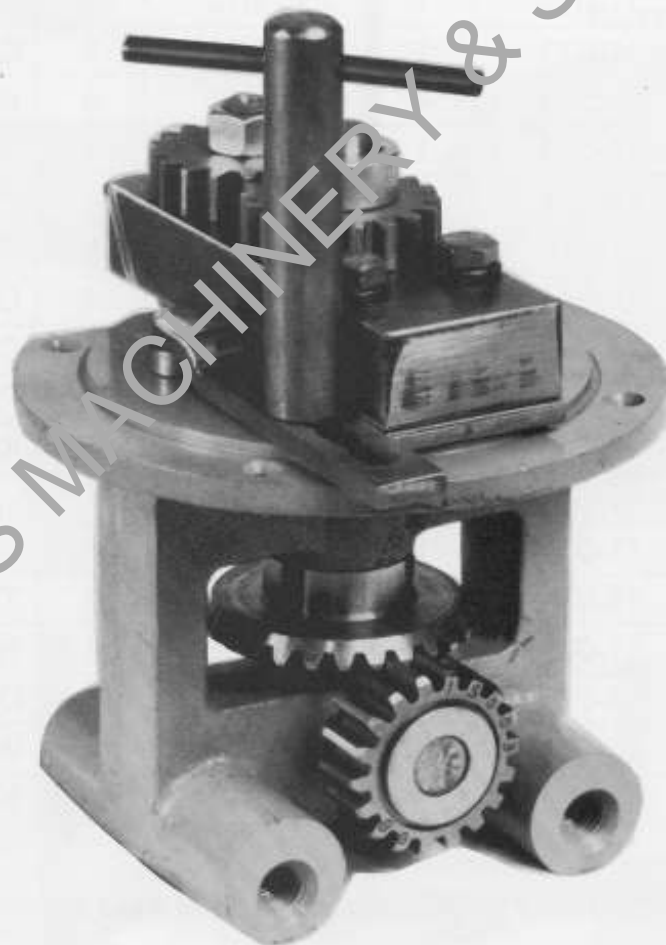


# flagler

Designers and Manufacturers of Sheet Metal Roll Forming Machinery

## Flanging Attachment

### Operating Instructions and Parts List



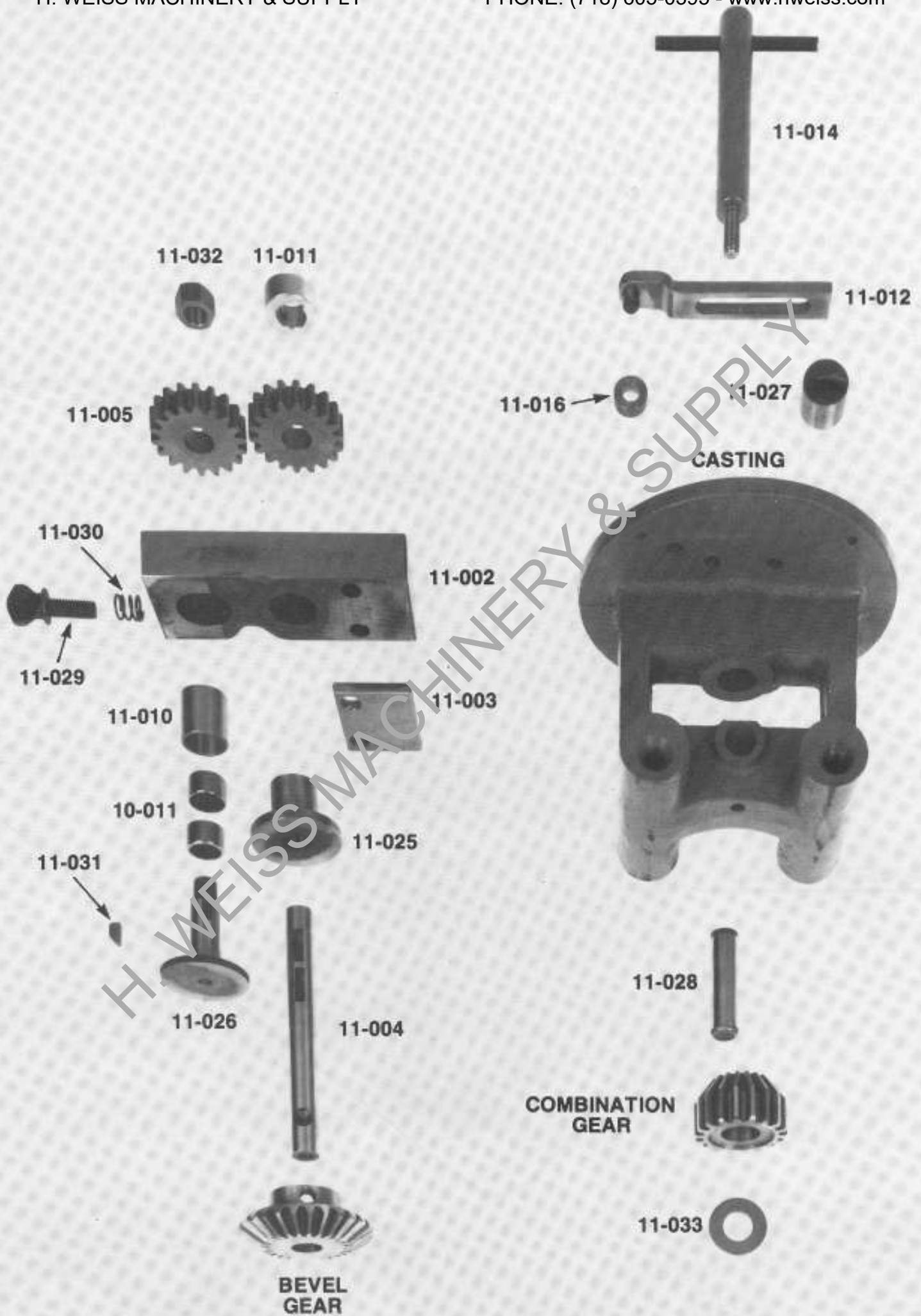
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## Flanging Attachment Parts List

Model 24 Junior Flanging Attachment		Model 22 Portable Flanging Attachment		Model 20 Standard Flanging Attachment		Description
Part No.	Qty.	Part No.	Qty.	Part No.	Qty.	
11-001	1	13-001	1	15-001	1	Casting
11-002	1	11-002	1	11-002	1	Forming Block
11-003	1	11-003	1	11-003	1	Forming Block Spacer
11-004	1	11-004	1	11-004	1	Main Shaft
11-005	2	11-005	2	11-005	2	Plain Gear
11-006	1	11-006	1	15-002	1	Bevel Gear
11-007	1	11-007	1	15-003	1	Combination Gear
11-009	1	11-009	1	NA	NA	Bearing #1012
11-010	1	11-010	1	11-010	1	Race #IR-1316
11-011	1	11-011	1	11-011	1	Collar
10-011	4	10-011	4	10-011	6	Bearing #108
11-012	1	11-012	1	11-012	1	Guide Roll Holder
11-014	1	11-014	1	11-014	1	Roller Guide Handle
11-016	1	11-016	1	11-016	1	Guide Roll
11-017	1	11-017	1	11-017	1	Gear Cover Assembly
11-018	1	13-002	1	15-004	1	Cover Assembly
11-025	1	11-025	1	11-025	1	Plain Roll
11-026	1	11-026	1	11-026	1	Knurled Roll
11-027	1	11-027	1	11-027	1	Lifter Button
11-033	1	11-033	1	11-033	1	Oilite
11-029	1	11-029	1	11-029	1	Thumb Screw
11-030	1	11-030	1	11-030	1	Spring
11-028	1	11-028	1	11-028	1	Dowel Pin
11-031	1	11-031	1	11-031	1	Woodruff Key (modified)
11-032	1	11-032	1	11-032	1	½"-20 NF Hex Nut

Contact your Flagler Distributor for price and availability of these and other Flagler Products.

**Important: Disconnect Power Before Removing Covers for Any Reason**



## Operating Instructions for Power Flanging Attachment

1. Tighten the gauge adjustment screw and loosen it a quarter turn (this setting is correct for 26 gauge material). If the flange is wrinkled, the adjustment is too tight; if there is slippage, then it is too loose.
2. Turn up a "starting flange" by using the slot cut in the tabletop. Once the operator is accustomed to the flanger, this will not be necessary. As the metal passes through the forming rolls, exert a small force on the piece in the direction indicated by the arrows in the figure below. This holds the metal to the height gauge and results in an even, uniform flange. Too much force will jam the machine.
3. On exceptionally small outer radii the piece may need to be run through the flanger a second time to remove wrinkles and to straighten the flange.
4. When flanging straight pieces or pieces having a constant radius, the operator may set the adjustable guide. To use the guide simply run a piece partly through the rolls and then slid the guide against the flange and tighten down the T-handle. As a result, the following pieces can be released after started.
5. To flange small inner radii, no guide is needed. Start the piece and LET GO.
6. If you fail to turn the flange to the full height, or the flange runs off the edge of the piece, the piece is not spoiled; simply run it through the flanger again.
7. After flanging a few pieces, the operator will get the "feel" of the machine and find out how easily that the metal is guided up to a perfect flange. For ease in handling of material, stand at the front of the machine.

**ADJUSTABLE GAUGE**

