

LockFormer / Auto Glide Power Flanger

Operating Instructions

The operation of the machine is dependent upon proper gauge settings. The heavier materials require a greater spring pressure than the lighter and the settings can be made by turning the rear adjusting dial (43412) counter clockwise until a stop is reached. Then turn adjusting dial clockwise the proper amount of turns as indicated in chart #1, at right.

CHART #1

With Rear Adjusting Handle (43412) all the way out (counter clockwise movement), settings for gauges are as follows:

SETTINGS-Clockwise	TO-
1/2 to 1 turn	24-26 ga
1-1/2 to 2 turns	20-22 ga
2-1/2 to 3 turns	18 ga
3-1/2 to 4 turns*	16 ga

*Adjustment for 16ga material only.

The 14701 Adjusting Dial sets the proper clearance between the Knurled Forming Roll (11613) and Plain Forming Roll (11612). To operate machine properly, adjust the dial to thickness of material to be used and feed material with lead edge preformed into the rolls. (Preforming can be done by inserting material into slot cut into lower right of machine table top.) Proper adjustments will result with a smooth regular flange. Too much pressure will create a "buckled" flange showing a heavy knurl marking @ on flanged edge of the material. Insufficient pressure will cause material to slip in the rolls and not be powered through the machine.

The buckled flange can also be caused by too much pressure being exerted by the pressure arm (40070). Consult setting chart in manual or data on machine. A slight change of the above- settings may have to be made to suit variances in material.

An irregular flange on curve surfaces would be caused by not enough pressure on the pressure arm and the dial setting should be increased by a clockwise adjustment.

A section of material formed with a buckled flange can be corrected by moving Auto Guide lever arm roller assembly back and out of position. Then start flange back through the machine. -Do not apply any pressure to material - but only support piece as it goes through machine.

To eliminate galvanized accumulation on knurled forming roll it may be necessary from time to time to apply either kerosene or a light machine oil to the knurled roll. This will aid in keeping the roll from an over deposit of galvanized material. If galvanized material packs into knurl recesses it is desirable to clean this part with a scraping tool or wire brush and then oil.

When running materials, other than cold roll steel or galvanized, e.g. aluminum stainless or copper, a slight modification of the standard settings may be required to operate properly.

For Running: Aluminum, Copper (soft) Materials:

The above materials will require a looser setting on both the front gauge (thickness) setting and pressure setting (spring pressure). Experience or test settings will be required.. Should material shear at the corner, the damage could be caused by excessive pressure or metal pick-up and "galling" on the lifter button.

Where "galling" or metal pick-up is evident, the material will require lubrication to the part of the material being formed. Lubricants such as kerosene or a light machine oil should prove adequate.

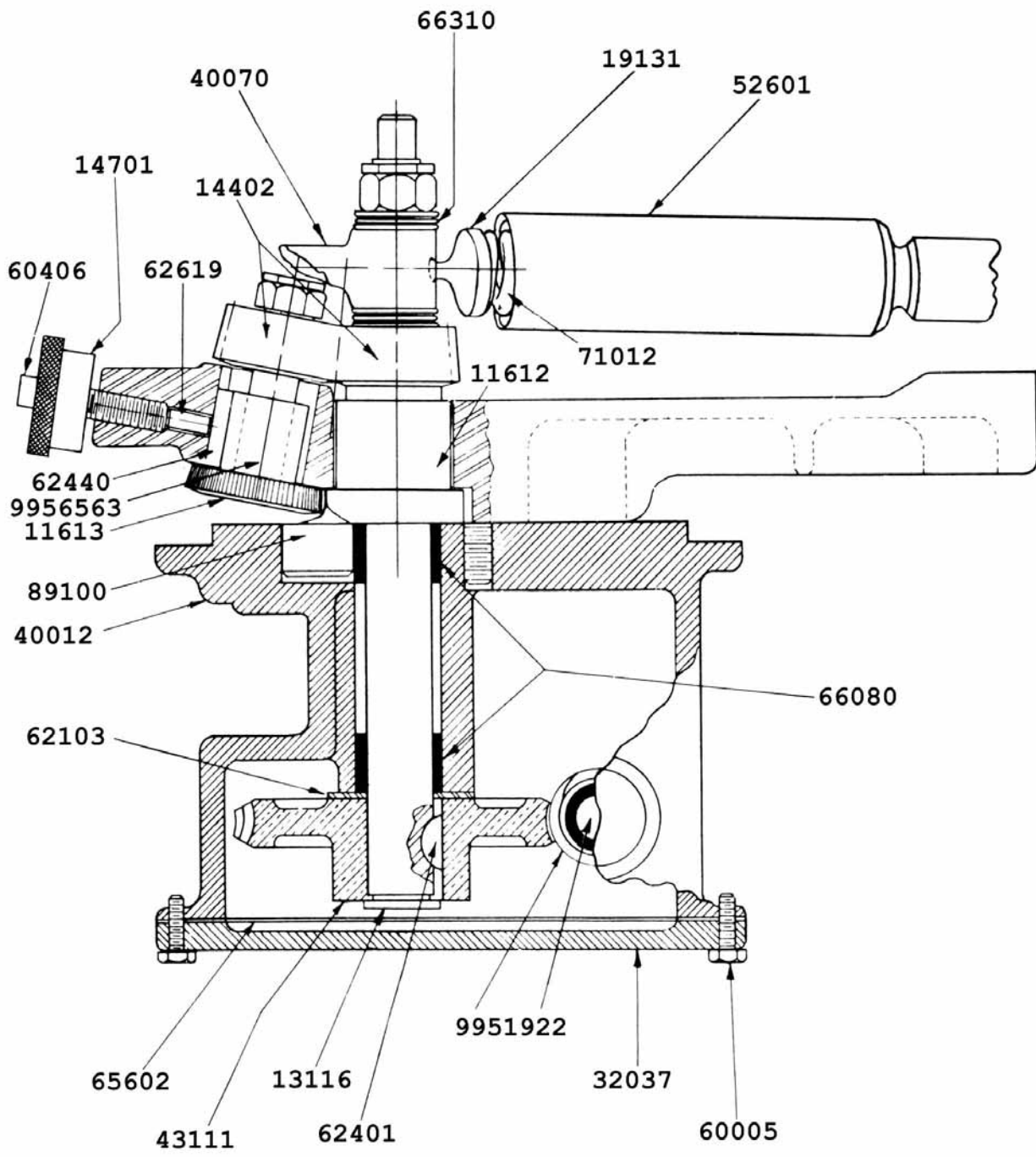
For Running: Stainless Steel or Hard Brass Materials:

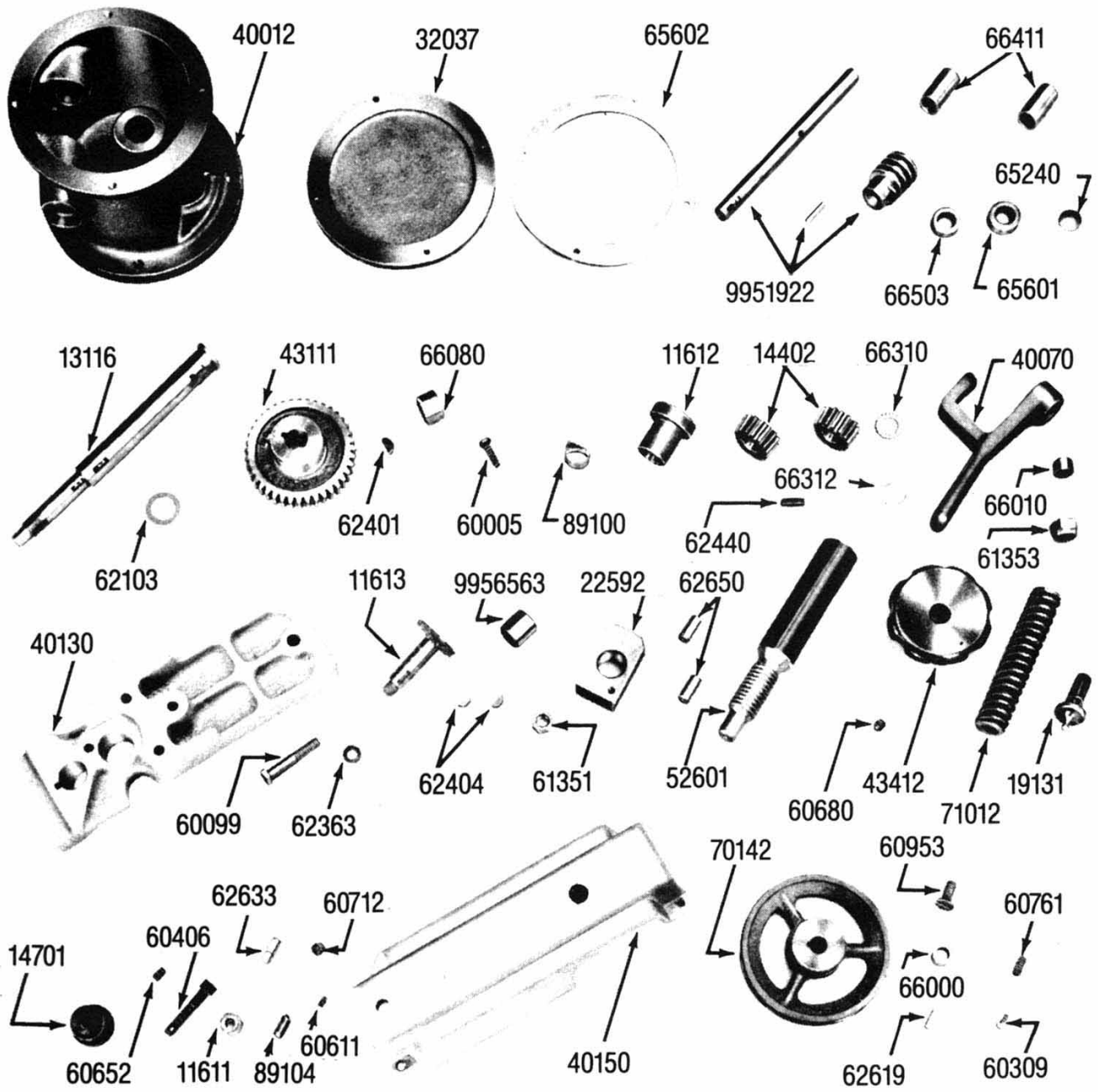
Increased spring pressure may be required for running certain types of stainless. A standard thickness setting is adequate. A drawing compound may be necessary to eliminate pick-up. A special aluminum bronze lifter button may be necessary for prolonged use of stainless materials. (A special quotation would be required for this button.)

MODELS 16 AND 18 GAUGE AUTO GUIDE
PARTS LIST

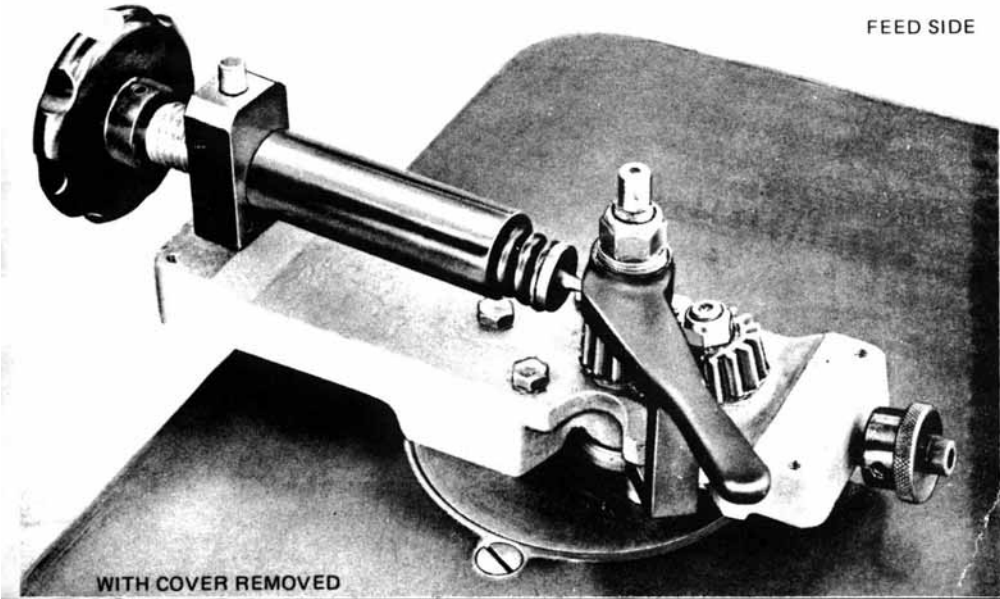
New Part No.	Description	Pieces Per Unit	New Part No.	Description	Pieces Per Unit
40012	Gr. Hsg. AG 88010 1		62619	1/4 x 1' DW1	1
32037	Hsg. Cvr. AG 88020	1	11611	Adj. Guide Roll	1
65602	Gskt. 15028	1	62633	318 x 1 DWL	1
9951922	Sti. Worm Gr. Assy.	1	89104	Sensory Cstg.	1
66503	605 Thrust Brg.	1	60712	7/16-20 x 318 SSS Cup	1
66411	AA832-5 Am plx. Brg.	2	60611	1/4-20 x 3/8 SSS	1
65240	7/8 Freeze Pig.	1	40150	Topcvr. AG 88150 1	
65601	Oil Seal 6260	1	66000	B88 Torr Brg.	1
13116	Drv. Shft. 1		60309	114-20 x 1/2 SHCS 4	
62103	7/8 x .025 Wshr.	1	60761	5/16-18 x 3/4 Sq. HSS	1
43111	Worm Gr. Brz. 70854	1	*58514	Stand Assy.	1
62401	9 Wdrf. Key	3	*29469	Mtr. Base 2	
66080	B1412 Torr. Brg.	2	*80030	3/4 HP 1 60 18 66 1	
60005	1/4-20 x 3/4 HHCS 5		*70140	AC 33 x 518 Shv. 1	
89100	Raw Lift Btttn.	1	*70142	AC 53 x 5/8 Shv.	1
11612	PI. Form Roll	1	*70027	4L560 Belt	1
14402	Gr. Bvl.	2	*80481	Bx. Conn. 1/2	2
62404	61 Wdrf. Key	2	*80431	Bx. Cable 14-2 x 42	1
66310	NTA1018 Torr. Brg.	2	*60875	3/8-16 x 1CB	4
40070	Co m p. Arm AG 8B070	1	*61120	3/8-16 HN Hvy. Sf.4	
66010	Bl 08 Torr. Brg.	3	*80204	Toggle Swch. 5011 1	
6133	5/8-18 Stop Nut	1	*80675	Handy Box Cvr.	1
40130	Form Hd. AG 88130	1	*60048	5il6-18 x 1 1/4 HHCS	4
60099	3/8-16 x 2 114 HHCS	3	*60576	10-24 x 1/2 RHMS 1	
62363	3/8 Lck. Wshr.	7	*60795	4 x 3/16 Dr. Scr. TP-U	4
11613	Knrl. Roll	1	*60797	4 x 1/4 D4 Scr. TP-U	8
9956563	Inner Race Assy.	1	*60953	3/8-16 x 1 FHSCS 4	
61351	1/2-20 Stop Nut	1	*61101	5/16-18 HN Hvy. SF.	4
22592	Adj. Pvt. Nut	1	*62010	5/16 x 1/16 Wshr. 8	
62650	1/2 x 1 DWL	2	*62029	3/8 x 1/16 Wshr.	4
52601	Adj. Spring Tube	1	*62362	5/16 Lck. Wshr.	4
43412	Adj. Handle. 709121		*62370	1/4 Lck, Wshr.	4
60680	3/8-16 x 318 SSS	1	*66312	TRB1018 Torr. Race	4
71012	Comp. Sprg.	1	*80483	Bx. Conn. 3/8	2
19131	Spr Pvt. Rod	1	*80525	Cord Set 14-3 10	1
62440	Cncv.Key	1	*80602	Rg. Tng. Terminal 2	
14701	Adj. Dial 1		*80607	Insulating Cap	1
60652	5/16-18 x 1/2 SSS 1		*80608	Wire Joint	1
60406	3/8-16 x 1-3/4"SHCS	1	*80650	Handy Box 4SS1	1
			*85151	AG Pf. Name Plate 1	
			*85162	Instruction Plt	1
			*85164	Lckform Logo	1
			14702	Adj. Dial 1	
			80020	1/2 HP-1-60-18-56 1	

*Not Illustrated





FEEED SIDE



WITH COVER REMOVED