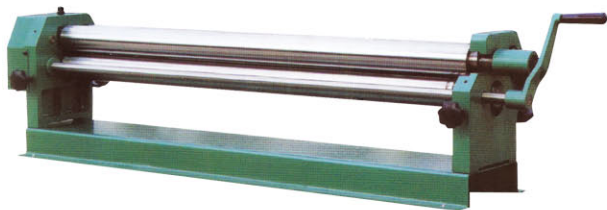


4213-0



SLIP ROLLS INSTRUCTION MANUAL 50" (1300MM) X 16GA

HOW TO FORM CIRCLES IN JUST TWO PASSES.

Length of material necessary to form the desired size circle is the first consideration in circle forming. To determine approximate length of material needed, use the formula $C = \pi D$. C is Circumference, π equals 3.1417, D is Diameter. For example, to find the length of material needed (C or Circumference) to form a circle 4" in diameter multiply 3.1417 by 4". Result - 12.5667 is the circumference of approximate length of material needed. Cut a few pieces of material to this length for test forming. Material may have to be lengthened or shortened depending upon results of the test forming run.

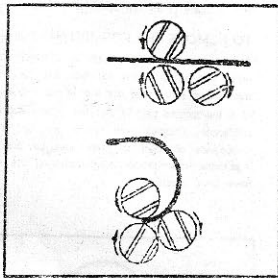
TO ADJUST ROLLER - for material thickness, loosen the thumb screw to the right of the adjusting screws. Turn the adjusting screws to raise or lower the lower pinch roll. Insert the material between the rolls from the front of the machine and set rolls so the material fits tightly. Retighten the thumb screws and remove the material from between the rolls.

TO ADJUST THE ROLLER - for the diameter of circle to be formed, raise the idler roll by pulling the cam lever toward the operator until the idler roll seems to "fall into place". Loosen the thumb screws next to the rear adjusting screws on the back of the roller. Set the idler roll by turning the rear adjusting screws. After the idler roll has been set for the desired angle of bend, tighten the thumb screws.

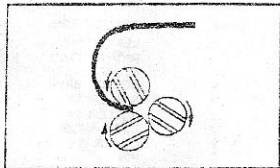
NO EXACT FORMULA - can be followed when making this adjustment because material "springback" varies with the kind of material being formed. Only by test forming several pieces can the correct adjustments be obtained. Rolls must be adjusted exactly parallel or the material will spiral during the rolling process.

TO OPERATE ROLLER - after diameter adjustments have been made, insert material from front of roller and turn operating handle in a clockwise direction until about half of the material has passed through the rolls, if roller is power operated make sure that the upper pinch roll is rotating in a counter clockwise direction. Then, while feeding material, raise the idler roll. Continue turning until a half circle has been formed. It is important that you operate the roller while engaging the

cam lever. For if the cam lever is engaged while the rolls are not turning, a noticeable flat spot or line will be formed across the width of the material.



AFTER HALF CIRCLE - has been formed, reinsert the formed end of the material into the roller (as illustrated) and turn operating handle in a clockwise direction to form a complete circle. If roller is power operated, turn switch in a position that allows the upper pinch roll to rotate in a counter clockwise direction.



FRONT AND REAR ADJUSTMENT SCREWS

The four adjusting screws (two located in the front and two located in the rear) have been built into the left and right side frames.

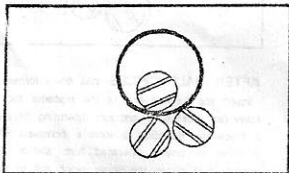
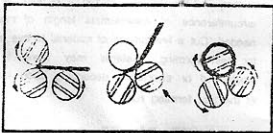
The two front adjusting screws enable the operator to raise or lower the pinch roll, so that the correct gap between the upper and lower pinch roll may be obtained to feed the desired stock into the machine.

The left and right rear adjusting screws assist the operator in raising or lowering the idler roll which determines the degree of bend in the stock that is being fed through the machine. The right and left side frames are each equipped with a scale to aid the operator in determining.

TO REMOVE THE FORMED PART-lift clamp handle and slide the support lever handle to the right. The upper pinch roll will rise. Slide the material off roll. If the material is not long enough or if the formed part is not the proper diameter, additional samples will have to be made. Thousands of identical parts can be precisely duplicated when proper adjustments of the roller have been made.

REVERSE ROLLING

CIRCLES-the same diameter as the diameter of the rolls and slightly larger, can be formed with the Roller in just one pass. To make the adjustment for material thickness and to determine the length of material needed, see the instructions given under "How To Form Circles in Just Two Passes".



PARTS LIST

PART. NO	DESCRIPTION	PART. NO	DESCRIPTION
1.	LEFT STAND	25.	BEARING
2.	RIGHT STAND	28.	ROLLER STAND
3.	STNAD BASE	27.	LEVER
4.	ROLLER BASE	28.	HANDLE COVER
5.	ROLLER 1#	29.	SCREW
5.	ROLLER 2#	30.	SCREW
7.	LOCK KNOB	31.	SCREW
8.	COVER	32.	LINCHPIN
9.	PIN	33.	WASHER
10.	CRANK HANDLE	34.	STUD
11.	ADJ.SCREW	35.	STUD
12.	GRIP SHAFT	36.	HANDLE KNOB
13.	DRAW BAR	37.	PIN
14.	KNOB	38.	NUT
15.	DRAW BAR STAND	39.	NUT
16.	ADJ.SCREW	40.	STUD
17.	GEAR	41.	WASHER
18.	ROLLER 3#	42.	STUD
19.	SHAFT	43.	NUT
20.	SHAFT	44.	PIN
21.	COVER LEFT	45.	SCREW
22.	COVER RIGHT	46.	NUT
23.	GEAR	47.	STUD
24.	GEAR LOCKING SHAFT	48.	WASHER

