TTC

Slip Roll

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Before Operating Your Tools,
Please Read This Instruction Carefully

ITEM NO.61-251-130
MODEL NO .SR50

Slip Roll

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SPECIFICATION

Name:	50" x16 Gage Slip Rolls
Length Capacity:	50"
Rolling Thickness Capacity:	16 Gages
Min.Radius:	1-1/2"
Weight:	506lbs.

HOW TO FORM CIRCLES IN JUST TWO PASSES

Length of material necessary to form the desired size circle is he first consideration in circle forming. To determine approximate length of material needed, use the formula:

$C = \pi D$

C is circumference.

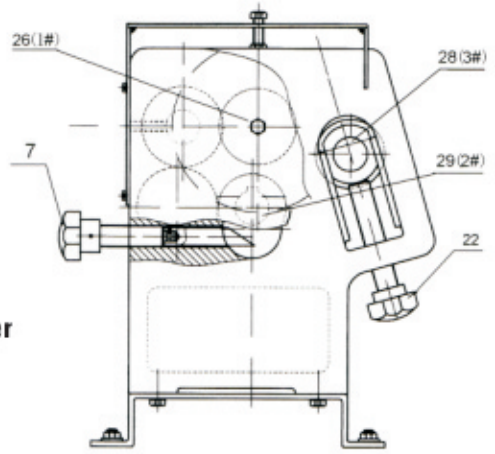
π equals 3.1417.

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

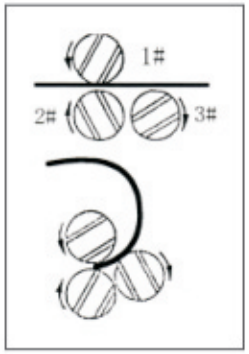
For different material thickness, adjust the 2# roller to right position to roll the sheet correctly.Turn the setting screw (Part# 7) to raise or lower the 2# pinch roller (Part# 29). Insert the material between the rollers(1# & 2#) from the front of the machine and set rollers so the material fits tightly. Fasten the setting screws and remove the material from 1# & 2# rollers



TO ADJUST ROLLER - for the diameter of cylinder

For the diameter of cylinder, adjust the 3# roller to right position to roll the sheet to right diameter. Loosen the setting screws (Part#22) at the end of left and right stands, set the 3# idler roller (Part# 28) to right Position which will determine the diameter of cylinder), after the 3# idler roller has been set for the desired diameter, fasten the setting screws (Part# 22). No Exact Formula – can be followed when making this adjustment because material "springback" varies with the kind of material being fromed. 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 adjustment have been made, insert material from front of 1# & 2# rollers and turn operating handle in a clockwise direction until about half of the material has passed through the rolls. After half circle has been formed, reinsert the formed end of the matrial into the roller (as illustrared) and turn operating handle in a clockwise direction to form a complete circle.

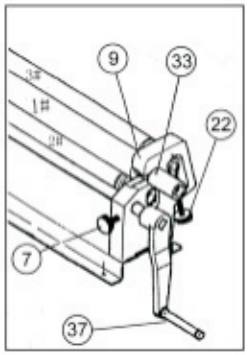
FRONT AND REAR ADJUSTMENT SCREWS

The four setting screws (two located in the front(Part# 7) and two located in the rear (Part# 22) have been built into the left and right side stands.

The two front setting screws (Part# 7) enable the operator to raise or lower the pinch roller (Part# 29), so that the correct gap between the upper(1# roller) and lower pinch roller(2# roller) may be obtained to feed the desired stock in into the machine.

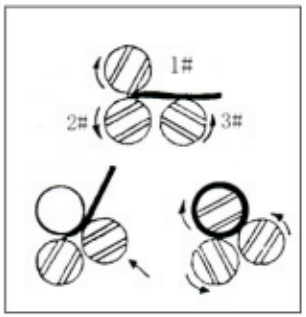
The left and right rear setting screws (Part# 22) assist the operator raising or lowering the idler roller(3# roller) which determines the diameter of bend in the stock that is being fed through the machine.

TO REMOVE THE FORMED PART



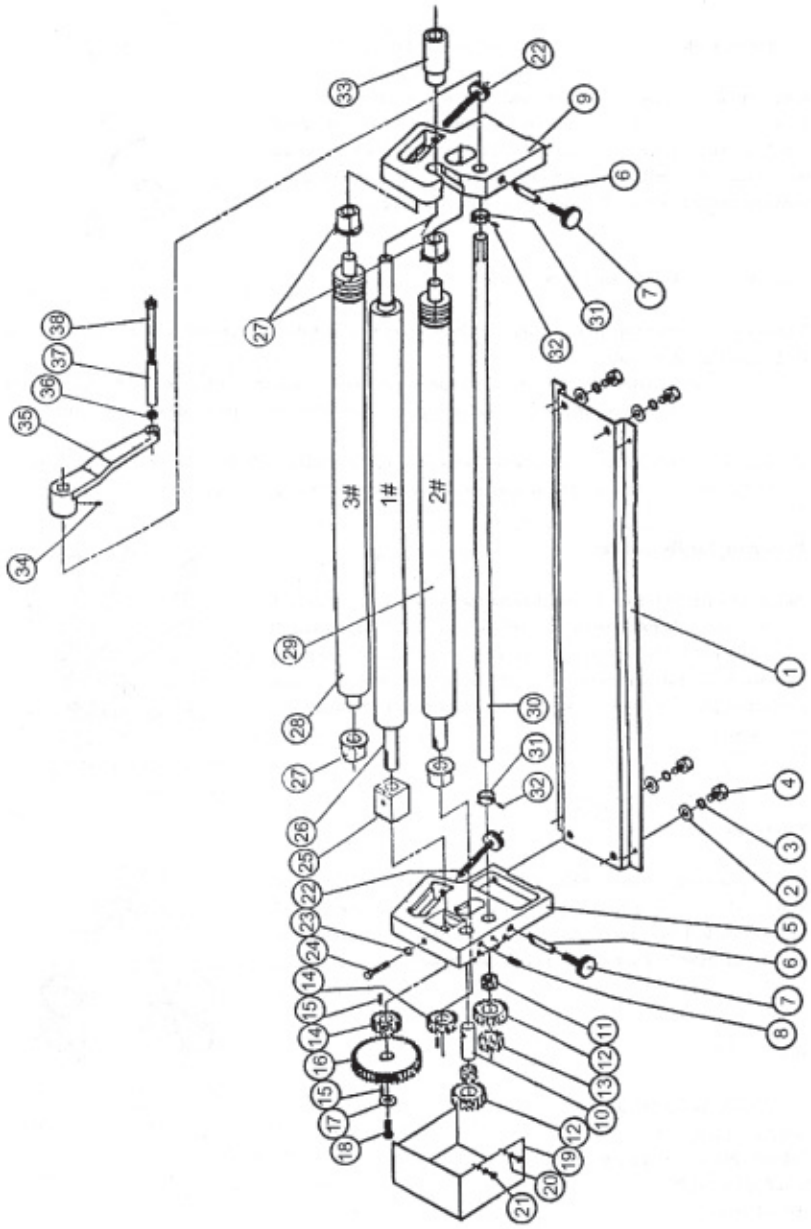
Pull out 1# roller bush (Part# 33) which fasten the 1# roller in the right stand, and then slide the 1# roller out from the right side stand, pull the material off roller. If the material is not long enough or if the formed part is not the proper diameter, additional samples will have to be made. Thousands of identical parts can be precisely duplicated when proper adjustments of the roller have been made.

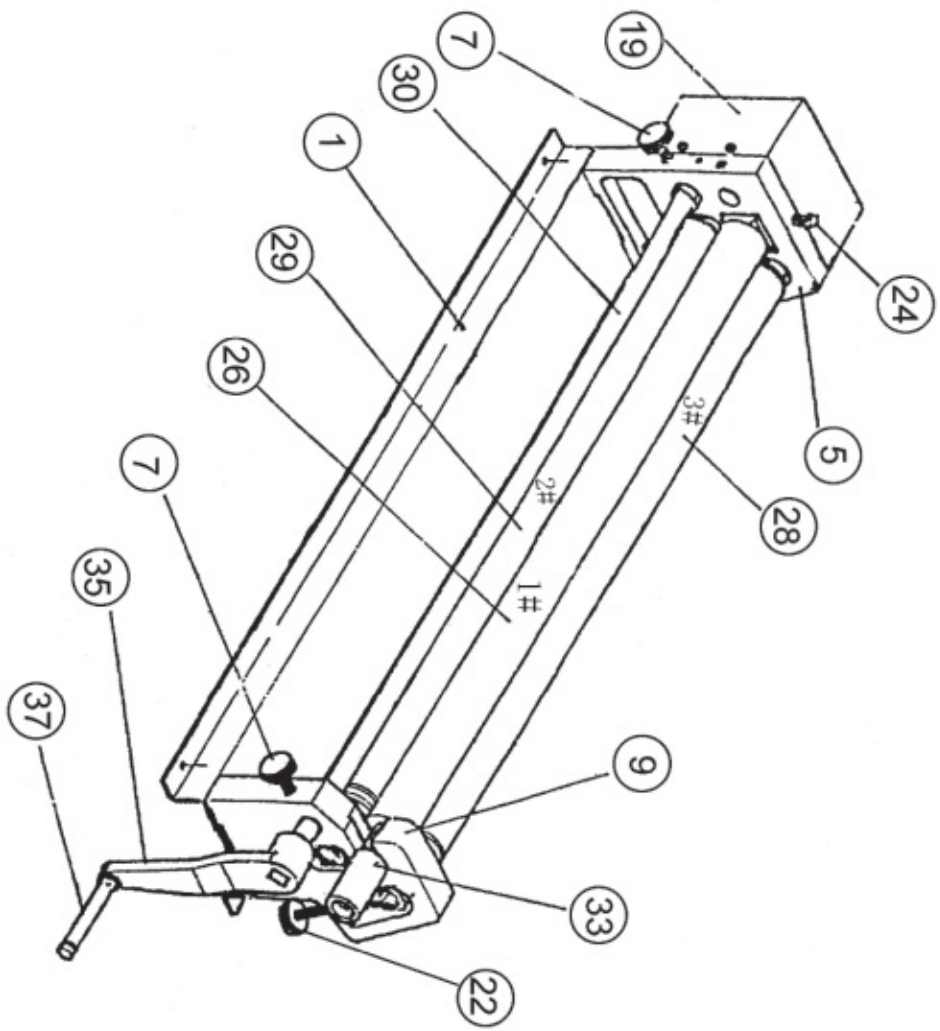
REVERSE ROLLING



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
1	BASE
2	WASHER
3	SPRING WASHER
4	HEX SCREW
5	LEFT STAND
6	PUSH SPINDLE
7	SETTING SCREW
8	LOCKING SCREW
9	RIGHT STAND
10	GEAR LOCKING SHAFT
11	BEARING
12	GEAR
13	GEAR
14	GEAR
15	KEY
16	GEAR
17	WASHER
18	HEX SCREW
19	GEAR COVER
20	SPRING WASHER
21	HEX SCREW
22	3# ROLLER SETTING SCREW
23	HEX MUT
24	HEX SCREW
25	1# ROLLER BASE
26	1# ROLLER
27	2# OR 3# ROLLER BASE
28	3# ROLLER
29	2# ROLLER
30	SHAFT
31	HANDLE LOCKING BUSH
32	LOCKING SCREW
33	1# ROLLER BUSH
34	HEX SCREW
35	CRANK HANDLE
36	HEX NUT
37	GRIP BUSH
38	GRIP SHAFT