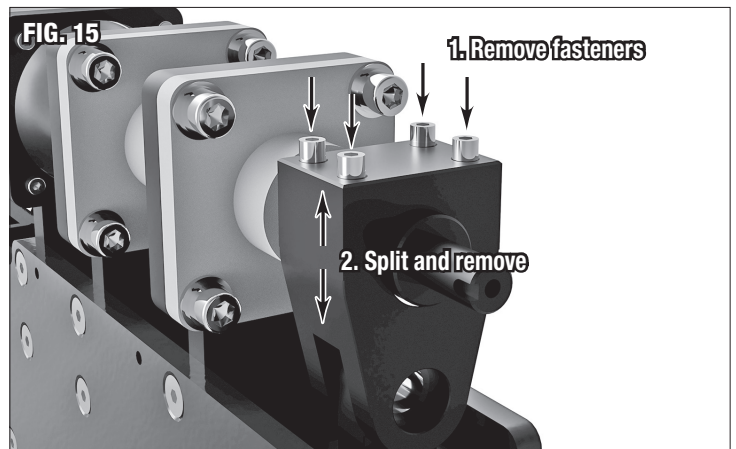
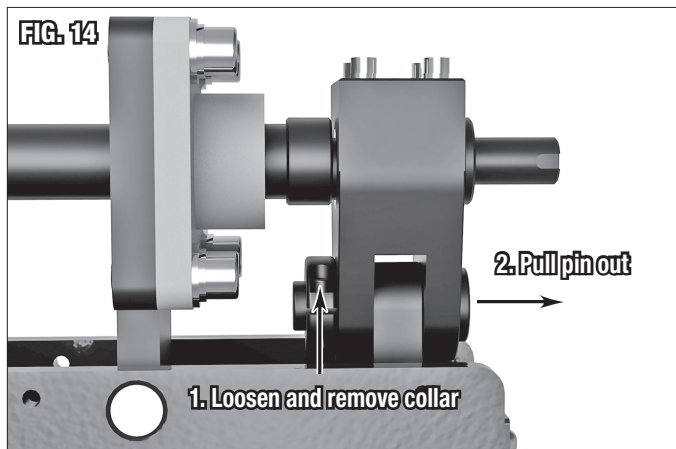
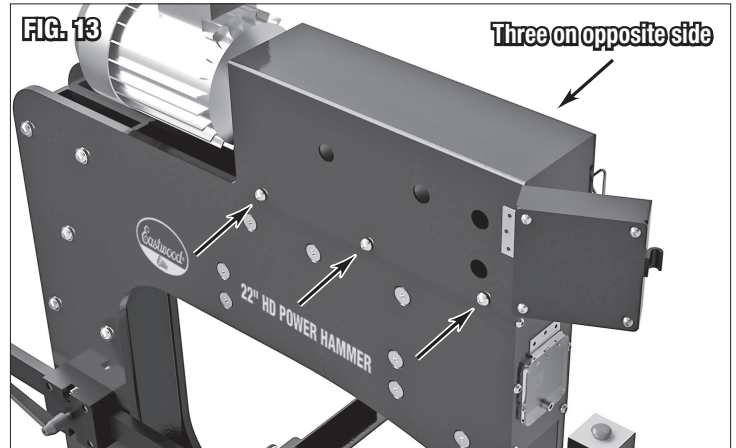
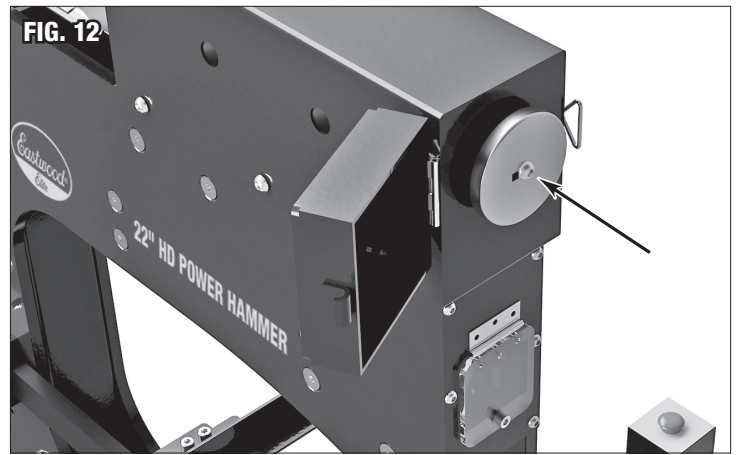
SWITCHING BETWEEN RIGID BLOW AND SPRUNG BLOW

- First, disconnect the power hammer from the power source.
- Loosen the retaining fastener and open the Spring Setting Window [M].
- Spin the four-spoked metal block on the inside until you feel it lock in a detent and the drilled spoke is facing you. This enables sprung mode (**FIG 10**).
- Spin the four-spoked metal block to the right 45° until you feel it lock in another detent and the spokes are under the bolt heads to enable rigid mode (**FIG 11**).
- Close the Spring Mode Window and refasten it.



CHANGING SPRINGS AND PRELOAD

- First, disconnect the power hammer from the power source.
- Remove the hammer, collet, and collet nut.
- Unfasten and remove the keyed hammer handwheel (**FIG 12**)
- Remove top guard by unscrewing the six fasteners (**FIG 13**). Note that there are vibration damping strips under the fasteners on either side.
- Loosen and pull off the top hat pin collar, then pull the pin out (**FIG 14**). Be careful, the hammer shaft will drop down.
- Remove the crank link cap by unfastening the four screws (**FIG 15**). The cap and crank link can then be removed.
- Remove the front guard by unscrewing the six fasteners (**FIG 16**). Then, remove six of eight fasteners holding the hammer shaft guide to the frame, leaving two on either side loose to allow it to pivot (**FIG 17**).
- Pivot the hammer shaft guide outward and lift the hammer shaft assembly out (**FIG 17**).



- Secure the hammer shaft assembly in a vise. Unfasten four spring shoulder bolts and the shaft assembly will split from the top hat (**FIG 18**).
- The spring set can now be replaced. Always replace as a set. Never mix spring rates or uneven wear and damage to the machine could occur.
- Additionally, you may remove shims for less preload on the springs. Less preload will result in more spring travel and a more gradual “softer” hit. To adjust the shim stack:
 - Unbolt the hammer shaft from the spring plate (**FIG 19**) to remove the shaft.
 - The shoulder bolts can now be removed, and the shim stacks can be adjusted. Always adjust the shim stacks evenly. Never mix shim heights or uneven wear and damage to the machine could occur.
 - Reinstall shoulder bolts and hammer shaft. Ensure hammer shaft orientation stays the same or the notch indicating mode may not be visible.
- Reassemble components in reverse order. Ensure all bolts are fastened TIGHT.

FIG. 18

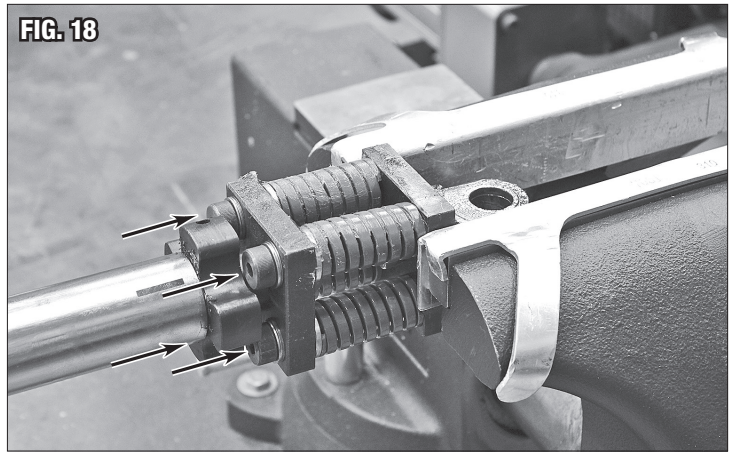


FIG. 19

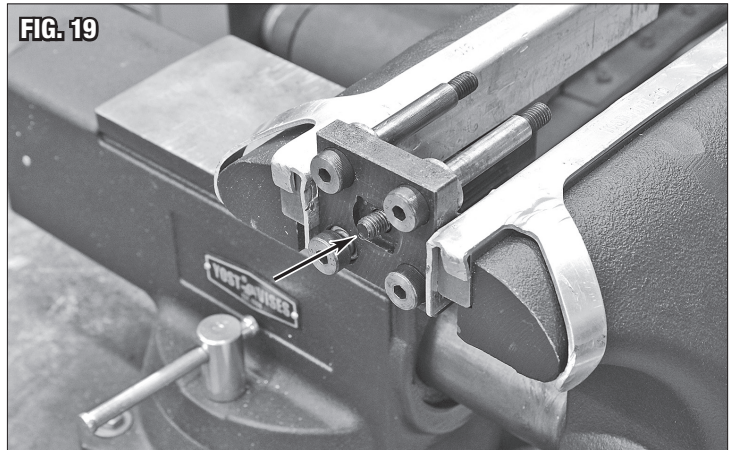
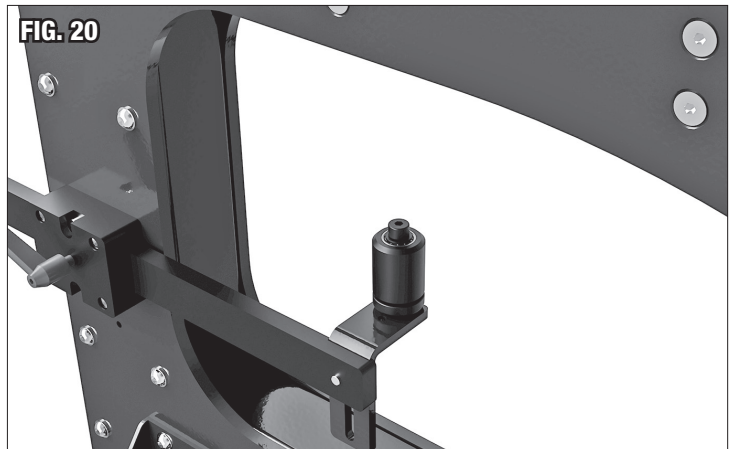


FIG. 20



FENCE

To assist in consistent feeding of your workpiece, the frame is equipped with a “fence.” This simple device gives you a backstop you can insert the panel to every time for a consistent forming depth.

It can be used as shipped with the 12” wide, flat angle iron fence for straight workpieces. Alternatively, install the Fence Roller with M8x80 Shoulder Bolt [F] (**FIG 20**) for objects that are curved.

DIE AND TOOL STORAGE

The left side of the stand features a convenient area to store all die sets (**FIG 21**). The front of the stand, immediately behind the Anvil Height Hand-wheel features hooks to hang wrenches (**FIG 21**). The upper right side of the stand, between the feet, has a tray area for quick tool access (**FIG 22**).

FIG. 21

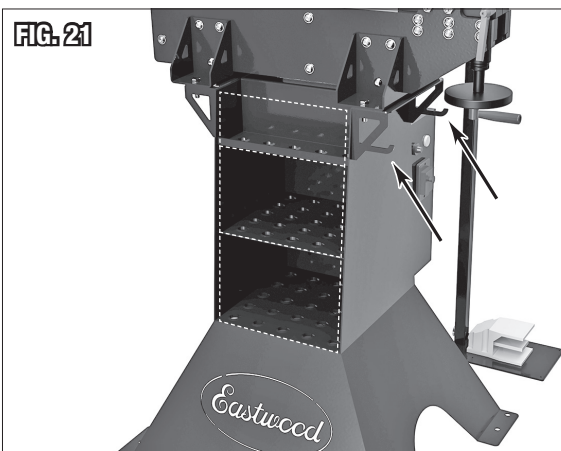
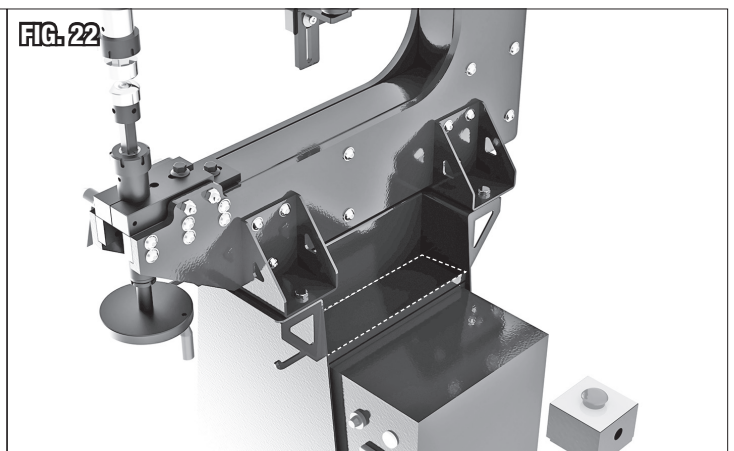


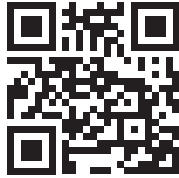
FIG. 22



OPERATION

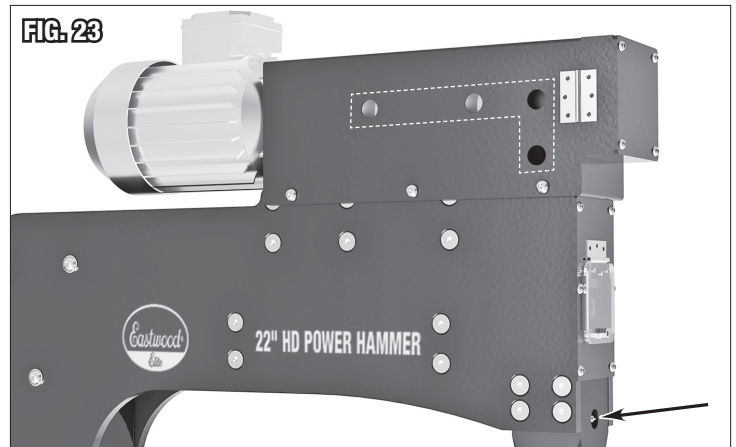
- Flip up the ON/OFF/Emergency Stop Button **[I]** cover and press the green button to power on the machine.
- Ensure the remote emergency stop button above the foot pedal is not triggered by rotating it counterclockwise.
- Turn the Speed Adjustment **[J]** counterclockwise to start with a lower speed.
- Press the foot pedal down slowly. The pedal control is variable and also allows you to control speed in addition to the Speed Adjustment dial.
- Carefully feed the workpiece into the hammer steadily and allow it to work the metal. Use the fence to your advantage for maximum control.

For more in-depth power hammer theory-of-operation and demonstration videos follow the link from this QR code:



MAINTENANCE

- The HD reciprocating power hammer produces heavy vibrations during operation. Periodically check all hardware for looseness and damage.
- Lubricate the crank shaft and piston grease fittings monthly with an NLGI #2 equivalent grease if used regularly. The crank shaft fittings are accessible by pulling out the rubber plugs in the top cover (**FIG 23**) and the piston grease fitting is located below the Spring Setting Window **[c]** (**FIG 23**).
- Periodically lubricate the sliding surfaces of the fence arm and anvil height adjustment screw with an ISO 68 equivalent oil to prevent corrosion and promote free movement.



TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Motor Does Not Run	VFD has not fully reset	The VFD needs approximately 10 seconds after power on before it is ready for use.
	ON/OFF/Emergency Stop Button [I] cover closed	Open cover and press green button to activate machine.
	Emergency stop triggered	Rotate emergency stop clockwise to release it.
	Incorrect input voltage	The Eastwood Elite 22" HD Power Hammer requires a grounded, 120VAC circuit protected by a 15A breaker.
	Circuit breaker tripped	Reset input power circuit breaker. Verify circuit and wiring integrity.
Stalling During Forming	Workpiece too thick for operation	Do not exceed machine capacity.
	Motor overheated	Allow cooling time if motor is hot.
Excessive Vibration or Noise	Loose components, hardware	Inspect unit for damage, loose components, hardware. Do not continue use until problem has been identified and fixed.
Workpiece Finish Damage	Anvil or hammer dirty	Verify the forming surfaces are clean, free of dust and grit.
	Anvil or hammer damaged	Forming surfaces should be smooth and undamaged. Repair or replace if damage is observed.
Poor Forming Results	Incorrect hammer and anvil selection or poor alignment	Ensure the hammer and anvil being used are suitable for shape needed. Verify alignment and clearance between hammer and anvil.

[illegible]

ADDITIONAL ITEMS

R&D MUST-HAVE ACCESSORIES



#72800
Yost 760-DI 6"
Swivel Head Rotating Vise



#73304
Eastwood English Wheel
with Floor Stand



#73882
Eastwood Elite 225 Amp
AC/DC Digital TIG Welder

OPTIONAL ITEMS

- #74219** 90° Edge Setting Hammer and Anvil Set
#74218 Lower Toolpost Assembly

Visit eastwood.com for complete info and pricing.

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: tech@eastwood.com

PDF version of this manual is available at eastwood.com

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA 800.343.9353 eastwood.com

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