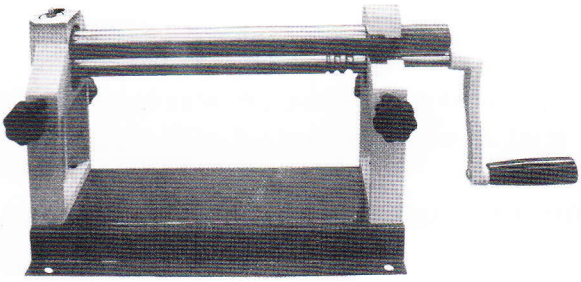
7031

12" SLIP ROLL

Model: W01-0.8 x 305



ASSEMBLY & OPERATING INSTRUCTIONS

SPECIFICATIONS

Minimum Roll Diameter	1"
Maximum Roll Length	12"
Maximum Thickness (Steel)	20 Gauge / 0.9"
Maximum Thickness (Brass)	18 Gauge / 1.2"
Maximum Thickness (Aluminum)	17 Gauge / 1.36"
Wire Forming Grooves	1/8", 1/4", & 3/8"
Weight	13 kgs
Overall Dimensions	23"x 6.68"x 9.43"

SAVE THIS MANUAL

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

READ ALL INSTRUCTIONS BEFORE ASSEMBLING OR OPERATING THE SLIP ROLL.

SAFETY WARNINGS & CAUTIONS

WARNING: When using electric tools. machines or equipment, basic safety precautions should always be followed to reduce the risk of fire. electric shock, and personal injury.

READ ALL INSTRUCTIONS BEFORE USING THIS TOOL

1. KEEP WORK AREA CLEAN. Cluttered areas invite injuries.
2. CONSIDER WORK AREA CONDITIONS. Don't use in damp, wet, or poorly

lit locations. Don't expose to rain. Keep work area well fit.

3. KEEP CHILDREN AWAY.ALL children should be kept away from the work area Don't let them operate machine.
4. STORE IDLE EQUIPMENT. When not in use, tools should be locked up in a dry location to inhibit rust. If possible, store in an area out of reach of children.
5. DONT FORCE THE MACHINE OR TOOL It will do the job better and more safety at the rate for which it was intended.
6. USE THE RIGHT TOOL. Don't force a small tool or attachment to do the work of a larger industrial tool. Don't use a tool for a purpose for which it was not intended.
7. DRESS PROPERLY. Don't wear loose clothing or jewetry. They can be caughr in moving parts.Protective gloves and non-skid fcotwear are recommended when working. Wear restrictive hair covering to contain long hair,preventing it from getting caught in machinery.
8. USE EYE AND EAR PROTECTION. Use a full face mask if the work you're doing produces metal filings, dust or wood chips. Goggles are acceptable in other situations. Wear a clean dust mask if the work creates a lot of fine or coarse dust When operating for extended periods of time, use approved ear protection. Safety goggles and ear protectors are available from distributor.
9. SECURE WORK. Use clamps or a vise to hold the work if possible. It's safer than using your hands and it frees both hands to operate the tool.
10. DONiT OVERREACH. Keep proper footing and balance at all times.
11. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Keep handles dry, clean, and free form oil and-grease.
12. STAY ALERT. Watch what you are doing. Use common sense. Don't operate any tool when you are tired.
13. CHECK DAMAGED PARTS. Before using any tool, any part that appears damaged should be carefully checked to detemine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and other conditions that may affect its operation.Any part that is damaged

should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.

14. REPLACEMENT PARTS AND ACCESSOPIES. When seruiving, use only identical replacement parts. Only use accessories intended for use with this tool. Approved accessories are available from distributor.
15. DO NOT OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS. Read warning labels on prescriptions to determine if your judgement or reflexes are impaired while taking drugs. if there is any doubt, do not operate machine.

MOUNTING

Step 1: Bolt the Slip Roll to a secure work surface using the four holes in the BASE (#25)

Step 2: You must purchase your own hardware. Buy four 5/16" bolts, nuts, and lock washers, and eight washers. Add 1" to the thickness of your workbench to determine the appropriate length of your bolts.

Step 3: Place the Slip Roll in the desired location, making sure there is enough room for the handle (positioned on the right when looking from the front) to be moved. Make sure there is enough room behind the Roll to accommodate stock.

Step 4. Mark the bench through the holes in the BASE.

Step 5. Remove Slip Roll

Step 6. Drill 11/32" holes in the workbench.

Step 7. Place the Slip Roll so the holes in the BASE line up with the drilled holes.

Step 8. Install hardware in the following order:

A. Bolt B. Slip Roll C. Workbench D. Washer
E. Lock Washer F. Washer G. Nut

ADJUSTMENTS

1. To increase the gap between SHAFT 1 (#17) and SHAFT it (#18) to allow for varying thichness of materials, screw out the ADJUSTMENT KNOB (#24). To decrease the gap, screw it in. Make sure to adjust both KNOBS at equal amount .See Figure 1

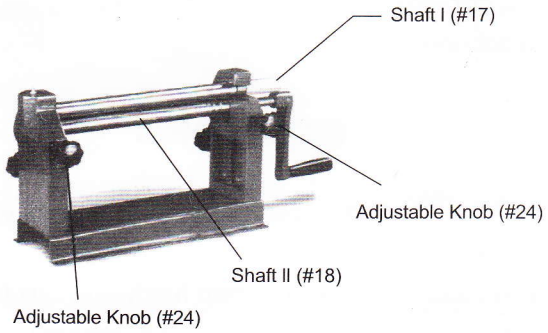


Figure 1-Adjusting the Material Gap

2. To increase the gap between SHAFT 1 and SHAFT III(#8) to increase the diameter of your rolls, screw out the ADJUSTMENT KNOB (#4).For smaller diameter rolls, screw the KNOB in, For oven rolls, adjust both KNOBS at equal amount .To create cones, adjust one side more than the other ,See Figure2.

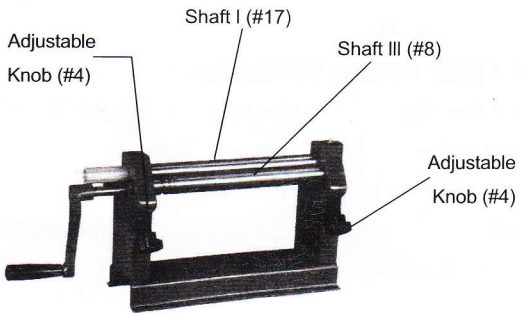


Figure 2-Adjusting the Roll Gap

Step 1: Perform all adjustments as required (see above) depending upon material thickness and whether you are engaging in straight rolls or cones.

Step 2: Insert material's edge between SHAFT1 (#17) and SHAFT11 (#18). See Figure3.

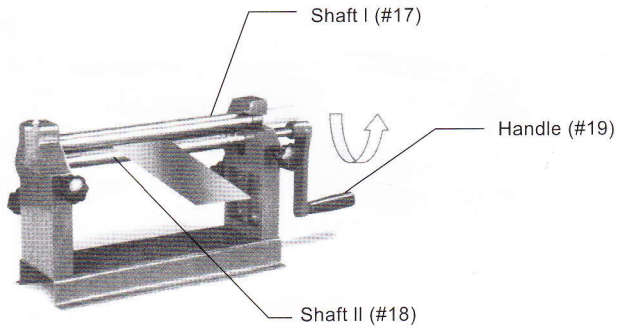


Figure 3-Inserting Material

Step 3: Turn HANDLE (#19) to process material.

Step 4: If you are only performing partial rolls and need to remove the material, slide out the SHAFT1 RELEASE ROD (#11) and pull SHAFT 1 forward. See Figure4.

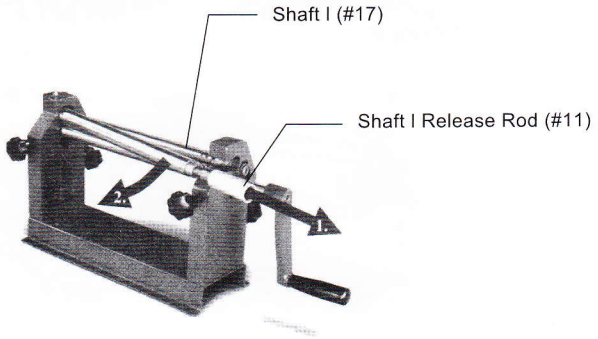


Figure 4-Removing Partial Rolls

Step 5: To form wires, select the smallest groove that you can use and put the edge of that wire on the groove of SHAFT11. Other operations are identical to sheetmetal forming. See Figure 5.

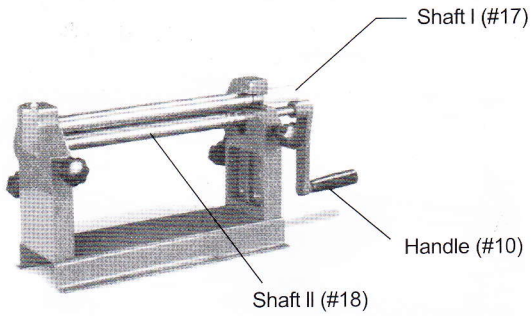


Figure 5-Wire Forming

Step 6: To form rings from wire, process the wire until the end meets the length of the stock .Remove SHAFT 1 as mentioned above, cut the stock where the end meets it.

MAINTENANEC

Keep rolls free of oil,dirt and grease at all times.
Lubricate the gears as necessary by injecting grease through the hole in the oil cup (#2),See figure 6.

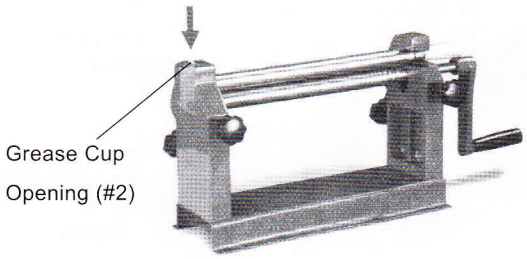
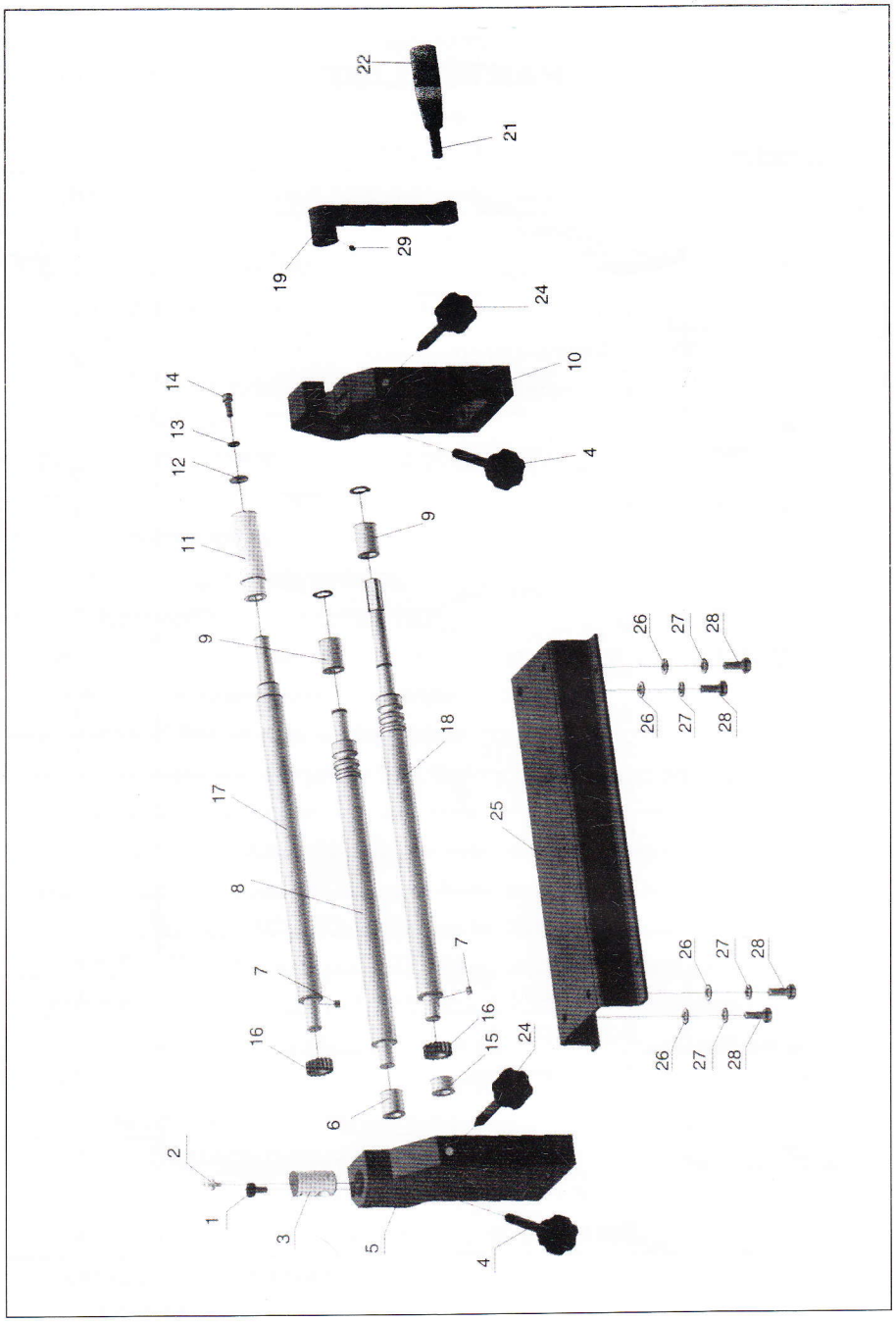


Figure 6-Lubricating the Gears

PARTS LIST

Item#	Description	Qty
1	Adjustment Screw	1
2	Grease Cap	1
3	Rotating Support	1
4	Adjustment Knob	2
5	Left Stand	1
6	Bushing	1
7	Flat Key 4x8	2
8	Shaft Ⅲ	1
9	Handle Shaft	2
10	Right Stand	1
11	Shaft Release Rod	1
12	Washer 6	1
13	Washer 6	1
14	Screw M6 x 16	1
15	Bushing	1
16	Gear	2
17	Shaft Ⅰ	1
18	Shaft Ⅱ	1
19	Handle	1
21	Handle Grip	1
22	Bolt M 10 x 10	1
24	Adjustment Knob	2
25	Base	1
26	Washer 10	4
27	Spring Washer 10	4
28	Bolt M 10 x 20	4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