Lockformer / 20 Gauge Auto Guide Power Flanger

INSTALLATION

1. Place Flanger over Power Unit Plate so that the Idler Gear of the Flanger meshes with the Driven Gear of the Power Unit.

2. Place two cap screws in the costing mounting holes and tighten costing to the plate.

3. Fasten the back cover With sheet metal screws provided.

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 #l, at right.

CHART ttl

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. (Prefoming 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.

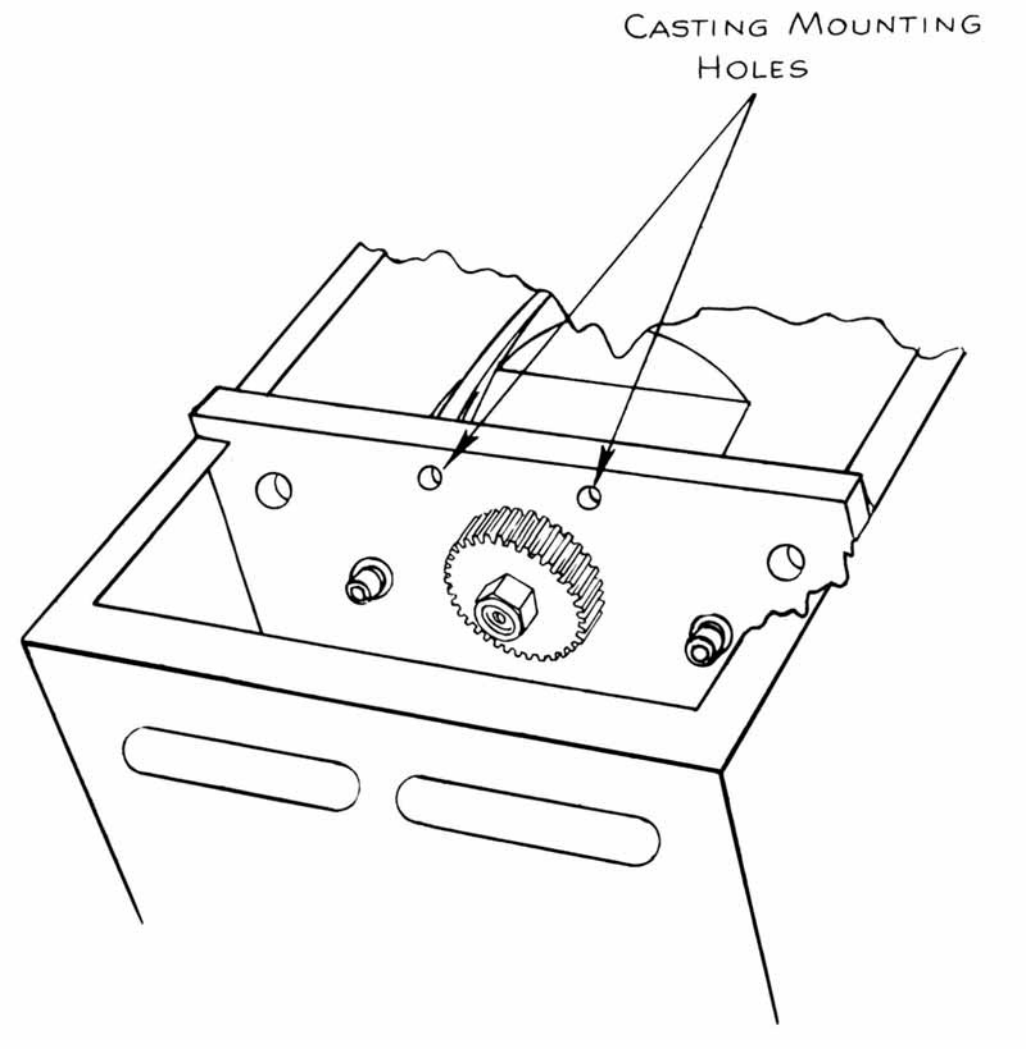
For Running: Aluminum, Copper (soft) Materials:

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.

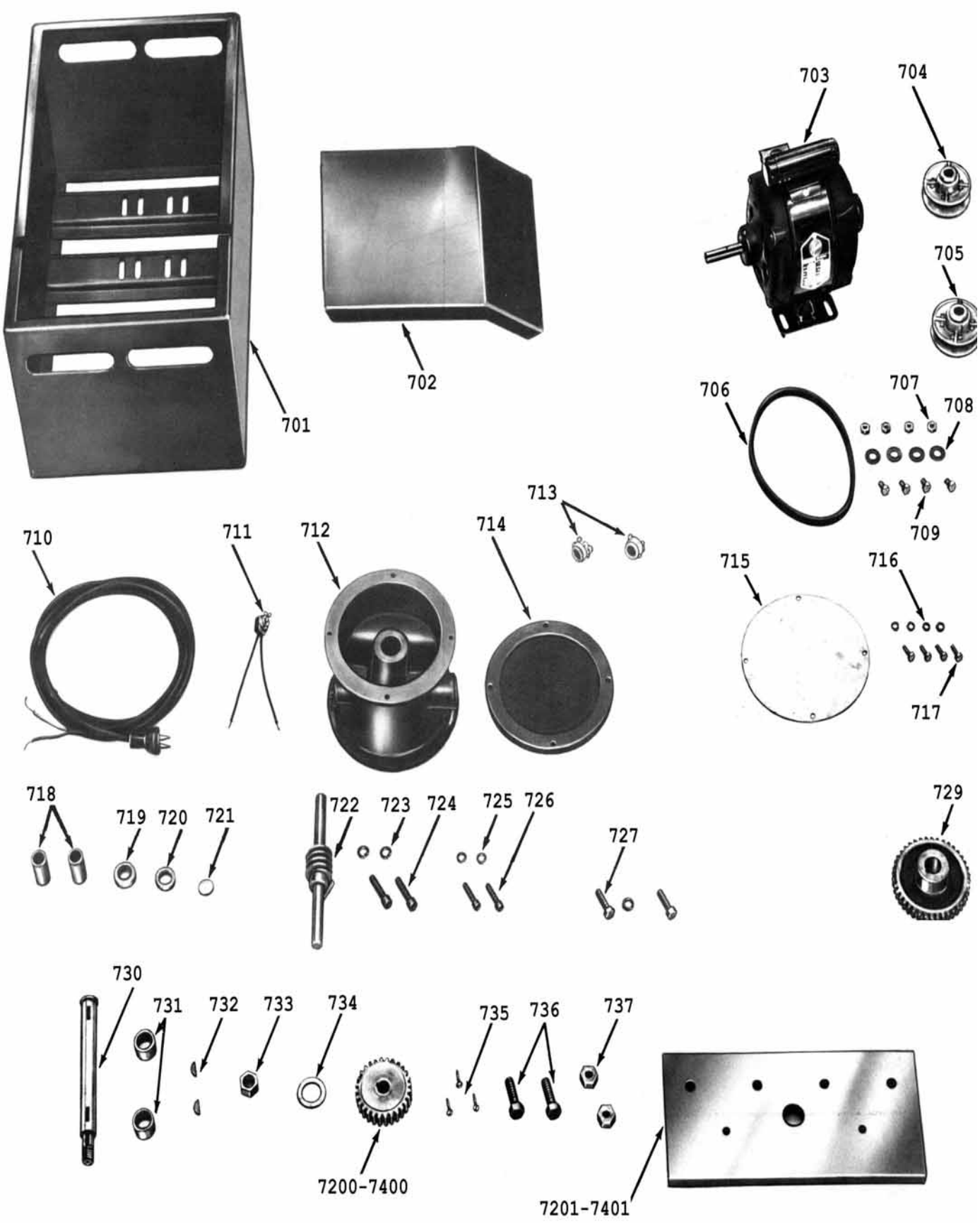
Where "galling" or metal pick-up is evident, the material will require lubrication to the part of the material being formed. Lubricants such as kerosene or a light machine oil should prove adequate.

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.)



New Part No.	Old Part No.	Description	Pcs. Per Unit
50022	701	Stand	1
35327	702	Back Cover	1
80010	703	Motor 1/3 HP lPh 60 CY	1
70137	704	Sheave Motor	1
70142	705	Sheave Reduction	1
70021	706	V-Belt	1
61100	707	5/16" Nut	4
62010	708	Washer 5/16 x 1/16	8
60047	709	5/16" - 18 3/4" H.H.C.S.	4
80535	710	Cord	1
80206	711	Toggle Switch	1
40011	712	Gear Housing	1
80481	713	Bx Connectors	2
40020	714	Housing Cover	1
65602	715	Housing Gasket	1
62370	716	1/4" Lock Washer	4
60005	717	1/4" - 20 x 3/4" H.H.C.S.	4
66411	718	Bearing	2
65601	719	Oil Seal	1
66503	720	Thrust Bearing	1
65240	721	Freeze Plug	1
51922	722	Worm Gear Assembly	1
62363	723/728A	3/8" Lock Washer	6
60408	724	3/8" - 16 x 1-3/4" S.H.C.S.	2
62363	725	5/16" Lock Washer	4
60097	727A	3/8" - 16 x 1-3/4" H.H.C.S.	2
60155	727B	1/2" - 13 x 1-3/4" H.H.C.S.	2
62364	728B	1/2" Lock Washer	2
43111	729	Bronze Worm Gear	1
13101	730	Drive Shaft	1
66080	731	Bearing	2
62401	732	Woodruff Key	3
61204	733	5/8" Hex. Nut - 18 NF	1
62105	734	7/8 . 10 x.050 Washer	8
60821	735	Sheet Metal Screws	4
60090	738	3/8" - 16 x 3/4" H.H.C.S.	4
14225	7200	20-22 GA. AG Gear	1
20351	7201	20-22 GA. AG Plate	1
50904	7202	20-22 GA. Forming Table	1
14201	7400	Driver Gear	1
20352	7401	24 GA. Slitter Plate	1
50905	7402A	AG Forming Table	1
60575		10-24 x 3/8" R.H.M.S.	1
89102		Lifter Button	1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