

SLIP ROLL FORMERS 0381, 381, 382, 383



No. 381

These machines are available in four different sizes. All four models offer the standard front roll drive. These units may be mounted directly to a sturdy work bench or to an optional fabricated pedestal, designed specifically for each unit.

MODEL	0381	381	382	383
Capacity.....ga.	24	22	22	20
Max Length.....ins.	42	36	30	24
Min Diameter.....ins.	3	3	3	3
Shipping Weight Boxed...lbs.	270	250	225	190

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 (7) 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 accommodating 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.



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Pexto 381 Manual

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