



24", 36", 50" SLIP ROLLS



**24"-22GA.
MODEL: KC-S2422**



**36"-22GA.
MODEL: KC-S3622**



**50"-16GA.
MODEL: KC-S5016**

INSTRUCTION MANUAL

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IMPORTANT INFORMATION

WARRANTY INFORMATION

2-YEAR
LIMITED WARRANTY
FOR THIS SLIP ROLL

PROOF OF PURCHASE

Please keep your dated proof of purchase for warranty and servicing purposes.

REPLACEMENT PARTS

Replacement parts for this tool are available at our authorized KING CANADA service centers across Canada. For servicing, contact or return to the retailer where you purchased your product along with your proof of purchase.

LIMITED TOOL WARRANTY

KING CANADA makes every effort to ensure that this product meets high quality and durability standards. KING CANADA warrants to the original retail consumer a 2-year limited warranty as of the date the product was purchased at retail and that each product is free from defects in materials. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations and lack of maintenance. KING CANADA shall in no event be liable for death, injuries to persons or property or for incidental, special or consequential damages arising from the use of our products. To take advantage of this warranty, the product or part must be returned for examination by the retailer. Shipping and handling charges may apply. If a defect is found, KING CANADA will either repair or replace the product.

IMPORTANT: IF THIS MACHINE IS DAMAGED DUE TO FEEDING MATERIALS THAT ARE A THICKER GAUGE STEEL THAN (20GA.-BB-S2420, 22GA.-BB-S3622, 16GA.-BB-S5016), THE WARRANTY WILL BE NUL AND VOID.

IMPORTANT INFORMATION



UNPACKING

Refer to the parts diagram which corresponds to your slip roll model number and size.

Check for shipping damage. If damage has occurred, a claim must be filed with carrier. Check for completeness. Immediately report missing parts to dealer

Carefully open crate, unbolt slip roll from shipping pallet and remove from crate using heavy duty lifting equipment such as an overhead crane.

WARNING! Be careful not to touch overhead power lines, piping, lighting, etc. If lifting equipment is used, see specifications below for weights of the slip rolls. Proper tools, equipment and qualified personnel should be employed in all phases of unpacking and installation.

The slip rolls come assembled as one unit. Additional parts which need to be fastened to the tool should be located and accounted for before assembling:

24" & 36" slip roll assembly

-Crank handle (Part# 11-14)

50" slip roll assembly

-Crank handle (Part# 11-13)

IMPORTANT: Rolls are coated with a protectant. To ensure proper fit and operation, remove coating. Coating is easily removed with mild solvents, such as mineral spirits, and a soft cloth. Avoid getting cleaning solution on paint or any of the rubber or plastic parts. Solvents may deteriorate these finishes. Use soap and water on paint, plastic or rubber components. After cleaning, cover all exposed surfaces with a light coating of oil.

WARNING! Never use highly volatile solvents. Non-flammable solvents are recommended to avoid possible fire hazard.

SPECIFICATIONS

24" SLIP ROLL MODEL: KC-S2422

Maximum thickness	22 gauge (.036") mild steel
Maximum length	24"
Roll diameter	2"
Minimum cylinder size formed	2"
Wire groove diameter	3/16, 1/4 and 5/16"
Overall dimensions	42 x 13 x 15"
Weight	180 lbs

36" SLIP ROLL MODEL: KC-S3622

Maximum thickness	22 gauge
.....	(.030") mild steel
Maximum length	36"
Roll diameter	2"
Minimum cylinder size formed	2"
Wire groove diameter	3/16, 1/4 and 5/16"
Overall dimensions	55 x 13 x 15"
Weight	242 lbs

50" SLIP ROLL MODEL: KC-S5016

Maximum thickness	16 gauge
.....	(.060") mild steel
Maximum length	50"
Roll diameter	3"
Minimum cylinder size formed	3"
Wire groove diameter	1/4, 3/8 and 7/16"
Overall dimensions	72 x 14 x 16"
Weight	500 lbs



OPERATION & MAINTENANCE

ASSEMBLY

Refer to the parts diagram which corresponds to your slip roll model number and size.

24" AND 36"

Remove crank arm assembly (Part# 11-14), from bottom roll (Part# 19) by loosening hex bolt (Part# 14), reverse position and replace on to roll, then tighten bolt securely.

50"

Place crank arm assembly (Part# 11-13) onto shaft (Part# 6). Secure in position by tightening set screw (Part# 13).

INSTALLATION

Machine should be installed on a level surface, with proper lighting. Machine is to be stand-mounted or bench-mounted. Be sure to provide clearance for crank arm rotation. Use the four mounting holes in the base to bolt machine securely to bench or stand (fasteners not included). Area around machine should be clear of scraps, oil, or dirt. Apply a suitable non-skid material to floor. Allow approximately three feet of clearance on all sides of the slip rolls for ease of operation.

OPERATION

Refer to the parts diagram which corresponds to your slip roll model number and size.

1. Adjust the bottom roll position for material thickness. Insert the workpiece between the top and bottom rolls (Part# 19 and 21). Turn the bottom roll adjusting knobs (Part#10) until the workpiece fits tightly between the rolls.
2. Adjust the rear roll (Part# 20) for the diameter of the cylinder to be formed. The position of the rear roll controls the size of the cylinder that will be formed. Setting roll lower forms a larger diameter cylinder, setting the roll higher forms a smaller diameter cylinder. Because material spring back varies with the type of metal being formed, several test workpieces may need to be formed to obtain correct adjustment of the rear roll. Turn the rear roll adjusting knobs (Part# 15) to raise or lower the rear roll. Turn crank handle (Part# 12) clockwise, until workpiece is through the rolls. Check diameter of test workpiece, and adjust the rear roll if necessary. Repeat until the correct adjustments are obtained. Rolls must be adjusted parallel or the workpiece will spiral during the rolling process.
3. When the cylinder has been formed completely, it can be removed without distortion.

24" AND 36"

Loosen the hex head bolt (Part# 24) on the clamp handle (Part# 23). Lift the clamp handle and move the clamp (Part# 26) completely back. Pulling the roll lift handle (Part# 8) forward will tilt the top roll up and the workpiece can be easily removed.

PARTS DIAGRAM & PARTS LISTS

Refer to the Parts section of the King Canada web site for the most updated parts diagram and parts list.

50"

Grasp the pivot sleeve (Part# 31) and pull out from the frame (Part# 30). Pulling the pivot sleeve forward will move the top roll out of the frame.

4. When rolling a workpiece near capacity thickness and length, it may be necessary to pass the workpiece through rolls several times to reduce cylinder to the desired diameter. Adjust rear roll so that the workpiece can pass through the rolls without difficulty. Slightly raise the rear roll before each succeeding pass until the desired diameter is obtained.
5. To form cylinders which have diameters that are approximately the same size as the rolls, reverse rolling is employed. Insert the workpiece from the rear side over the rear roll (lower roll is necessary,) and into the top and bottom rolls. Secure the workpiece by turning the bottom roll adjusting knobs (Part# 10). Bend the workpiece as far as possible by raising the rear roll using the rear roll adjusting knobs. Rotate crank handle (Part# 12) counter clockwise to form cylinder.

To reduce the flat spot on the starting edge of thicker materials, reverse the workpiece after the first pass. Feed the edge of the workpiece that passed through the rolls last, first on the next pass.

MAINTENANCE

Refer to the parts diagram which corresponds to your slip roll model number and size.

LUBRICATION

Coat rolls with light oil to prevent rusting.

24" AND 36"

MONTHLY

1. Use medium weight, non-detergent oil and multi-purpose or bearing grease.
2. Oil the rolls through the oil holes located in the guide blocks (Part# 17-18) and on top of the pivot block (Part# 33).
3. Grease the bearing surface of the right side of the top roll.
4. Grease the gears (Part# 28, 32).

50"

MONTHLY

1. Oil the rolls through the oil holes located on the guide blocks (Part# 27), and the pivot block (Part# 26).
2. Oil the crank shaft (Part# 6) through oil holes located on the front of the left and right frames (Part# 4 and 30).
3. Grease all gears (Part# 5, 6, 22 and 23) and grease the bearing surface of the right side of the top roll.