HARE&FORBES
MACHINERYHOUSE

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S268 SRG 24 X 40 X 1MM

24" SLIP ROLL

OPERATION MANUAL

23-01-2003

S268 HAND ROLLS SRG24X40 1MM

24" SLIP ROLL

OPERATION MANUAL

Operation manual

1. Capacity

24"slip roll is a kind of sheet-metal machine to form scrolls. It can make the minimum scroll diameter 1-1/2"×24"long, as well as a ring, from all the sheet of low carbon steel and non-ferrous material.

2. Specifications:

2.1 Working capacity

2.1.1 Low carton steel sheet: thickness 0.03937 inches, width 24".

2.1.2 Non ferrous sheet: thickness 0.05906 inches, width 24".

2.2 Net weight: 83.6 IBS.

2.3 Dimensions (L×W×H): 39.37"×8.268"×13"

3. Installation and adjustment

3.1 Please fix the base of the machine on a stale work bench.

3.2 To adjust the clearance between drive roll (part No. 20) and idle roll (part No. 8), please may screw adjust bolt (part No. 35) in or out. Screwing in. the clearance will decrease. On the other hand. it will increase.

3.3 To adjust the clearance between idle roll (part No. 8) and back roll (part No. 7), please may screw adjusting bolt (part No. 22) in or out. Screwing in, the clearance will decrease. On the other hand. it will increase.

3.4 Installation of idle roll (part No. 8)

The left and of idle roll (part No. 8) is supported in the square block (part No. 5) and the right is in the hole of right frame (part No. 9). Pulling out free hand (part No. 10) and loosing hexagonal blot (part No. 3), the idle roll will swing on the left guide-way.

To remount the idle roll. please pull handle (part No. 10) out at first. Then put the idle roll in the middle hole of right frame (part No. 9). At last, please push the free handle (part No. 10) in the right frame.

4 Operation

4.1 Before use, please check the installation and adjustment, swinging the crank handle (part No. 23) without load, inspecting the engagement of the four gears (part No. 30; 2 pieces each), washing or rubbing the rolls (drive roll. Idle roll, back roll).

4.2 Working procedures

4.2.1 After adjusting the roll to the proper clearance, please feed a sheet between the drive roll (part No. 20) and the idle roll (part No. 8), swing the crank handle (part No. 23). And then the scroll will be formed . If you find the diameter of the scroll worked does not conform to the requirement , please adjust the adjusting bolt (part No. 22) to get the required diameter . Screwing in adjust bolt (part No. 22), the diameter will increase.

On the other hand , it will decrease.

4.2.2 To get the scroll off the machine, pleast pull the free handle (part No. 10) out , then close to the operator . After getting the idle roll (part No. 8) out of the middle hole of the right frame (part No. 9), you will have the scroll worked.

4.2.3 Remount the idle roll (part No. 8). Please refer to part 3.4

4.3 Notes:

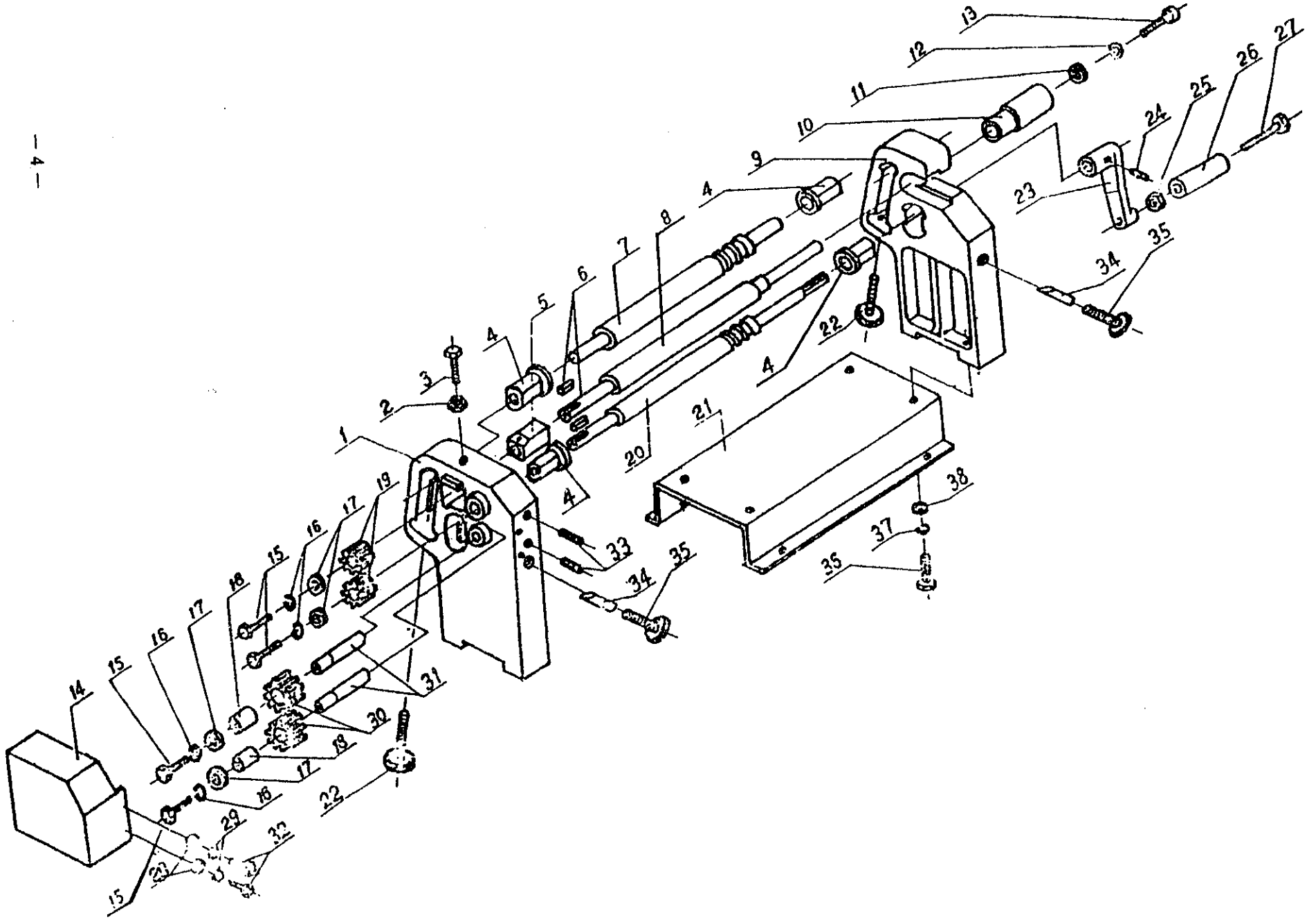
4.3.1 To avoid any hurt , please get your hands away from the machine when it is working .

4.3.2 Please don't feed any unworkable materials between the rolls . Otherwise. the rolls will be damaged.

4.3.3 You may do the rings with wire grooves on the right ends of the drive roll (part No. 20) and the back roll (part No. 7). But any work beyond the capacity of the machine should not be done . Otherwise , the machine will be damaged.

5. PARTS LIST

Items No.	Descriptions	Sizes	Quantity
1	Left Frame		1
2	Nut	M12	1
3	Hexagonal Bolt	M12×40	1
4	Support Bush		4
5	Square block for idle roll		1
6	Flat Key	4×20	2
7	Back Roll		1
8	Idle Roll		1
9	Right Frame		1
10	Free Handle		1
11	Flat Washer	8	1
12	Spring Washer	8	1
13	Screw	M8×16	1
14	Cover		1
15	Hexagonal Bolt	M8×16	1
16	Flat Washer	8	4
17	Spring Washer	8	4
18	Roller Bearing	7942/20	2
19	Pinion Gear		2
20	Drive Roll		1
21	Base		1
22	Adjusting Bolt		2
23	Crank handle		1
24	Screw	M6×10	1
25	Hexagonal Bolt	M10	1
26	Sleeve for handle		1
27	Hexagonal Bolt	M10×110	1
28	Flat Washer	6	2
29	Spring Washer	6	2
30	Gear		2
31	Shaft		2
32	Hexagonal Bolt	M6×10	2
33	Screw	M8×30	2
34	Pin		2
35	Adjusting Bolt		2
36	Hexagonal Bolt	M12×20	4
37	Flat Washer	12	4
38	Spring Washer	12	4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