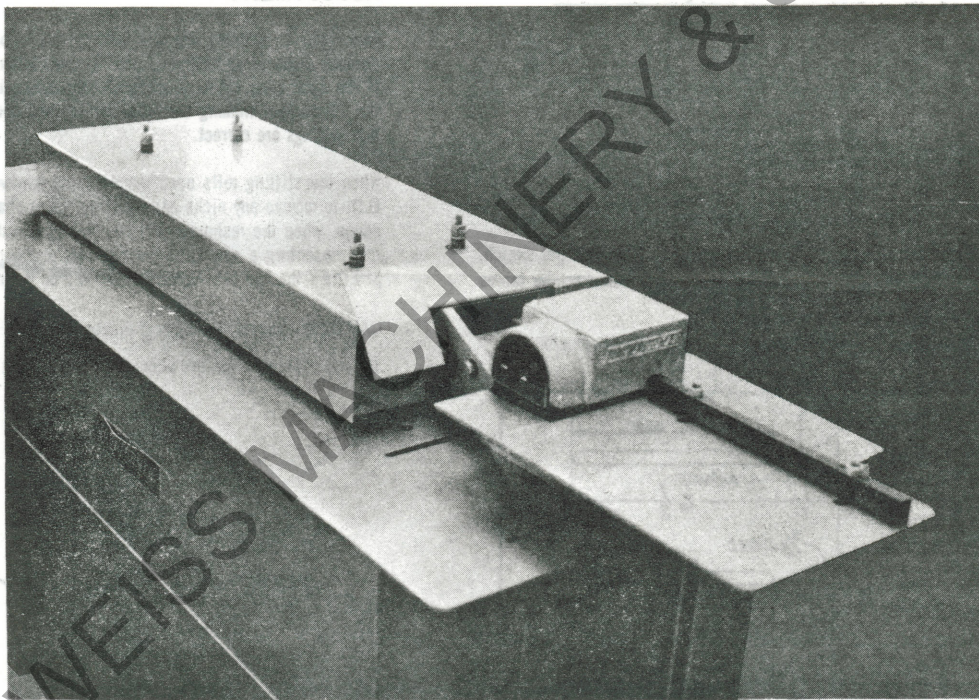


# Operating Instructions

## "S" Cleat Cutter Attachment

for

8900 Series Super Speed Cleatformer



# LOCKFORMER

*Where the Machines of Tomorrow are Made Today<sup>SM</sup>*

Maximum Capacity of Unit: 22 Ga. Galv. (.0350" Material)  
Minimum Length of Cleat to be cut: 9" minimum

Note: "S" Cleat Slitting attachments supplied with Super Speed Cleatformer (Model 8900) can be mounted by starting with Step No. 4. All Auxiliary gauges are factory set and should not require any further adjustments.

### TO INSTALL ON SERIES 8900 SUPER SPEED CLEATFORMER

1. Remove present cover and notch entrance end per sketch as required.

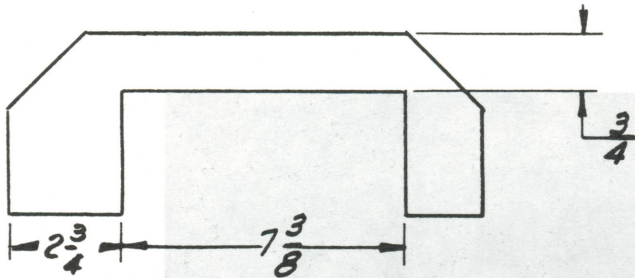


Figure 1 - Feed-End View of Cover of Super Speed Cleatformer Model 8900

2. Remove entrance gauge bars of present "S" Cleat and elongate table lots per sketch, as required. Suggestion: Drill 3/8 hole then cut out slot. Note: On machine tables with continuous slot the above elongation is not required.

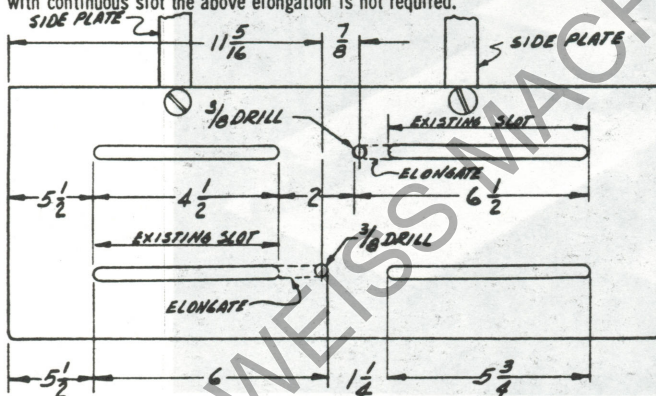


Figure 2 - Entrance Table Detail Model 8900

3. Replace Auxiliary entrance Gauges using special gauge bars and bolts provided in carton. Reset gauges as outlined in Chart I and in Super Speed Machine operating instructions.

### TO OPERATE "S" CLEAT CUTTER ATTACHMENT

1. Check settings and make sure all mounting bolts are tight.
2. Start machine and place the material against the entrance gauge bar of the slitting attachment and feed the stock into the slitting rolls. The slit material will automatically deflect downward to the forming roll while the piece in the operator's hand will deflect upward to clear the machine. The slitter will cut straight as long as the material which has not gone thru the slitting rolls is held against the entrance gauge bar.

Note: When running long sheets it is advisable that the sheet be supported at approximately the same height as the slitting attachment entrance table.

### ADJUSTMENT

The slitter is properly adjusted and tested before shipment. Should the gauge accidentally become misaligned, refer to installation instructions paragraph 5 on 8900. If the cleat runs out or if material distribution is not correct, check the mounting of the attachment making sure the unit is mounted parallel to the machine side plates and settings are correct.

When the slitting rolls need sharpening remove the bottom roll and grind it on the O.D. to remove any nicks and present a clear sharp edge. The top roll has two cutting edges, when the resharpened lower roll is reinstalled merely reverse the side of the roll presenting a new cutting edge. Note: When ordering parts for this unit, please SPECIFY the SERIAL NUMBER stamped on the name Plate.

CAUTION: Machine will jam if pieces less than 9" are used.

In case of jam-up, remove sheet deflector casting 56574 and remove material from unit.

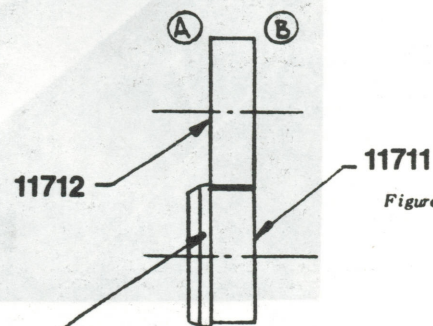


Figure 7 - Diagram of Rolls






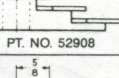



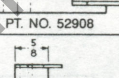

Grind this surface on center reverse top roll cutting edge A to B.



# **ENTRANCE GAUGE TABLE SETTINGS** **SUPER SPEED CLEATFORMER MODEL 8900**

For aligning entrance Gauge Bars refer to Drawing No. 3 for Dimensions and Settings.

**CHART 1**

AUX. ROLL SETS	LOCATION	MACHINE	ENTRANCE GAUGE TO BE USED	ENTRANCE GAUGE SETTING FROM EDGE OF ROLL
5/16 Pittsburgh	Gear Side	Super Speed Cleatformer	 PT. NO. 52907	1-11/16" / 1-3/4"
Type L & S Double Seam	Gear Side	Super Speed Cleatformer	 PT. NO. 52907	Type S 1-1/8" Type L 1-5/16"
Standing Seam	Gear Side	Super Speed Cleatformer	 PT. NO. 52907	2"
24 Female Button Lock	Gear Side	Super Speed Cleatformer	 PT. NO. 52907	2-3/32" / 2-5/32"
Drive Cleat	Gear Side	Super Speed Cleatformer	 PT. NO. 52907	2-1/8"
3 in 1	Gear Side	Super Speed Cleatformer	 PT. NO. 52908	Top Step 2-1/16" Middle Step 1-1/2" Bottom Step 15/16"
2 in 1	Gear Side	Super Speed Cleatformer	 PT. NO. 52909	Top Step 2-1/16" Bottom Step 1-1/2"
24 Female Button Lock	Plate Side	Super Speed Cleatformer	 PT. NO. 52907	2-3/32" / 2-5/32"
Drive Cleat	Plate Side	Super Speed Cleatformer	 PT. NO. 52907	2-1/8"
3 in 1	Plate Side	Super Speed Cleatformer	 PT. NO. 52908	Top Step 2-1/16" Middle Step 1-1/2" Bottom Step 15/16"
2 in 1	Plate Side	Super Speed Cleatformer	 PT. NO. 52909	Top Step 2-1/16" Bottom Step 1-1/2"

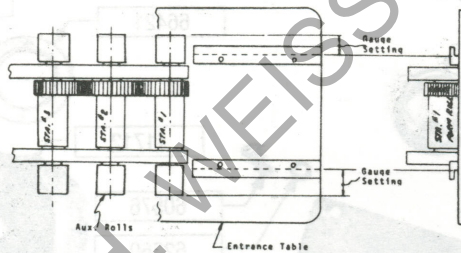


Figure 3 — Model 8900—Refer to Chart 1, Entrance Gauge Table Settings:

Note: There is an interference when using standard 2 in 1 and 3 in 1 Entrance Gauge Bars when the slitter is attached to the machine. It will, therefore, be necessary to furnish a special Entrance Gauge Bar for this operation. We will need the Serial No. of the machine and the type of rolls (2 in 1 or 3 in 1) for which the gauge bar is required. Please return the existing Gauge Bar for credit. New entrance gauge bar will be furnished from Lockformer, Chicago Factory.

4. Set slitting attachment on entrance table so that the spur gear of the attachment meshes with the gear of the No. 1 forming roll. Refer to Drawing No. 4 for set-up.

5. By placing the template furnished across the back of the slitting attachment casting, casting and the machine plate, bolt in place per sketch: Note: 7/32" Dimension is fabricated into the template. Template edges must be parallel to Machine plate and slitter attachment casting.

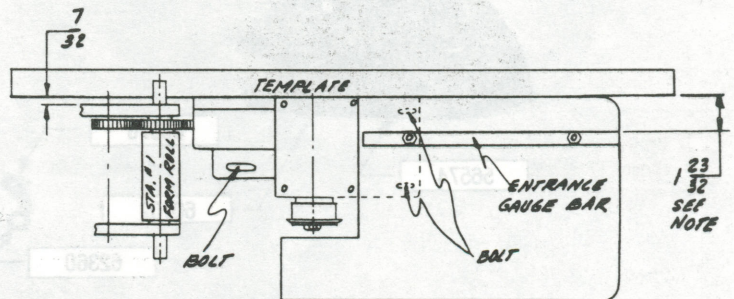


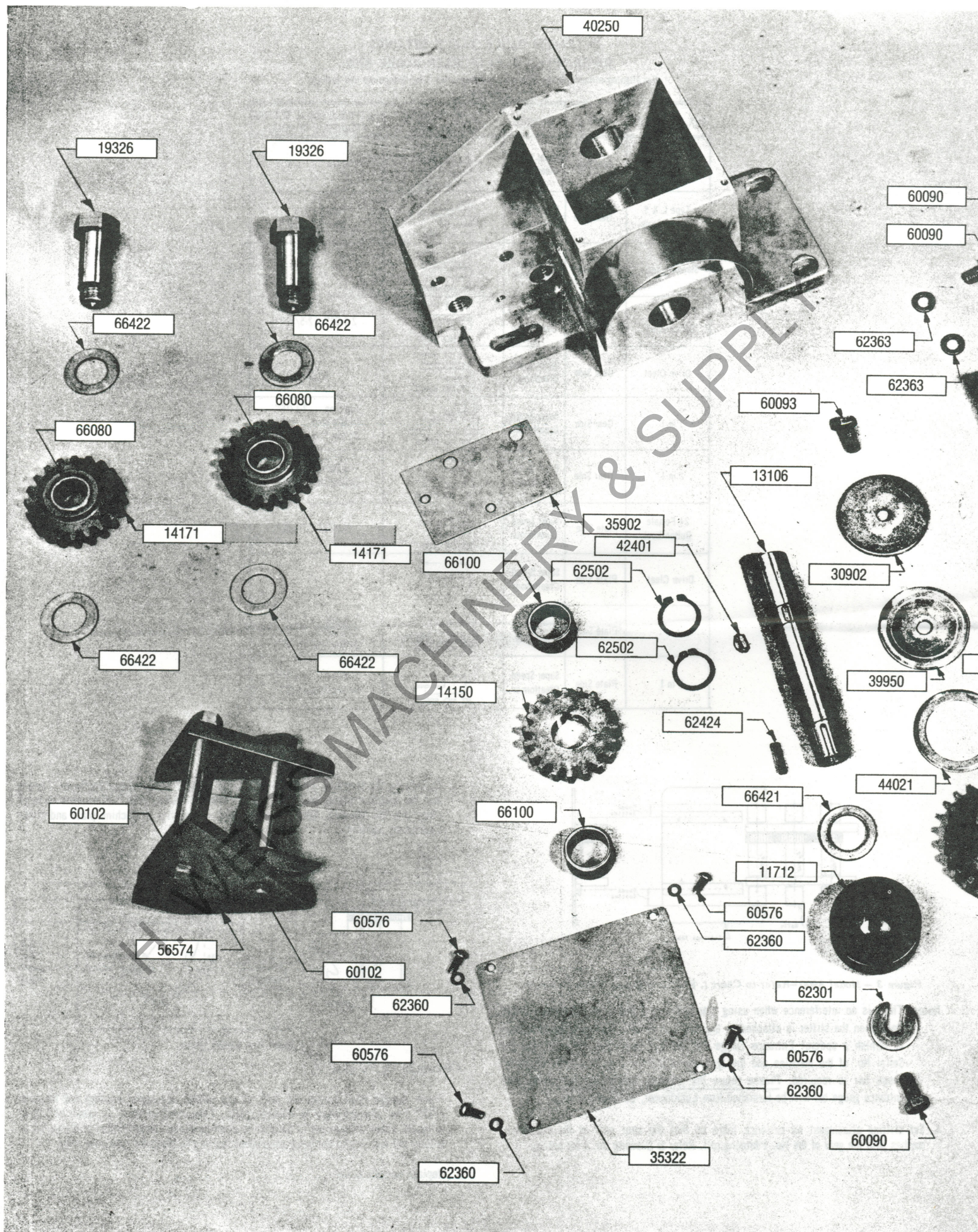
Figure 4 — Model 8900

Alternate Set-Up Procedure:

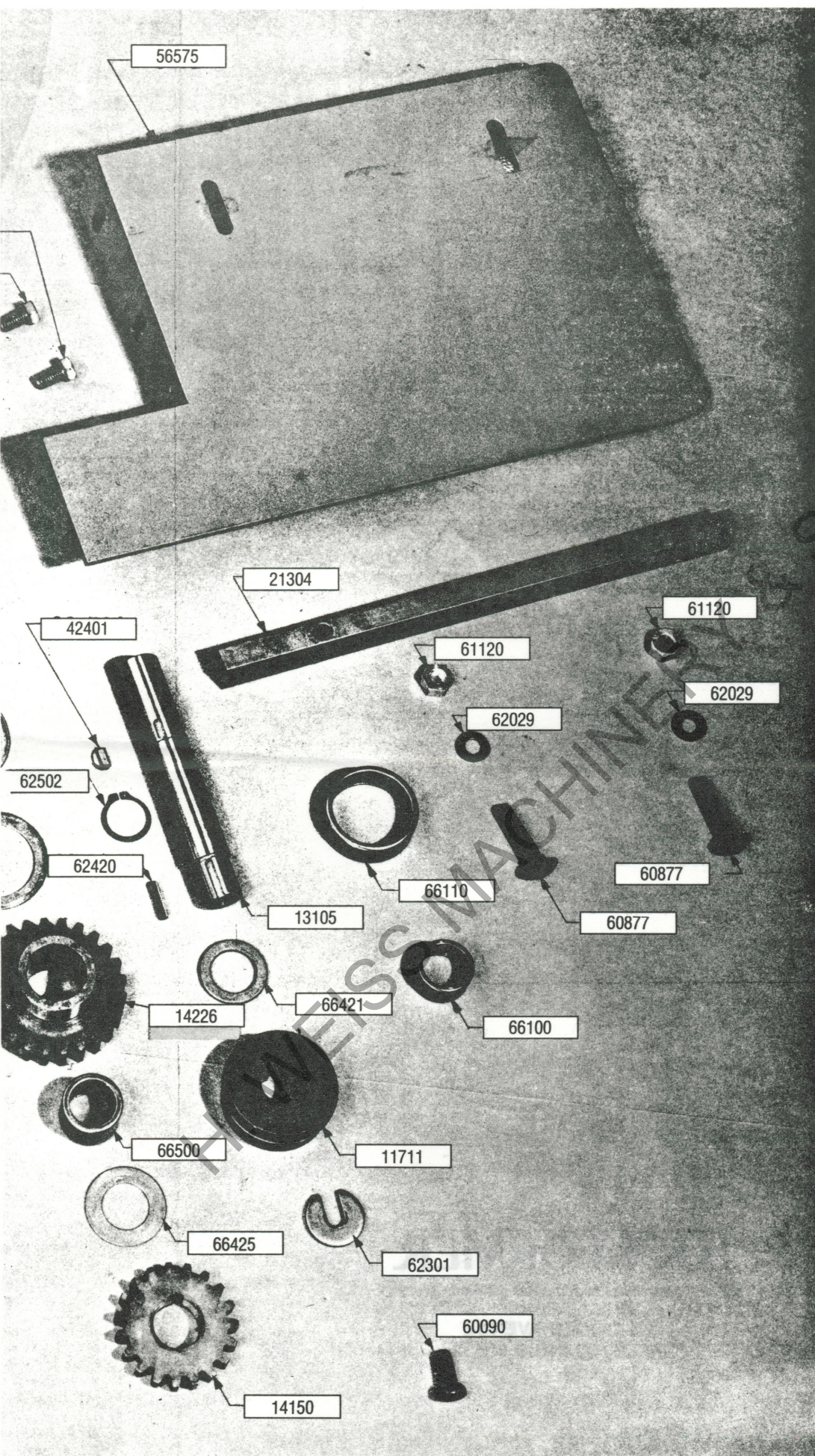
Place straight edge across the back of the slitter attachment casting and measure 7/32" from straight edge to machine plate. Take measurements at least 12" apart to insure slitter attachment is parallel to machine plate: Note: Entrance gauge bar is factory set and should not need adjustment. Setting is given for reference only.

6. Replace machine cover.









PART NO.	DESCRIPTION	REQ. PER UNIT
11711	Bottom Slitting Roll	1
11712	Top Slitting Roll	1
13105	Bottom Roll Shaft	1
13106	Top Roll Shaft	1
14150	Drive Gear	2
14171	Idler Gear	2
14226	Clutch, Gear	1
19326	Idler Stud	2
21304	Entrance Gauge	1
30902	Washer	1
*34700	Defl. Guard	1
35322	Cover Plate	1
35902	Wear Plate	1
*35979	Template	1
39950	Thrust Washer	1
40250	Main Housing	1
44021	Thrust Washer	1
56574	Deflector	1
56575	Entrance Table	1
*60045	5/16-18 x 1/2 HHCS	2
60090	3/8-16 x 3/4 Hex Cap Screw	4
60093	3/8-16 x 1 Hex HD Cap Screw	1
60102	3/8-16 x 5" Lg. Hex. Capscrew	2
*60498	5/16-18 x 3/8 SHCS	1
*60571	8-32 x 3/4" RHMS	2
60576	10-24 x 1/2" Lg. Rd. Hd. Mach. Screw	4
*60795	4 x 3/16 Drive Scr.	2
*60876	3/8-16 x 1-1/4 CB	3
60877	3/8-16 x 1-3/4" Lg. Carriage Bolt	2
*61020	8-32 Hex Nut	2
61120	3/8-16 Hex. Nut	2
*62002	3/16 x .049 Wsr.	2
62029	3/8 ID Plain Washer	2
62301	"C" Washer	2
62360	3/16 Lockwasher	4
62363	3/8 Lockwasher	5
62420	3/16 Sq. Key	1
*62424	3/16 Sq. Key 1/2	1
62502	Retaining Ring	3
66080	Bearing	2
66100	Bearing	3
66100	Bearing	1
66421	Thrust Washer	2
66422	Thrust Washer	4
66425	Thrust Washer	1
*66430	TT150-2 Brg.	1
66500	Clutch	1
*71154	1" Collar	1

\*Not Shown