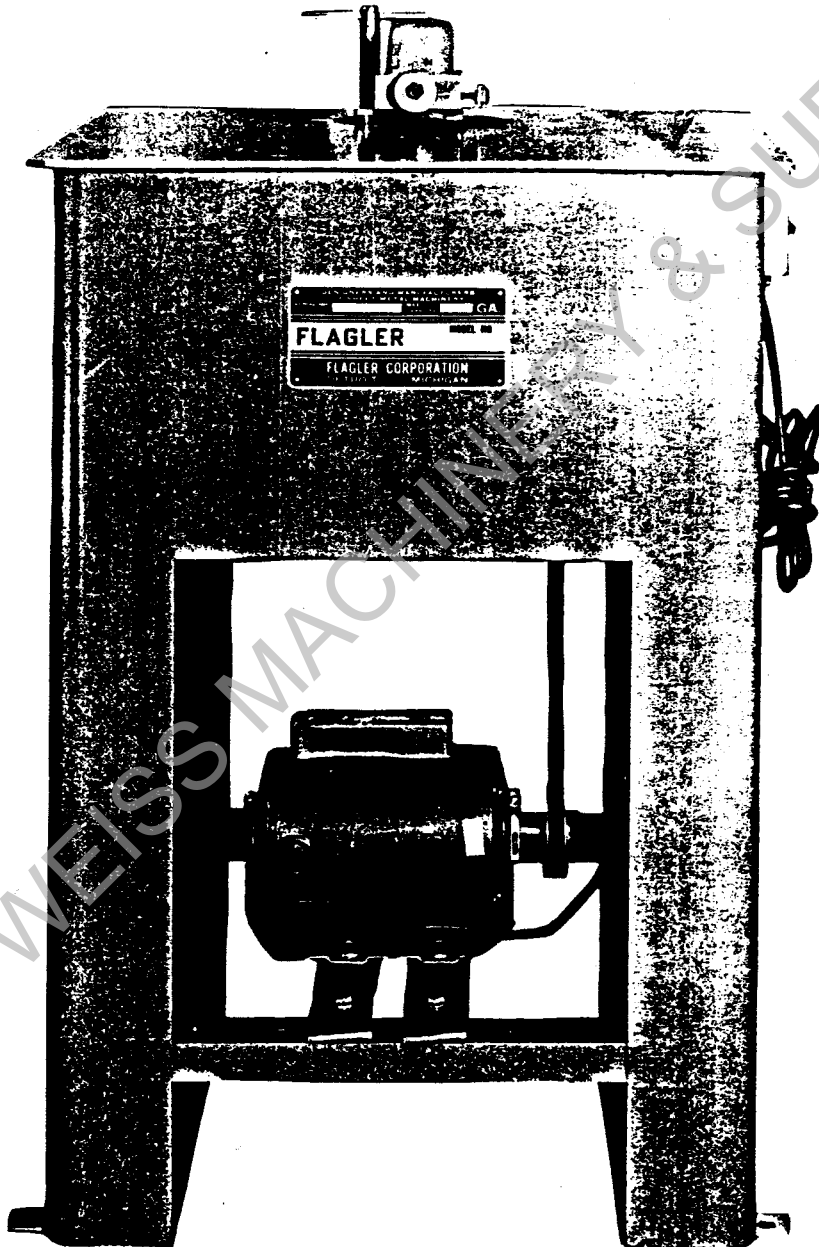
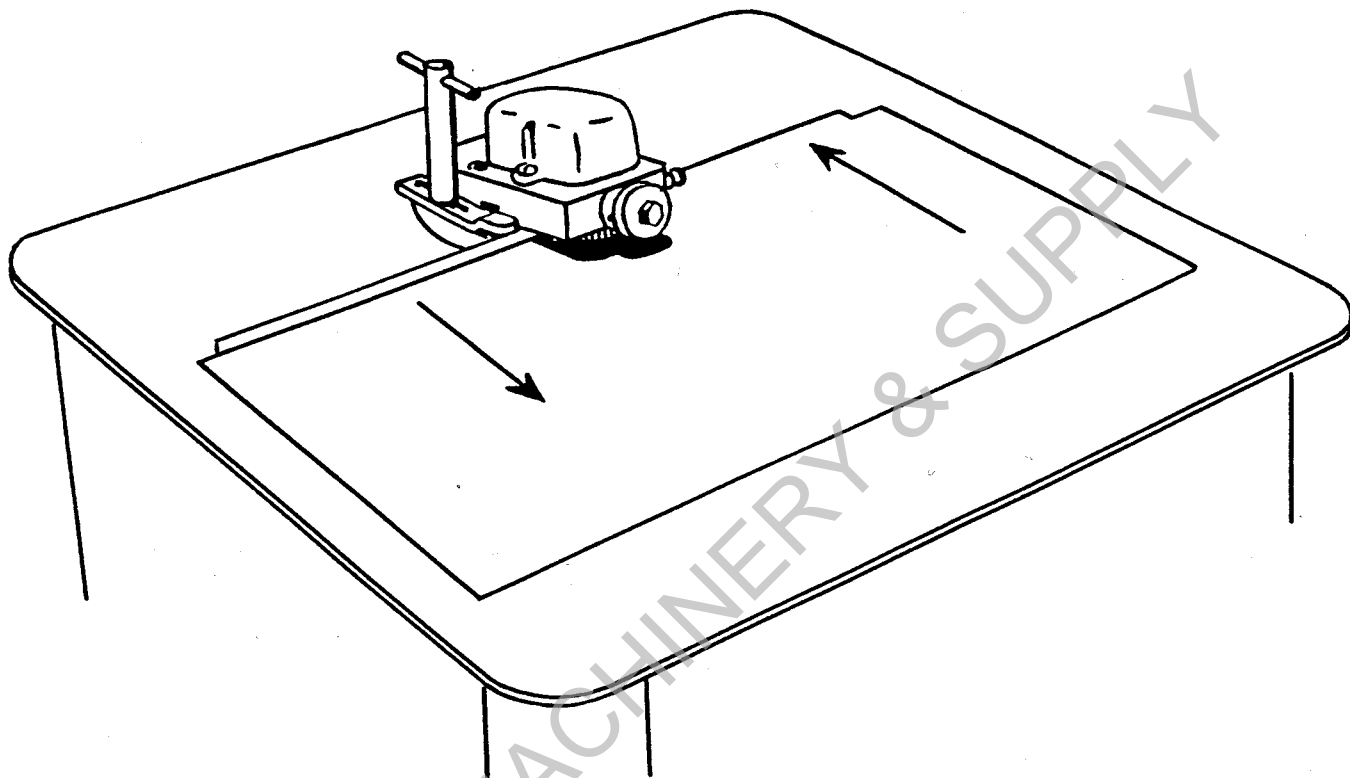


# GENERAL OPERATING INSTRUCTIONS AND PARTS LIST



The adjusting dial on the flanging head must be set to the gauge to be handled. To do this, turn the dial to the right as far as it will go (without forcing); then back off until the number of the gauge to be worked is opposite the scribed mark.

Turn up a "starting Flange" (by using the slot cut in the table top for this purpose). Start the Flanger and feed the "starting flange" into the rolls from the right side. (The metal moves from right to left through the rolls as you face the machine.)



Press or push the metal being worked in accordance with the arrows in the accompanying sketch. When the piece is first started, it is easiest to push the right hand side of the metal being worked toward the machine or away from you; when the metal is about half way through, it is easiest to pull that part already flanged toward you. It will take one or two "practice" flanges before you will be able to turn a perfect flange; hence it is advisable to practice on waste stock before trying to flange an actual fitting.

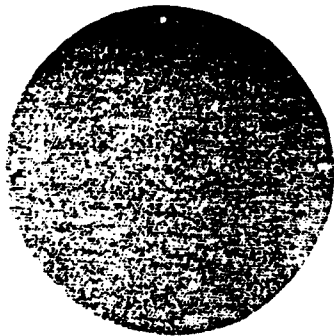
If the flange comes from the rollers in a wrinkled or "buckled" condition, you are applying too much pressure; if the flange does not come up to the full height or "runs off" the piece being worked, you are applying too little pressure.

A buckled flange can be corrected by starting the same flange through the rollers a second time AND BY APPLYING NO PRESSURE WHATEVER. (Simply start the piece AND LET GO).

A low flange can be brought up to height by running it through the rollers again and applying slightly more pressures in so doing.

18 GA. POWER FLANGER - MASTER PARTS LIST

| <u>Part No.</u> | <u>Description</u>         | <u>Quantity</u> |
|-----------------|----------------------------|-----------------|
| 27-001          | Gear Housing               | 1               |
| 27-002          | Gasket                     | 1               |
| 27-003          | Housing Cover - Casting    | 1               |
| 28-001          | Forming Head               | 1               |
| 27-005          | Dial                       | 1               |
| 27-006          | Vertical Shaft             | 1               |
| 27-007          | Horizontal Shaft           | 1               |
| 27-008          | Worm Gear                  | 1               |
| 27-009          | Worm Gear                  | 1               |
| 27-010          | 15 Tooth Gear              | 2               |
| 10-011          | Bearing B-108              | 2               |
| 11-010          | Race IR-1316               | 1               |
| 27-024          | Thrust Bearing #605-Nice   | 1               |
| 14-021          | Bearing B-1412             | 2               |
| 27-011          | Bronze Bushing P-64-12     | 2               |
| 27-012          | Oil Seal CR-6229           | 1               |
| 11-012          | Guide Roll Holder Assembly | 1               |
| 11-014          | Roll Guide Handle Assembly | 1               |
| 11-016          | Guide Roll                 | 1               |
| 27-025          | Gear Cover Assembly        | 1               |
| 27-023          | Cabinet Assembly           | 1               |
| 10-031          | Label-Manufacturer         | 1               |
| 10-032          | Motor                      | 1               |
| 10-038          | Starter GE-5981-8          | 1               |
| 10-040          | Label - Osha               | 1               |
| 10-042          | Warning Label              | 1               |
| 27-019          | Pulley AZ50                | 1               |
| 27-020          | Pulley AZ30                | 1               |
| 27-021          | "V" Belt 4L560             | 1               |
| 27-022          | Freezer Plug Dorman-P14C   | 1               |
| 14-048          | Motor Clamp Assembly       | 4               |
| 28-037          | Knurled Roll               | 1               |
| 28-038          | Plain Roll                 | 1               |
| 27-039          | Lifter Button              | 1               |



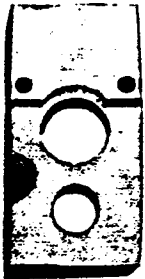
27-002



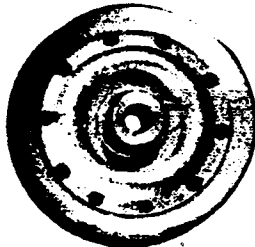
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27-001



28-001



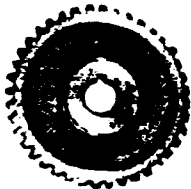
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27-021



27-006



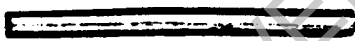
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27-020



27-010



27-007



27-009



14-021



27-005



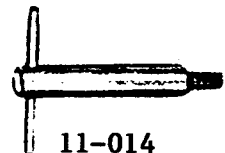
28-037



11-012



28-038



11-014

27-012



11-010



27-024



11-016



27-011



27-039