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Distributors of new & used workshop Equipment

S271 SRG-50

HAND ROLLS 1300 X 75MM

ASSEMBLY & OPERATING

INSTRUCTION

24-08-2001

S271 HAND ROLLS 1300 X 75MM

SRG50

24/8/01

W01-1.5 × 1300(50")

SLIP ROLL

**ASSEMBLY & OPERATING
INSTRUCTION**

MADE IN CHINA

1 SPECIFICATION

- | | |
|---------------------------|---------------------|
| 1.1 Maximum capacity | 50" |
| 1.2 Minimum roll size | 3" |
| 1.3 Gauge | 16 gauge mild steel |
| 1.4 Rod/wire grooves dia: | 5/16", 3/8", 1/2" |
| 1.5 Approx. ship. weight: | 524 Ibs |

2 SAVE THIS MANUAL

You will need the manual for the safety warning and precautions, assembly instructions, operating and maintenances, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep the manual and invoice in a safe and dry place for future reference.

3 SAFETY WARNINGS AND PRECAUTIONS

WARNING: When using roller equipment, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment.

Read all instructions before using this tool!

- 3.1 Keep work area clean. Cluttered area invite injuries.
- 3.2 Maintain proper work area conditions. Do not use tool in damp, wet, or poorly lighted areas. Don't expose tool to rain.
- 3.3 Keep children away. Children should not be in the work area or handling machines or tool.
- 3.4 Do not force the tool. Use the proper size and gauge of steel. Do not use inappropriate attachments in an attempt to exceed the tool's capacity.
- 3.5 Dress Properly. Do not wear loose clothing or jewelry. They can be caught in moving parts. Non-skid footwear is recommended. Wear restrictive hair covering to contain long hair.
- 3.6 Use eye protection. Always wear ISO approved impact safety goggles.
- 3.7 Protect hands. Wear approved hand gloves when handling sheet metal to avoid cuts and injuries.

3.8 Do not overreach. Keep proper footing and balance at all times. Do not reach over or across running machines.

3.9 Maintain Proper tool care. Keep clean for better and safer performance. Keep handles clean, dry, and free from oil and grease.

3.10 Remove adjusting keys and wrenches. Make it a habit to check that keys and adjusting wrenches are removed from the tool or machine work surface before using tool.

3.11 Stay alert. Watch what you are doing ; use common sense. Do not operate any tool when you are tired.

3.12 Check damaged parts. Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician.

3.13 Replace part and accessories when necessary. When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from dealer.

3.14 Do not operate tool if under the influence of alcohol or drugs. Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

4 UNPACKING

The 50 inch Slip Roll machine should come assembled when unpacked. Look for any loose parts in the packing material before discarding. If any are found, try and find the part on the parts list or on the exploded view of the machine, and reinstall the part.

5 ASSEMBLY AND ADJUSTMENT

5.1 Mount the Slip Roll machine to a bench by bolting the base of the machine (#21) to the bench. Refer to illustration on page 7.

5.2 Adjust distance between shaft 1 (#8) and shaft 2 (#20) if necessary.

A. The distance between shaft 2 (#20) and shaft 1 (#8) can be adjusted by turning the adjusting bolts (#35).

B. To decrease the distance between the two shaft, turn the adjusting bolts (#35) clockwise.

C. To increase the distance, turn the adjusting bolt (#35) counter clockwise.

5.3 Adjust distance between shaft 1 and shaft 3 if necessary.

A. The distance between shaft 3 (#7) and shaft 1 (#8) can be adjusted by turning the adjusting bolts (#22).

B. To decrease the distance between the two shafts, turn the adjusting bolts (#22).

C. To increase the distance, turn the adjusting bolts (#22) counter clockwise.

5.4 Removal of shaft 1 (#8) if necessary. The left end of shaft 1 is mounted on a square bushing (#5), and the right end of shaft 1 is mounted through the right stand (#9) into the sleeve (#10).

A. To remove shaft 1, remove the sleeve (#10) off the right end of shaft 1.

B. Next, at the top of the left stand, loosen hex bolt (#3).

C. Pull the right end of shaft 1 outward.

5.5 Remounting shaft 1

A. Reinsert the right end of shaft 1 into hole in the right stand.

B. Tighten hex bolt (#3) on the top of the left stand.

C. Push the sleeve (#10) on to the end of shaft 1.

6 OPERATION

Before using, check the mounting and adjustment of this machine. Rotate the handle (#23) and check whether the four gear (#19, #30, #39) have good, firm contact with each other. Shaft 1, 2, and 3 should be clean and free of metal debris. Refer to illustration below, and on the last page.

6.1 Forming rolls

6.1.1 Insert steel plate between shaft 1 (#8) and shaft 2 (#20).

6.1.2 Rotate the handle (#23) to metal roll

6.1.3 If the diameter of the metal roll is not correct, turn the adjusting bolts(# 22) clockwise to decrease the diameter, or counterclockwise to increase the diameter of the roll.

6.1.4 To remove the finished roll, pull out sleeve (#10) on the end of shaft 1(# 8), nearest the handle (#23) , and swing shaft 1 out of the right stand. Then remove the steel roll from shaft 1.

6.2 Forming rings

The half-round slots on the right side of shaft 2 (#20) and shaft 3 (#7) can be used to form rings of various dimensions.

6.2.1 Insert steel in half-round slot of shaft 2 (#20) or shaft 3 (#7).

6.2.2 Rotate the handle (#23) to form the metal ring.

WARNING: Keep hand away from the shaft and metal plate during operation. Do not attempt to form rolls from materials other than those specified.

7 PARTS LIST

Parts list

Part No.	Description	Qty	Part No.	Description	Qty
1	Left stand	1	22	Adjusting bolt	2
2	Nut M12	1	23	Handle	1
3	Hex. bolt	1	24	Locking screw	1
4	Support bushing	4	25	Hex. nut	1
5	Square bushing	1	26	Handle bushing	1
6	Flat key	3	27	Hex. bolt	1
7	Shaft 3	1	28	Washer	2
8	Shaft 1	1	29	Spring washer	2
9	Right stand	1	30	Large gear	1
10	Sleeve	1	31	Small shaft	1
11	Washer	1	32	Hex. bolt	2
12	Spring washer	1	33	Locking screw	2
13	Screw	1	34	Pin	2
14	Cover	1	35	Adjusting bolt	2
15	Hex. bolt	4	36	Hex. bolt	4
16	Spring washer	4	37	Spring washer	4
17	Washer	4	38	Flat washer	4
18	Bearing	1	39	Gear	1
19	Small gear	2	40	Long shaft	1
20	Shaft 2	1	41	Bushing	1
21	Base	1			

SLIP ROLL - 50 INCH
PARTS BREAKDOWN

