





DRIVE ASSEMBLY

16 GAUGE SLITTER INSTALLATION/OPERATING INSTRUCTIONS:

General Specifications:

Maximum Cutting Capacity - 16 Ga. Steel, .0598"; min. cap. - 30 Ga., .0120";
 Maximum Width of Cut - 24-1/8";
 Minimum Width of Cut - 1/2";
 Horsepower - 3/4;
 Voltage - 115/1/60, standard (or as ordered)
 Cutting Speed - 50 fpm;
 Machine Weight - 420 lbs.;
 Machine Weight with Stand - 460 lbs.

VITAL Unpacking Instructions:

1. Remove lag bolts from crate;
2. Lift Machine off crate by its main C-Frame only;
CAUTION! Never lift machine by its motor base assembly or by its Gauge Bar Assembly; Damage to the Unit could result.
3. Examine all parts for damage (report any damage to carrier, then report to LOCKFORMER to arrange return, if necessary).

On-Site Installation:

1. This 16 Gauge Power Slitter was pre-wired and pretested at the factory; no adjustments other than desired cut-width settings are required;
2. If a stand was ordered, assemble it according to Illus. # 1, then mount Slitter on top it and bolt in place at all 4 corners with nuts & bolts provided;
3. In order to safely and efficiently operate the 16 Gauge Power Slitter, all operating personnel must read and understand this Manual!

WARNINGS AND SAFETY INSTRUCTIONS!

WHEN OPERATING THIS MACHINE, ALWAYS WEAR SAFETY GLASSES TO PREVENT EYE INJURY!

ALWAYS KEEP GUARDS IN PLACE ON MACHINE, WITH THEIR SCREWS SECURELY FASTENED!

ALWAYS PAY ATTENTION WHILE SLITTING STOCK: KEEP HANDS AWAY FROM CUTTING BLADE!

WARNING! Keep Fingers away from any power attachment, or away from any moving parts of Slitter while it is running; SLITTER CUTTING ROLLS ARE VERY SHARP!

KEEP FIRM FOOTING AND BALANCE AT ALL TIMES DURING OPERATION OF SLITTER!

ALWAYS PROTECT HANDS FROM SHARP EDGES OF MOVING SHEETS WITH GLOVES/PALM GUARDS!

NEVER USE THIS MACHINE IN DAMP OR WET LOCATIONS, OR EXPOSE TO SNOW OR RAIN, TO AVOID THE POSSIBILITY OF ELECTRIC SHOCK!

MAKE SURE ALL NUTS AND BOLTS ARE SECURE!

STOP MOTOR AND DISCONNECT POWER WHEN SLITTER IS NOT IN USE!

USE THE 16 GAUGE POWER SLITTER ONLY FOR THE JOB FOR WHICH IT IS INTENDED!

4/21/88

Operation of Slitter:

For Sheets less than 4' in length -

1. Connect Slitter to electrical power (at ordered voltage);
2. Flip switch to ON position;
3. Place stock (16-30 Ga.) in Guide Rail pocket just in front of Slitting Rolls. Be sure stock is in full contact with Gauge Bar's inner guiding surface;
4. Guide material into Slitting Rolls. When Slitting Rolls begin to cut, support end of material as shown in Illus. 2.

NOTE! AVOID PUSHING MATERIAL INTO GAUGE BAR WHILE IN SLITTING OPERATION; ONCE STOCK IS ENGAGED IN ROLLS, LET SLITTING ROLLS PULL STOCK THROUGH.

For Sheets 4' - 10' in length -

1. Support Tables must be set up at both ends of the Slitter for Slitting Sheets more than 4' in length. These Tables should consist of a flat surface, such as plywood or sheet metal; see Illus. # 3.
2. Repeat Steps 1 - 4 as above.

To Adjust Cutting Widths -

1. Loosen T-handle by turning counter-clockwise;
2. Grasp Gauge Bar Assembly at both ends and slide Bar to desired cutting width (according to scale mounted on Slitter);
3. Tighten T-Handle by turning clockwise.

Additional Operating Tips:

1. Let the machine do all the work; do not force sheet into Gauge Bar while machine is in slitting operation;
2. Avoid damaging or striking the Gauge Bar Assembly at any time;
3. Supporting long stock during slitting operation is important to quality of cuts made; If possible, add a third table at front of machine, especially when slitting small widths in succession.

Gauge Bar Adjustments (To ensure it is parallel to Upper Cutting Rollface; this is Not a routine adjustment; reset Bar this way only if it has been disturbed);

1. Turn machine off and disconnect power;
2. Loosen bolts (# 60047) at both ends of Brace (# 27481);
3. Loosen screws (# 60390) mounting Gauge Bar (# 27673);
4. Adjust screws (# 60397) to obtain proper Gauge Bar Setting (see Drg. # 55154 for further information);
5. Tighten screws (# 60390);
6. Recheck setting, as indicated on Drg.# 55154; "x" dimension must be the same at both ends of Gauge Bar (dimension itself is irrelevant as long as it is equal);
7. If setting is correct, tighten screws (# 60047) mounting brace. NOTE: When checking Gauge Bar settings, use a good quality Straight Edge and steel scale; avoid using sheet metal or other nominal-size stock.

4/21/88

Slitting Roll Installation/Removal:

1. Turn machine off and disconnect power;
 2. Loosen Mounting Nuts (# 43588) on lower shaft (# 15188) and upper shaft (# 15190) to remove Slitter Roll (# 15184);
 3. Slitting Rolls are reversible; when they begin to dull, turn each around to expose its other cutting edge;
- NOTE; DO NOT DISTURB SETUP OF SHIMS WHEN INSTALLING SLITTING ROLLS! ROLL CLEARANCE MUST REMAIN SET AT .001" - .003"!
4. Check to see if Pillow Block mounting bolts are secure and that shafts are at the correct offset;
 5. Tighten mounting nuts (# 43588) securely. Be sure that machined surface of nut is mounted toward Cutter face.
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Maintenance:

1. Whenever servicing machine, turn machine off and disconnect power;
 2. All Bearings are either flange Ball Bearings or B-Type sealed Bearings with inner races; neither requires any further lubrication;
 3. The worm and worm gear shaft must be periodically lubricated to prevent excessive wear under heavy use. Weekly Lubrication may Be Required! Remove chassis cover and lubricate worm and worm gears with MOLUB ALLOY Open Gear Grease heavy. Reinstall cover.
 4. Slitter rollfaces can be ground for resharping to an exact 90° from bore. After grinding, reinstall rolls without disturbing shim arrangement. NOTE: NEVER lubricate Slitting Rolls! Any lubrication will cause cutter slippage and reduce cutting efficiency!
 5. At some time, Gauge Bar Assembly can bind while being adjusted for cutting width. This is caused by gum deposits building up on C-Frame surface. Spray LOCKFORMER GALV-OFF or other comparable spray lubricant onto C Frame surface to enable Gauge Bar Assembly to move freely once again.
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4/21/88

TROUBLESHOOTING:

Problem	Cause/Remedy
Machine Noisy	<ul style="list-style-type: none"> a.) Apply grease to Worm Gear Unit; b.) Turn machine off and reposition motor and wormshaft alignment. c.) Bearings overloaded and need replacing.
Machine will not Cut 16 Ga. Material	<ul style="list-style-type: none"> a.) Shimming incorrect on front Pillow blocks, due to insufficient clearance; b.) Tighten Slitting Roll mounting bolts; c.) Slitting Rolls need sharpening;
Slitting Rolls Stick and Bind during Operation	<ul style="list-style-type: none"> a.) Lubrication or Foreign Material has built up on cutting edges of Slitting Rolls; clean edges with soft cloth; b.) Blade clearance inadequate; add or remove shims as needed to obtain proper .001-.003" clearance;
Slit Pieces have Up Bow or Flare along entire Length	<ul style="list-style-type: none"> a.) Adjust front Stock Support so its top edge is level with lower groove surface of Gauge Bar. b.) Slitter Rolls need sharpening;
Slit Pieces have Runout or or Bowing in middle Section	<ul style="list-style-type: none"> a.) Re-adjust Gauge Bar to be parallel with TOP Slitter Roll Face; b.) Re-adjust Slitter Rolls for 1/64" offset of <u>vertical</u> shaft centers (see drg. # 55154).

4/21/88

16 GA. SLITTER

