

**Before Operating Your Tools,
Please Read This Instruction Carefully**



Slip Roll

**ITEM NO.61- 251-129
MODEL NO . #SR24/SR50**

Content

How To Form Circles In Just Two Passes	3
To Adjust Roller For Material Thickness	3
To Adjust Roller For The Diameter Of Cylinder	3
To Adjust Roller For The Diameter Of Cylinder	3
Front And Rear Adjustment Screws	4
Reverse Rolling	4
Parts Drawing	5
Parts List	6

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:

$$C = \delta D$$

C is circumference.

δ 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

For different material thickness, loosen the thumb screw to the right of the adjusting screws.

Tune 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 Roller For The Diameter Of Cylinder

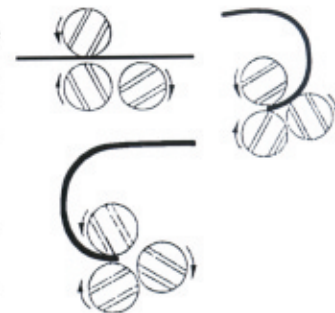
For the diameter of circle to be formed, raise the idler roll by pulling the cam lever toward the operator until the idler roll seems to "fall into place". Loosen the thumb screws next to the rear adjusting screws on the back of the roller. Set the idler roll by tuning the rear adjusting screws. After 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 Adjust Roller For The Diameter Of Cylinder

After diameter adjustment 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.

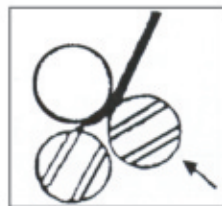
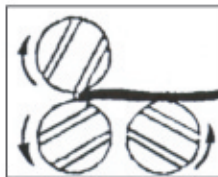
The two front adjusting screws enable the operator to raise or lower the pinch roll, so that the correct gap between the upper and lower pinch roll may be obtained to feed the desired stock into the machine.

The left and right rear adjusting screws assist the operator 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.

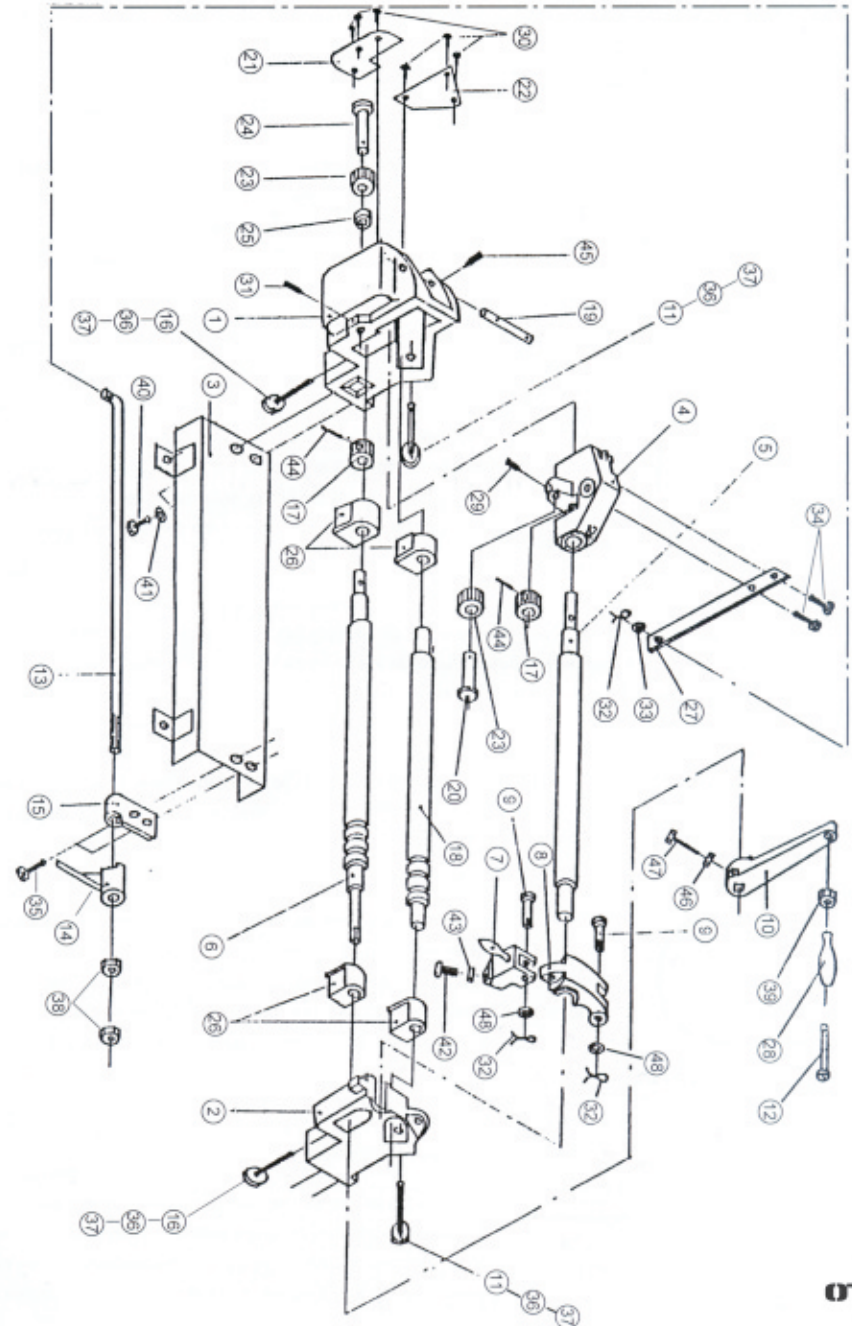
To Remove The Formed Part- lift clamp handle and slide the support lever handle to the right. The upper pinch roll will rise. Slide the material off roll. If the material is not long enough or if the formed part is not the proper diameter, additional samples will have to be made. Thousands of identical 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 DRAWING




PARTS LIST

PART#	DESCRIPTION	PART#	DESCRIPTION
1	LEFT STAND	35	STUD
2	RIGHT STAND	36	HANDLE KNOB
3	STAND BASE	37	PIN
4	ROLLER BAE	38	NUT
5	ROLLER 1#	39	NUT
6	ROLLER 2#	40	STUD
7	LOCK KNOB	41	WASHER
8	COVER	42	STUD
9	PIN	43	NUT
10	CRANK HANDLE	44	PIN
11	ADJ.SCREW	45	SCREW
12	GRIP SHAFT	46	NUT
13	DRAW BAR	47	STUD
14	KNOB	48	WASHER
15	DRAW BAR STAND		
16	ADJ.SCREW		
17	GEAR		
18	ROLLER 3#		
19	SHAFT		
20	SHAFT		
21	COVER LEFT		
22	COVER RIGHT		
23	GEAR		
24	GEAR LOCKING SHAFT		
25	BEARING		
26	ROLLER STAND		
27	LEVER		
28	HANDLE COVER		
29	SCREW		
30	SCREW		
31	SCREW		
32	LINCHPIN		
33	WASHER		
34	STUD		