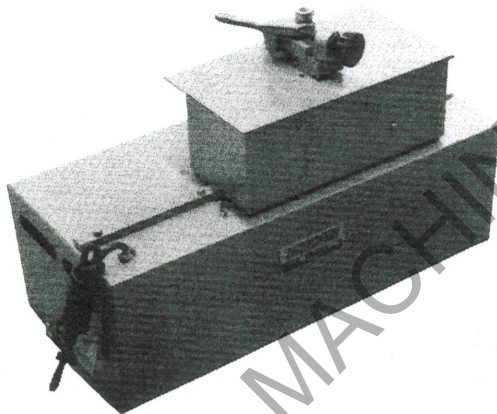
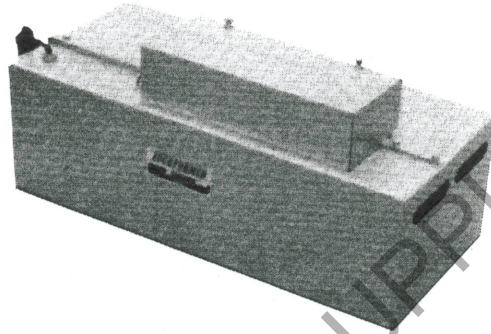


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Model 24 Instructions and Parts Diagram

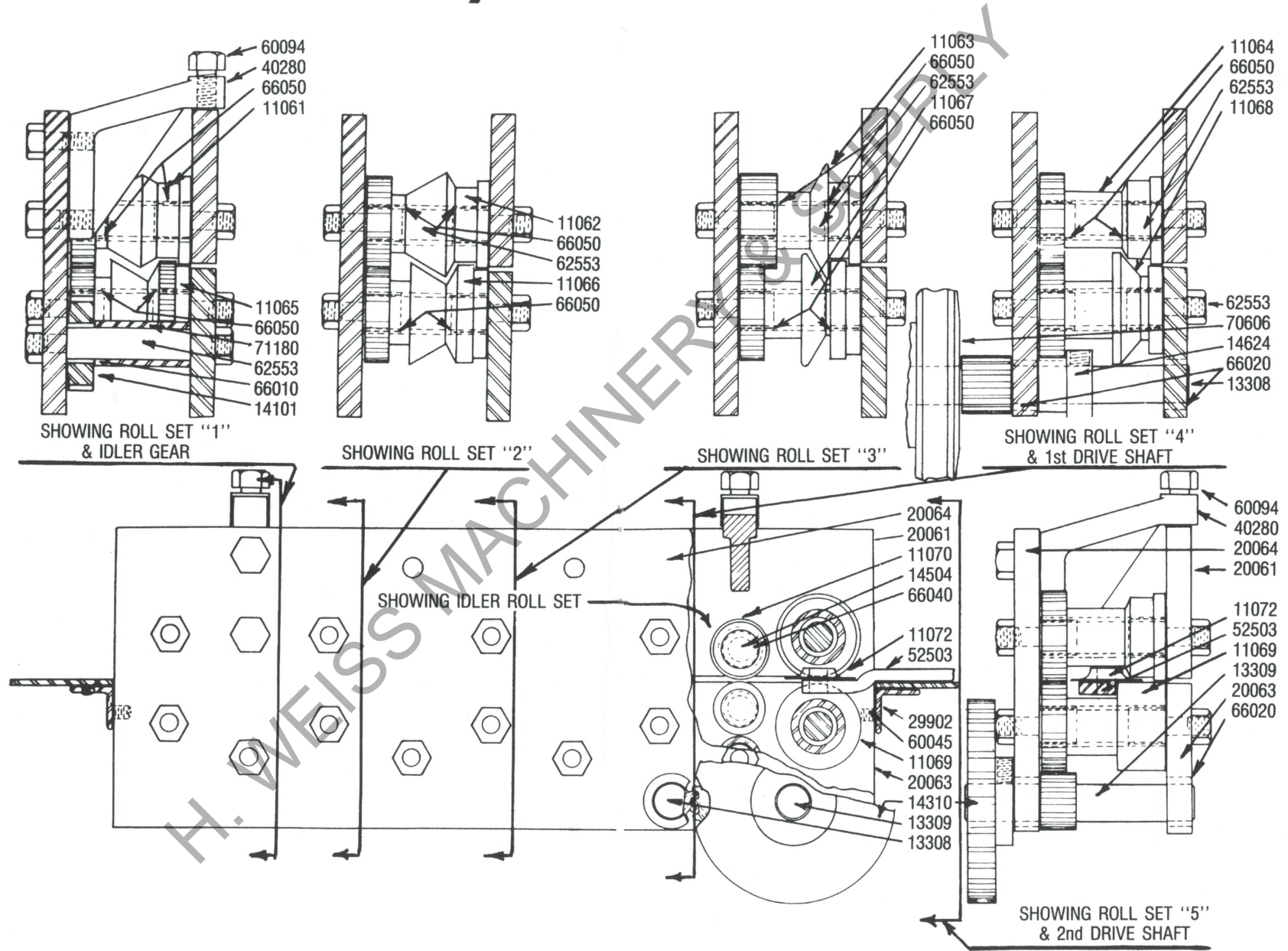


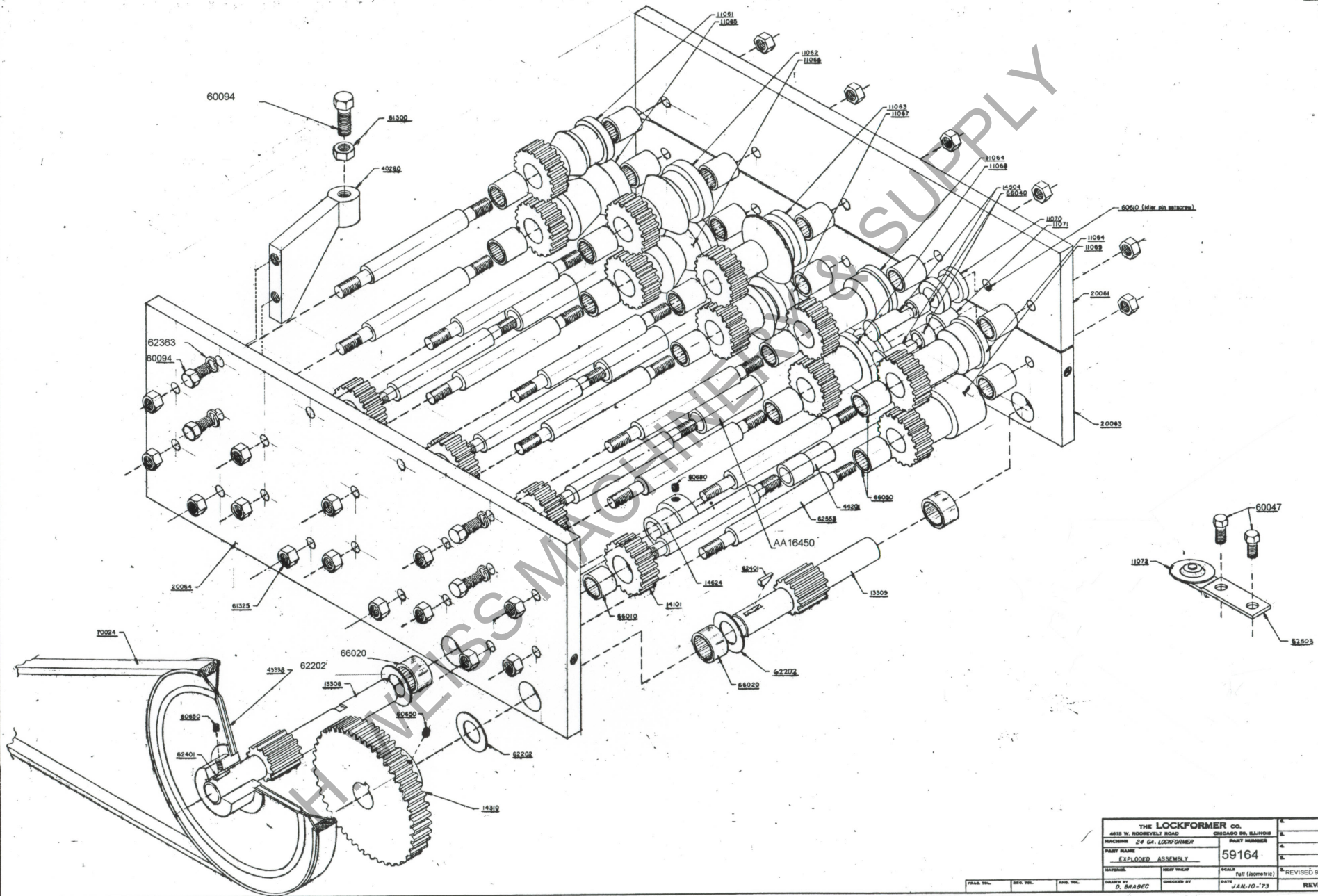
LOCKFORMER Model 24

LOCKFORMER

Where the Machines of Tomorrow are Made TodaySM

24-Gauge Lockformer Assembly





THE LOCKFORMER CO.		CHICAGO 90, ILLINOIS	
MACHINE 2 1/2 G. LOCKFORMER		PART NUMBER	
EXPLODED ASSEMBLY		59164	
MATERIAL	QUANTITY	SCALE	REVISED 92004 ASHOK.
DESIGNED BY D. BRABEC	DRAWN BY	DATE JAN-10-'73	REVISIONS M

PARTS LIST AND DESCRIPTION

Part Number	Description	Pieces Per Unit	Part Number	Description	Pieces Per Unit
20064	Back Housing Plate	1	62401	#9 Woodruff Key	2
20063	Lower Front Housing Plate	1	11070	Upper Idler Roll (need 1 66040)	1
20061	Upper Front Housing Plate	1	11071	Lower Idler Roll (need 1 66040)	1
21101	Feed Gauge Bar	1	14504	Idler Roll Pin	2
11069	Bottom Forming Roll B5	1	60094	3/8-16 x 1-1/4 HHCS FT	2
11068	Bottom Forming Roll B4	1	60047	5/16-18 x 3/4 HHCS	6
11067	Bottom Forming Roll B3	1	62553	Spacer Stud	14
11066	Bottom Forming Roll B2	1	50013	Stand Assembly	1
11065	Bottom Forming Roll B1	1	80206	Toggle Switch 82070	1
11064	Top Forming Roll T4 & T5	2	39508	Cover Assembly	1
11063	Top Forming Roll T3	1	70608	2 A5 23 5/8 Sheave	1
11062	Top Forming Roll T2	1	60650	5/16-18 x 5/16 SSS	1
11061	Top Forming Roll T1	1	61101	5/16-18 HN Heavy SF	8
13308	1st Drive Shaft w/Integral Gear	1	60680	3/8-16 x 3/8 SSS	1
13309	2nd Drive Shaft w/Integral Gear	1	60610	1/4-20 x 1/4 SSS	2
14310	Gear Driven with Hub	1	61300	3/8-16 Jam Nut SF	2
70606	Sheave Machine 9-1/8"	1	61325	3/8-24 Lck. Nut	28
52503	Opening Roll Hldr Assembly/EXIT GUIDE BAR	1	80525	Cord 14-3 x 10 Ft.	1
29902	Machine Support	2	70024	4 L 500 Belt	1
40280	Bracket Cast	2	80010	1/3 HP 1 60 18 56	1
66050	Bearing B1012 Torr	20	80481	BX Connector 1/2	2
66020	Bearing B128 Torr	4	60525	5/16-18 x 3/4 FHMS	4
11072	Opening Roll	1	62362	5/16 Lck. Washer	12
66040	Bearing B812 Torr	2	60795	4-3/16 Drive Screw U Cad	4
66010	Bearing B108 Torr	4	85156	Lf. Cap Name Plate	1
60045	5/16-18 x 1/2 HHCS	6	62202	3/4 x .031 Brs. Washer	4
71180	Spacer	3	60091	3/8-16 x 1 HHCS	4
44201	Spacer Step	1	62009	5/16 x 1/16 St1. Washer	8
14624	Thrust Collar	1	62363	3/8 Lock Washer	4
14101	Idler Gear (need 1 66020)	4	80493	Sta. Kon Connector B14250	2
			80607	Insulating Cap	2
			80608	Wire Joint	2
			80703	Toggle Switch Plate	1
			85178	Lockformer Logo	1

Operating Instructions

Holding the material against the angle gauge slide it into the forming head. Be sure that the material remains against the gauge until work is finished.

Make "Hold-Down Adjustment" to meet any variation in the material of your locality. Do not adjust unless material slips, tends to leave gauge, or curls up at finish.

If the material slips, tighten the studs equally until the condition is overcome.

It is very important that long sheets be fed into the machine flat and against the gauge for the start.

IMPORTANT: If proper care is taken, the small knife edge roll that holds the pocket of the Pittsburgh Lock open will not break. If burrs and twists from snip cuts are not flattened out, it will sometimes strike against the opening roll causing it to break.

SPECIFICATIONS

GENERAL: Recess for Pittsburgh Lock Flange is $\frac{5}{16}$ " deep . . . Hammer-over edge adjustable for width . . . Uses about $\frac{7}{8}$ " of material . . . One piece Pittsburgh lock rolls, gears and shafts . . . **FORMING UNIT:** Hardened and ground steel shafts, precision made case hardened steel forming rolls, machine cut gears . . . **CAPACITY:** 24 gauge and lighter . . . **MOTOR:** Standard equipment $\frac{1}{3}$ H.P., 110-220 V., 60 cycle, single phase, A.C., plugs into regular light socket (other types available) . . . **DRIVE:** single V belt . . . **STAND:** arc-welded steel construction finished in blue machinery enamel, heavy top plate . . . **DIMENSIONS:** 30" long, 14" wide, 16 $\frac{1}{2}$ " high overall including Power Flanger, 12" high without flanger, cabinet height 8" . . . **WEIGHT:** 150 lbs. . . . **ROLLER BEARINGS THROUGHOUT.** Power Flanger makes $\frac{1}{4}$ " Right Angle Flange on either straight or curved pieces to a radius as small as 1 $\frac{3}{4}$ ". It is fitted with an adjustable guide which can be set to hold metal to the gauge and automatically turn a flange to a given radius or a straight line.

Lubrication

The slow speed shafts

do not require lubrication. Check oil in motor occasionally.

If machine is used out of doors an oil or grease film will prevent rusting of surfaces.