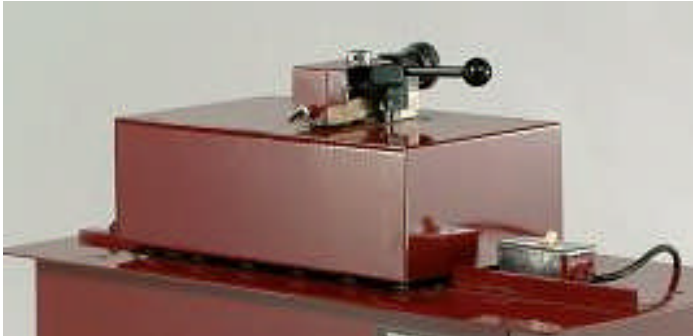


flagler

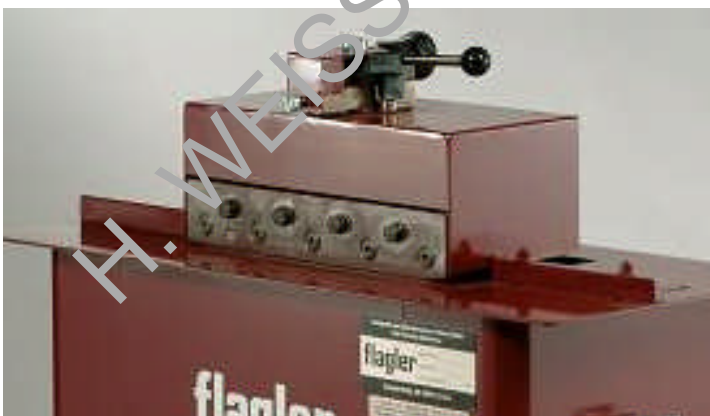
Operating Instructions and parts list for Flange Follower Attachments for
Flagler Model 24, 22, and 20 Ga. Pittsburgh Machines



22 Ga. Portable



24 Ga. Junior



20 Ga. Standard

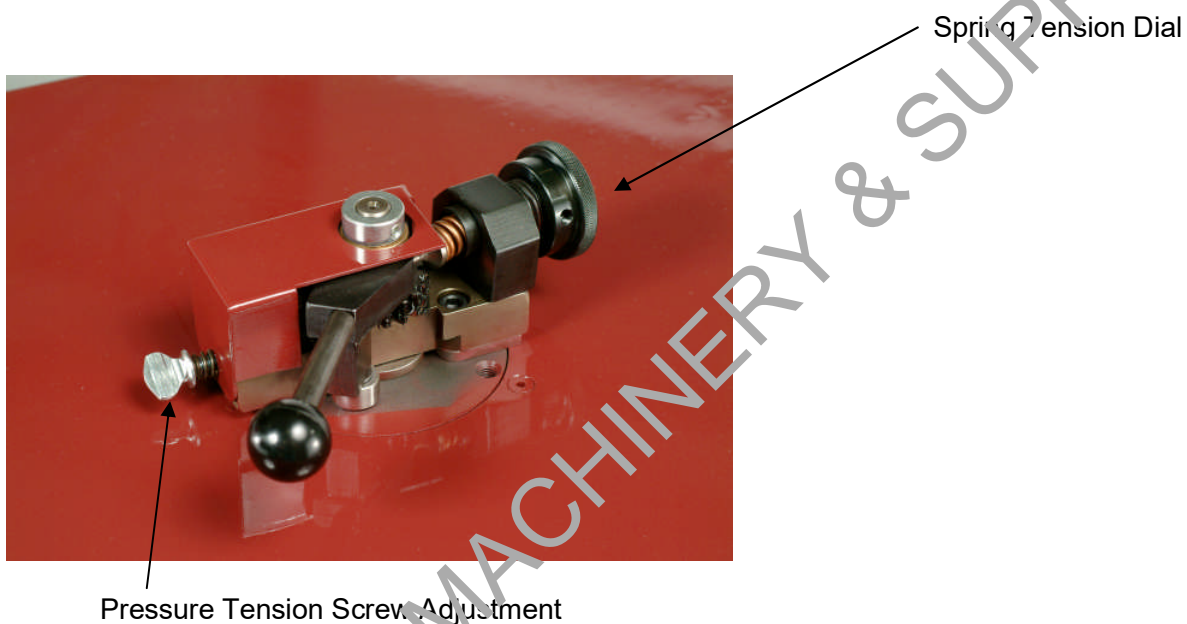
Disconnect power prior to removing any guarding for any reason

Operating Instructions

The gauge capacity of the Flange Follower will depend on the model. The gauge of the Flanger will correspond directly to the gauge capacity of the machine in which it is installed on, for example a Flanger Mounted on a 24 Ga. Junior Pittsburgh machine will have a gauge capacity of 24 Ga. galvanized metal.

All parts to be run through the Flanger must have the front corner of the part bent as a starting flange in the slot provided on the top of the machine.

There are 2 possible adjustment areas of the Flanger; the large stamped dial on the back side of the Flanger and the thumb screw on the front side.



The thumb screw setting sets the pressure between the 2 forming dies. If the flange is wrinkled or immediately pushes out of the rolls then the pressure is too tight. If the material is not feeding in properly and is slipping, then it is too loose. This will have to be adjusted between different gauges.

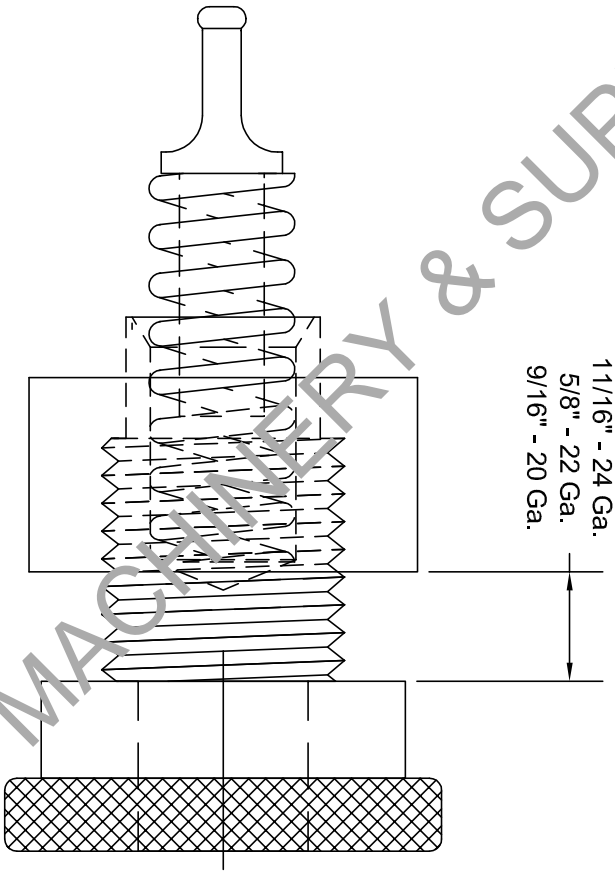
The Spring Tension Dial sets the pressure of the spring loaded cam roller on the exiting of the part. The dial is stamped and set at the factory setting for straight pieces.

Varying different shapes can be run through and the pressure will have to be adjusted accordingly. Commonly outside radius pieces can run at the straight setting and inside radii have to have a looser spring tension, as much as one complete revolution of the dial.

The Factory Setting Locations for the dial location on straight pieces can be measured using the diagram shown on the following page.

Disconnect power prior to removing any guarding for any reason

Flange Follower Factory Settings for Straight Pieces



H. WEISS MACHINERY & SUPPLY



Breakdown shown is of 20 Ga. Flanging Attachment

Disconnect power prior to removing any guarding for any reason

Item	Description	Model 24		Model 22		Model 20	
		Part #	Qty.	Part #	Qty.	Part #	Qty.
Z	Casting	11-001	1	13-001	1	15-001	1
R	Forming Block	11-002	1	11-002	1	11-002	1
T	Spacer Plate	11-003	1	11-003	1	11-003	1
A	Main Shaft	11-108	1	11-108	1	11-108	1
O	Plain Gear	11-005	2	11-005	2	11-005	2
BB	Bevel Gear	11-006	1	11-006	1	15-002	1
CC	Combination Gear	11-007	1	11-007	1	15-003	1
S	Bearing #108	10-011	2	10-011	2	10-011	4
C	Bearing #1012	11-009	4	11-009	4	11-009	3
E	Oilite #TT-1204-01	11-033	3	11-033	3	11-033	3
U	Race #IR-1316	11-010	1	11-010	1	11-010	1
D	Collar	11-011	1	11-011	1	11-011	1
J	Swivel Block	11-101	1	11-101	1	11-101	1
M	Adjustment Screw	11-102	1	11-102	1	11-102	1
G	Adjustment Handle	11-104	1	11-104	1	11-104	1
L	Spring	11-109	1	11-109	1	11-109	1
K	Nose	11-103	1	11-103	1	11-103	1
F	Cam Block Assembly	11-107	1	11-107	1	11-107	1
H	Cam Follower CF 7/8-B	22-015	1	22-015	1	22-015	1
N	Knob/Handle Assembly	11-110	1	11-110	1	11-110	1
B	Gear Cover Assembly	11-111	1	11-111	1	11-111	1
X	Plain Roll	11-025	1	11-025	1	11-025	1
W	Knurled Roll w/key & nut	11-026	1	11-026	1	11-026	1
Y	Lifter Button	11-027	1	11-027	1	11-027	1
AA	Dowell	11-028	1	11-028	1	11-028	1
P	Thumb Screw	11-029	1	11-029	1	11-029	1
Q	Spring	11-030	1	11-030	1	11-030	1
V	#61 Woodruff key (modified)	11-031	1	11-031	1	11-031	1
	Cover	11-018	1	13-002	1	15-004	1

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