

# SLIP ROLL

Model: W01-5116(50")



**ASSEMBLY & OPERATING INSTRUCTION**

## Specifications

1.1 Maximum capacity	50"
1.2 Minimum roll size	3"
1.3 Gauge	16gauge mild steel
1.4 Rod/wire grooves dia:	5/16", 3/8", 1/2"
1.5 Approx. ship. weight:	524lbs

### Save This Manual

You will need the manual for the safety warnings and precautions, assembly instructions, operating and maintenance procedures, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep the manual and invoice in a safe and dry place for future reference.

#### READ THIS INSTRUCTIONS BEFORE USING THIS TOOL

- 1. KEEP WORK AREA CLEAN.** Cluttered areas invite injuries.
- 2. CONSIDER WORK AREA CONNECTIONS.** Don't use tools in damp, wet, or poorly lit locations. Don't expose to rain. Keep work area well lit.
- 3. KEEP CHILDREN AWAY.** All children should be kept away from work area.
- 4. STOCK IDLE EQUIPMENT.** When not in use, tools should be locked up in a dry location to inhibit rust. If possible, store in an area out of reach of children.
- 5. USE THE RIGHT TOOL.** Don't force a small tool or attachment to do the work of a larger industrial tool. Don't use a larger industrial tool. Don't use a tool for a purpose for which it was not intended.
- 6. DRESS PROPERLY.** Don't wear loose clothing or jewelry. Non-skid footwear is recommended when working to prevent slipping. Wear protective hair covering to contain long hair.
- 7. USE EYE PROTECTION.** Wear approved impact goggles at all times when using this tool.
- 8. SECURE WORK.** Use clamps or a vise to hold the work if possible. It's safer than using your hands and it frees both hands to operate the tool.
- 9. DON'T OVERREACH.** Keep handles dry. Clean, and free from oil and grease. Follow instructions for lubricating and changing accessories.
- 10. MAINTAIN TOOL WITH CARE.** Keep handles dry, clean, and free from oil

and grease. Follow instructions for lubricating and changing accessories.

- 11. CHECK DAMAGE PARTS.** Before using any tool, any parts that appear damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and other conditions that may affect its operation. Any part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.
- 12. REPLACEMENT PARTS AND ACCESSORIES.** When serving, use only identical replacement parts. Only use accessories intended for use with this tool.
- 13. DON'T OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.** Read warning labels on prescription to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, don't operate machine.
- 14. NEVER STAND ON TOOL.** If tool is tipped over, serious injury or product damage could result.

## Unpacking

The 50 inch slip roll machine should come assembled when unpacked. Look for and loose parts in the packing material before discarding. If any are found ,try and find the part on the parts list or on the exploded view of the machine, and reinstall the part.

## Assembly and Adjustment

1. Mount the Slip Roll machine to a bench by bolting the base of the machine (#21) to the bench. Refer to illustration on page 7.
2. Adjust distance between Shaft 1 (#8) and Shaft 2 (#20) if necessary.
  - a. The distance between Shaft 2 (#20) and Shaft 1 (#8) can be adjusted by turning the Adjusting Bolts (#35)
  - b. To decrease the distance between the two shafts, turn the Adjusting Bolt (#35) clockwise.
  - c. To increase the distance, turn the adjusting bolt (#35) counter clockwise.

3. Adjust distance between Shaft 1 and Shaft 3 if necessary
  - a. The distance between Shaft 3 (#7) and Shaft 1 (#8) can be adjusted by turning the Adjusting Bolts (#22).
  - b. To decrease the distance between the two shafts, turn the Adjusting Bolts (#22) clockwise.
  - c. To increase the distance, between the two shafts, turn the Adjusting Bolts (#22)
4. Removal of Shaft 1 (#8) if necessary. The left end of Shaft 1 is mounted on a Square Bushing (#5), and the right end of Shaft 1 is mounted through the Right Stand (#9) into the Sleeve (#10).
  - a. To remove Shaft 1, remove the Sleeve (#10) off the right end of Shaft 1.
  - b. Next, at the top of the Left Stand, loosen Hex Bolt (#3).
  - c. Pull the right end of the Shaft 1 outward.
5. Remounting Shaft 1
  - a. Reinsert the right end of Shaft 1 into the hole in the Right Stand.
  - b. Tighten Hex Bolt (#3) on the top of the Left Stand.
  - c. Push the Sleeve (#10) onto the end of Shaft 1.

## **Operation**

Before using, check the mounting and adjustment of this machine. Rotate the Handle (#23) and check whether the four gears (#19, #30) have good, firm contact with each other. Shafts 1, 2 and 3 should be clean and free of metal debris. Refer to illustration below ,and on the last page.

### **Forming Rolls**

1. Insert the steel plate between Shaft 1 (#8) and Shaft 2 (#20).
2. Rotate the Handle (#23) to form the metal roll.
3. If the diameter of the metal roll is not correct, turn the Adjusting Bolts (#22) clockwise to decrease the diameter, of counterclockwise to increase the diameter of the roll.
4. To remove the finished roll, pull out Sleeve (#10) on the end of Shaft 1 (#8), nearest the Handle (#23), and swing Shaft 1 out of the Right Stand. Then remove the steel roll from Shaft 1.

## Forming Rings

The half-round slots on the right side of Shaft 2 (#20) and Shaft 3 (#7) can be used to form rings of various dimensions.

1. Insert the steel in half-round slot of Shaft 2 (#20) or Shaft 3 (#7).
2. Rotate the Handle (#23) to form the metal ring.

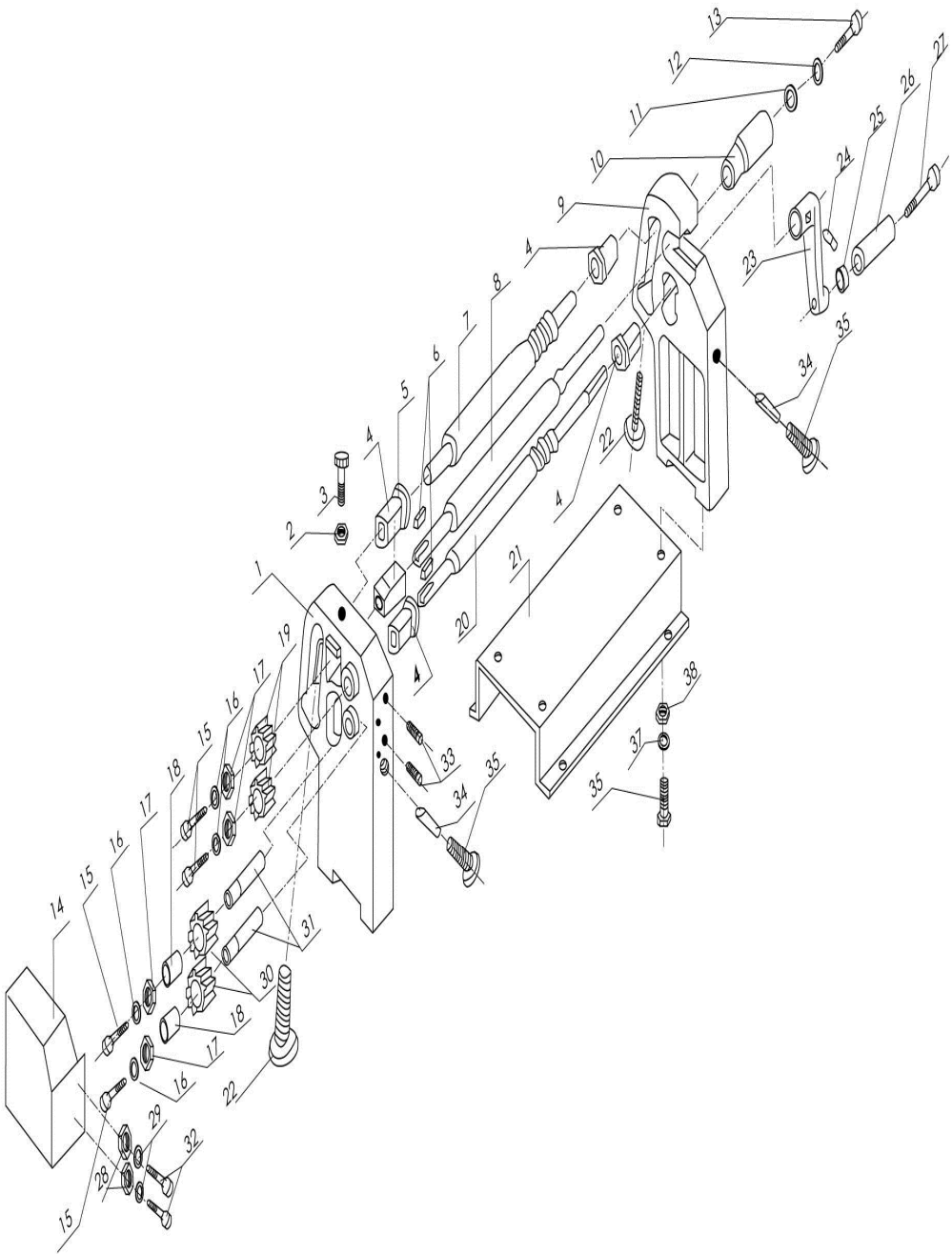
**WARNING:** Keep the hands away from the shafts and metal plate during operation. Do not attempt to form rolls from materials other than those specified.

## PARTS LIST

Part #	Description	Qty
1	Left Stand	1
2	Nut M12	1
3	Hex Bolt	1
4	Support Bushing	4
5	Square Bushing	1
6	Flat Key	3
7	Shaft 3	1
8	Shaft 1	1
9	Right Stand	1
10	Sleeve	1
11	Washer	1
12	Spring Washer	1
13	Screw	1
14	Cover	1
15	Hex Bolt	4
16	Spring Washer	4
17	Washer	4
18	Bearing	1
19	Small Gear	2
20	Shaft 2	1
21	Base	1
22	Adjusting Bolt	2
23	Handle	1
24	Locking Screw	1
25	Hex Nut	1
26	Handle Bushing	1

27	Hex Bolt	1
28	Washer	2
29	Spring Washer	2
30	Large Gear	1
31	Small Shaft	1
32	Hex Bolt	2
33	Locking Screw	2
34	Pin	2
35	Adjusting Bolt	2
36	Hex Bolt	4
37	Spring Washer	4
38	Flat Washer	4
39	Gear	1
40	Long shaft	1
41	Bushing	1

# Assembly Drawing



Note: This manual is only for your reference. Owing to continuous improvement of the machines, Changes may be made at any time without obligation on notice.



