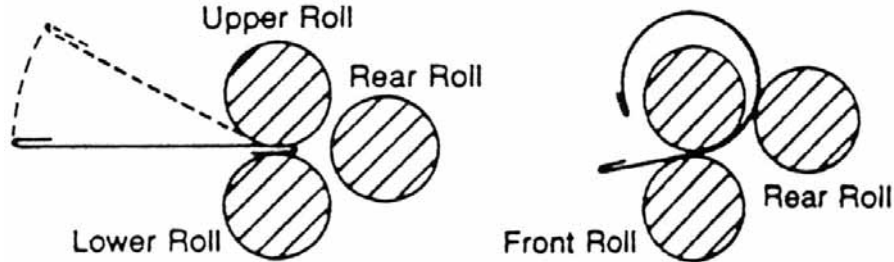


# Instructions on the No. 0381, 381, 382, 383 Slip Roll Formers

## INSTRUCTIONS

**CAUTION:** Be sure that the machine is securely bolted onto pedestal or to customer supplied bench. Pedestal or work bench should be bolted to floor.



1. Adjust Lower Roll (24) to grip the metal firmly and evenly but without straining the machine. Lower Roll (24) is adjusted up or down with the two lower Adjusting Screws (7).
2. Adjust Rear Roll (25) to form the metal up as it travels through the rollers. Rear Roll (25) is adjusted up or down with the two rear Adjusting Screws (7). Be sure Rear Roll (25) is parallel with Lower Roll (24). If rolls are not parallel, the formed metal will be conical in shape instead of cylindrical.
3. Feed the stock to the rolls only from the front.
4. As the front rolls grip the stock, lift the rear end of the metal upward. This will help reduce the flat spot on the leading edge of the sheet and will also cause the leading edge to pass over the rear roll readily.
5. The diameter of the formed cylinder is determined by the position of the Rear Roll (25). To increase the diameter of a cylinder, lower Rear Roll (25) by turning the two rear Adjusting Screws M counter clockwise. To reduce the diameter of a formed cylinder. raise Rear Roll (25) by turning the two rear Adjusting Screws (7) clockwise. The two rear Adjusting Screws (7) should be turned an equal number of turns in order to keep the Rear Roll (25) parallel with the front gripping rolls.
6. To remove a cylindrical piece without distorting it, lift up Locking Handle (19), raise Right Hand Housing Cap (1/2) and turn Cam Handle (6) down. This raises the outboard end of the Upper Roll (23) and allows the formed cylinder to be slipped off of the Upper Roll (23).
7. The lower Roll (24) and the Rear Roll (25) have grooves of varying widths in one end. These are for the purpose of accomodating a wired edge when forming a shape or when forming wire into a ring.
8. "X" points should be lubricated daily with a good grade machine oil. "Y" points should be greased weekly with Alemite #33 or equal.

Item No.	No. Req'd	Catalog No.	Description	No.	Req'd	No.	Description
1/1	1	267940011	Right Hand Housing A	11	2	767380109	Compensating Gear (10852)
1/2	1		Cap. R.H. Housing	12	1	767680111	Upper Compensating Gear Stud
1/3	1		Pin	13	1	767680112	Lower Compensating Gear Stud
			3/32 x 5/6 Cotter Pin	14	1	767160113	Rocking Box Pin
2	1	767490101	Left Hand Housing	15	1	767030114	Lifting Lower
3	1	767170102	Rocking Box	16	1	76722115	Front Cover Plate
4	4	767170103	Box	17	1	767220116	Rear Cover Plate
5	1	767210104	Cam	15	2	767630117	Lower Roll Spacer
6	1	767210105	Cam, Handle	19	1	267990001	Locking Handle
7	4	767650175	Adj. Screw	20	1		Pin
8	2	601012173	3/8-16 x W4 Hex Head Cap Screw	21	1		Locking Handle Screw
9	1	230700008	Crank Assembly, Hand	22	2	600134001	1/8 Sit. Alemite Fitting
9/1	1	767460096	Crank	23	1	767630080	Upper Roil - 0381
9/2	1	6403WOS	Handle	23	1	767630079	Upper Roll - 381
9/3	1	767210097	Stale. Crank	23	1	767630081	Upper Roll - 382
9/4	1	621012132	5/16 - 18 x 7/8 Soc. Setscrew	23	1	767630070	Upper Roll - 383
10	2	767380108	Roll Gear 110851)	24	1	767630083	Lower Roll - 0381

Item No.	No. Req'd	Catalog No.	Description
24	1	767630082	Lower Roll - 381
24	1	767630084	Lower Roll - 382
24	1	767630071	Lower Roll - 383
25	1	767630086	Rear Roll - 0381
25	1	767630085	Rear Roll - 381
25	1	767630087	Rear Roll - 382
25	1	767630072	Rear Roll - 383
26	1	767060089	Machine Base Assembly - 0381
26	1	767060088	Machine Base Assembly - 341
26	1	767060090	Machine Base Assembly - 382
26	1	767060073	Machine Base Assembly - 393
27	1	767030092	Cam Rod - 0391
27	1	767030091	Cam Rod - 381
27	1	767030093	Cam Rod - 382
27	1	767030074	Cam Rod - 383
28	2	621012126	5/16-18 x 3/8 Soc. Setscrew
29	2	767260110	Collar
30	1	600073513	3/32 x 5/8 Cotter Pin**
31	1	600073514	3/32 x 3/4 Cotter Pin
32	2	600073527	1/8 x 1 Cotter Pin
33	2	600123909	19 Woodruff Key
34	1	649023007	1/2 - 13 Check Nut**
35	2	649023006	7/16-14 Check Nut
36	1	678033104	5/16 Washer
37	1	678033106	7/16 Washer
38	4	678033107	1/2 Std. Washer
39	2	621012170	3/8-16 x 1/2 Soc. Setscrew
40	5	615012130	5/16- 18 x 5/8 13ulton Head Screw
41	2	601012271	1/2-13 x 1 Hex Head Cap Screw
42	2	601012275	1/2-13 x 1-1/2 Hex Head Cap Screw

\* Not sold separately - part of an assembly

\*\* Included in 267990001 assembly

ITEM No.	No. REQ'D	CATALOG No.	DESCRIPTION
T 1	1	767380108	Gear, Rear Roll
T 2	1	767380109	Gear, Idler
T 3	1	767260110	Collar. Rear Roll
T 4	4	767240124	Link
T 5	1	767240125	Shaft, Gear Idler
T 6	4	767980126	Bushing
T 7	1	767160127	Pin, Roll
T 8	1	600144105	1/8 Pipe Coupling
T 9	1	600144119	1/8 x 1-1/2 Pipe Nipple
T 10	1	621012126	5/16-18 x 3/8 Soc. Setscrew
T 11	1	600123909	#9 Woodruff Key
T 12	1	767160128	Pin
T 13	1	767630121	Rear Roll - 0381
T 13	1	767630122	Rear Roll - 381
T 13	1	767630123	Rear Roll - 382
T 13	1	767630120	Rear Roll - 383
10	1	767380108	Roll Gear
29	1	767260110	Collar
33	1	600123909	#9 Woodruff Key
43	1	621012126	5/16-18 x 3/8 Soc. Setscrew
45	1	600134001	1/8 Alemile Fitting Straight

**PEDESTAL**

P 1	1	239006007	Pedestal - 0381
P 1	1	239006C)07	Pedestal - 381
P 1	1	239006006	Pedestal - 382
P 1	1	239006006	Pedestal - 383

