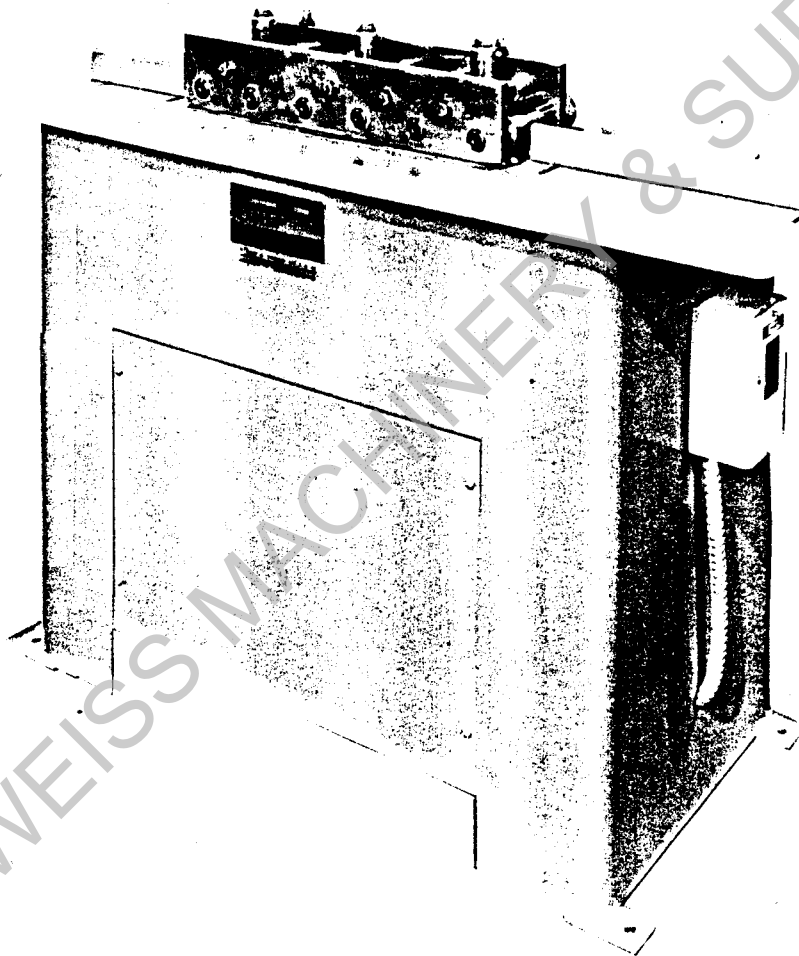


GENERAL OPERATING INSTRUCTIONS AND PARTS LIST



20 GA. HIGH SPEED PITTSBURGH MACHINE

20 GAUGE HIGH-SPEED

WIRING INSTRUCTIONS

The electricals on this machine are generally 220/440/3/60 and are normally wired at the factory for 220 volt current. Diagrams for change of voltage are on the motor.

OPERATING INSTRUCTIONS FOR PITTSBURGH ROLLS

Your Flagler High Speed Pittsburgh Machine has been adjusted at the Factory, but due to the variations in materials in different localities, it is sometimes necessary to re-adjust it. Proceed as follows;

1. If material slips or sticks on leaving forming head, tighten hold down stud at finishing end slightly.
2. If material works away from the feed gauge, tighten hold down studs at starting end until it corrects itself.
3. If material shows heavy pressure marks, loosen hold down studs slightly.

If a wider or narrower hammer-over edge desired, move the angle feed gauge forward or back. Be sure to keep the gauge parallel with the front edge of the top plate of the machine. MATERIAL SHOULD NOT TOUCH GAUGE ON FINISH END OF MACHINE.

It is very important that sheets be held flat and against the angle gauge when starting through for forming head. The 18" feed table has been designed to help the operator in this operation.

The Flagler High Speed will handle pieces 8" and longer. If shorter, leave on long piece, notch and cut afterwards.

INSTALLATION INSTRUCTIONS FOR AUXILIARY ROLLS

1. Remove top cover.
2. Remove rear section of top cabinet plate. This will expose the extended shafts on which the rolls are to be mounted.
3. (A) RIGHT ANGLE FLANGE AND DOUBLE SEAM (ACME)

In general, installation of any of these sets of rolls is the same. Pittsburgh lock rolls are installed at the factory, but the following will be helpful for auxiliary sets.

Mount angle feed gauge, if not already on machine. The rolls are identified by stampings on the outside end of the rolls, the letter and number corresponding to the position on the machine. For example -#T-1 roll is the top or upper roll in the first set; #B-1 is the bottom roll in the first set; #T-2 is the top roll in the second set, and so on. These rolls are mounted on their corresponding shafts with the numbered side faced out from the machine (this is very important) and held in place with the screws and washers provided for them. Be sure all screws are in place; Tighten rolls down securely and then proceed to adjust the gauge as per the adjustment instructions.

3. (B) DRIVE CLEAT ROLLS

Drive Cleat Rolls are installed on the side of the machine as shown in Fig. 1. Remove angle feed gauge. Mount the drive cleat feed gauge into position (Fig. 1.) Mount rolls on shafts as per instructions above, leaving roll #DC-T3 free to float without a screw or washer but with key in place. Tighten all other rolls securely and adjust the drive cleat feed gauge as per the adjustment instructions.

Note:

4. Replace rear section of top cabinet plate.
5. Adjust machine.
6. Replace top cover.
7. Machine ready to operate.

ADJUSTMENT INSTRUCTIONS

1. RIGHT ANGLE FLANGE, DOUBLE SEAM (AND ACME FORMS)

Angle feed gauge setting are best made by laying a straight edge along the outside faces of the rolls and suitably measuring from the straight edge as shown in Fig. 1. (See set up chart for dimensions).

2. DRIVE CLEAT ROLLS

Drive Cleat Rolls feed gauge is set by laying a straight edge on the outside of the gauge and measuring to the face of the rolls 3/4". (See Fig. 1.)

GENERAL OPERATING INSTRUCTIONS

Make sure that all of the adjustments are complete as per instructions. Start machine and run material into the forming rolls, taking care to hold material snugly against the angle feed gauge (Fig. 1.) It is of great importance when forming in either direction, check the feed gauge for parallel. If the material used is aluminum, see instructions covering adjustments.

LUBRICATING INSTRUCTIONS

Check and refill the four grease cups on the under side of the forming unit at least once a month. The slower speed shafts do not require lubrication. If machine is used out of doors, an oil or grease film will prevent rusting of surfaces.

FOR SAFETY PURPOSES DISCONNECT POWER BEFORE REMOVING COVERS TO CLEAN

COVERS MUST BE IN PLACE WHEN IN OPERATION

H. WEISS MACHINERY & SUPPLY

PHONE: (718) 605-0395 - www.hweiss.com

FLAGLER 20 GAUGE HI-SPEED

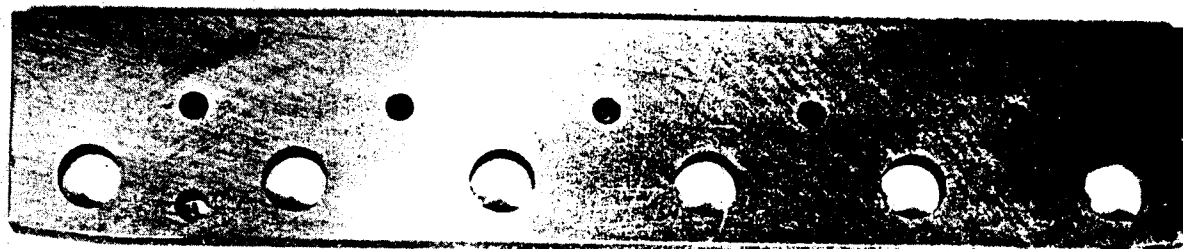
| Part no. | Description | Quantity |
|----------|----------------------------|----------|
| 16-001 | Bottom Front Plate | 1 |
| 16-002 | Bottom Back Plate | 1 |
| 16-003 | Top Front Plate | 1 |
| 16-004 | Top Back Plate | 1 |
| 16-005 | #1 Pinion Gear | 1 |
| 17-007 | #3 (or 2) Pinion Gear | 1 |
| 17-008 | Pinion Collar | 2 |
| 17-062 | Pinion Collar w/Keyway | 1 |
| 17-009 | Bull Gear | 1 |
| 17-010 | Roll Shaft | 12 |
| 17-012 | Roll Shaft Gear | 12 |
| 17-013 | Idler Gear | 4 |
| 17-014 | Driver Idler Gear | 1 |
| 17-015 | Plain Spacer | 7 |
| 17-017 | Plain Step Spacer | 2 |
| 17-018 | Plain Drilled Spacer | 3 |
| 17-019 | Drill & Tap Step Spacer | 2 |
| 17-020 | D & T Long Step Spacer | 1 |
| 14-052 | Snap Ring | 2 |
| 17-021 | Idler Roll Pin | 2 |
| 17-022 | Saddle Washer | 3 |
| 16-013 | Spring Washer # B-1250-040 | 24 |
| 14-054 | Spring Washer # B-0750-040 | 24 |
| 17-058 | Bearing 1612 | 24 |
| 20-005 | Bearing 162412 | 4 |
| 12-021 | Bearing 148 | 8 |
| 14-021 | Bearing 1412 | 2 |
| 11-009 | Bearing 1012 | 2 |
| 16-012 | Oilite TT-1709-01 | 2 |
| 17-024 | Opening Roll Holder | 1 |
| 17-059 | Hold Down Stud | 2 |
| 17-025 | Spacer Washers | 2 |
| 17-031 | Grease Bolt | 1 |
| 16-006 | --Cover Assembly-- | 1 |
| 16-007 | Top & Side | 1 |
| 17-035 | End | 2 |
| 16-009 | --Cabinet Assembly-- | 1 |
| 17-037 | Skirt | 2 |
| 17-038 | Louver Panel | 1 |
| 17-039 | Upper Side Panel | 2 |
| 17-040 | Feed Plate | 1 |
| 17-041 | Take-Off Plate | 1 |
| 16-010 | Side Plate | 2 |
| 17-063 | Feet | 2 |
| 17-044 | Bottom Side Angle | 2 |
| 14-040 | Lag Screw Plate | 4 |

FLAGLER 20 GAUGE HI-SPEED

| Part no. | Description | Quantity |
|----------|------------------------------|----------|
| 17-050 | Motor Support | 2 |
| 14-048 | --Motor Clamp Assembly-- | 4 |
| 14-049 | Base | 4 |
| 14-050 | Spacer | 4 |
| 17-046 | Lube Tube: 19" w/14-053 | 3 |
| 14-041 | Lube Lines: 12" w/14-053 | 2 |
| 14-053 | Lube Line Fittings | 10 |
| 17-051 | Motor (3N657-6) | 1 |
| 17-052 | Sheave (Driver) | 1 |
| 17-053 | Sheave (Driven) | 1 |
| 17-054 | Bushing | 1 |
| 17-055 | "V" Belt | 2 |
| 17-056 | Starter | 1 |
| 16-011 | Heater | 3 |
| 10-031 | Label-Manufacturer | 1 |
| 10-040 | Label-OSHA | 1 |
| 10-042 | Warning Label | 1 |
| 10-043 | Made In USA Label | 1 |
| 17-048 | Feed Gage | 1 |
| 17-049 | Take-Off Gage | 1 |
| 16-062 | Top 1 Pittsburgh Roll | 1 |
| 16-063 | Bottom 1 Pittsburgh Roll | 1 |
| 16-064 | Top 2 Pittsburgh Roll | 1 |
| 16-065 | Bottom 2 Pittsburgh Roll | 1 |
| 16-066 | Top 3 Pittsburgh Roll | 1 |
| 16-067 | Bottom 3 Pittsburgh Roll | 1 |
| 16-068 | Top 4 Pittsburgh Roll | 1 |
| 16-069 | Bottom 4 Pittsburgh Roll | 1 |
| 16-070 | Top 5 Pittsburgh Roll | 1 |
| 16-071 | Bottom 5 Pittsburgh Roll | 1 |
| 16-072 | Top 6 Pittsburgh Roll | 1 |
| 16-073 | Bottom 6 Pittsburgh Roll | 1 |
| 17-082 | Opening Roll | 1 |
| 16-075 | Top Idler Roll | 1 |
| 16-076 | Bottom Idler Roll | 1 |
| 17-150 | Top 1 3/8 Double Seam Roll | 1 |
| 17-151 | Top 2 3/8 Double Seam Roll | 1 |
| 17-152 | Top 3 3/8 Double Seam Roll | 1 |
| 17-153 | Top 4 3/8 Double Seam Roll | 1 |
| 17-154 | T. 5-10 3/8 Double Seam Roll | 1 |
| 17-157 | Btm 1 3/8 Double Seam Roll | 1 |
| 17-158 | Btm 2 3/8 Double Seam Roll | 1 |
| 17-159 | Btm 3 3/8 Double Seam Roll | 1 |
| 17-160 | Btm 4 3/8 Double Seam Roll | 1 |
| 17-161 | Btm 5 3/8 Double Seam Roll | 1 |
| 17-162 | Btm 6 3/8 Double Seam Roll | 1 |
| 17-048 | Feed Gage | 1 |

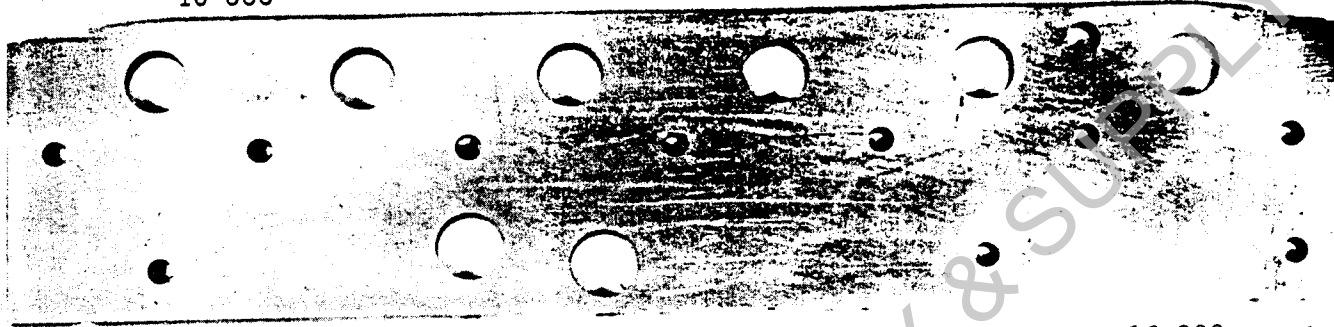
FLAGLER 20 GAUGE HI-SPEED

| Part no. | Description | Quantity |
|----------|------------------------------|----------|
| 17-049 | Take-Off Gage | 1 |
| 17-201 | Top 1 1 1/8 Dr. Cleat Roll | 1 |
| 17-202 | Top 2 1 1/8 Dr. Cleat Roll | 1 |
| 17-203 | Top 3 1 1/8 Dr. Cleat Roll | 1 |
| 17-205 | Top 5 1 1/8 Dr. Cleat Roll | 1 |
| 17-206 | Top 6 1 1/8 Dr. Cleat Roll | 1 |
| 17-207 | T. 7-10 1 1/8 Dr. Cleat Roll | 1 |
| 17-208 | Btm 1 1 1/8 Dr. Cleat Roll | 1 |
| 17-209 | Btm 2 1 1/8 Dr. Cleat Roll | 1 |
| 17-210 | Btm 3 1 1/8 Dr. Cleat Roll | 1 |
| 17-212 | Btm 5 1 1/8 Dr. Cleat Roll | 1 |
| 17-213 | Btm 6 1 1/8 Dr. Cleat Roll | 1 |
| 17-214 | B. 7-10 1 1/8 Dr. Cleat Roll | 1 |
| 12-213 | --Feed Gage Assembly-- | 1 |
| 12-214 | Base | 1 |
| 12-215 | Guide Rail | 2 |
| 14-211 | Straightener | 1 |
| 17-401 | Top 1 RAF Roll | 1 |
| 17-402 | Top 2 RAF Roll | 1 |
| 17-403 | Top 3 RAF Roll | 1 |
| 17-404 | Top 4 RAF Roll | 1 |
| 17-405 | Top 5 RAF Roll | 1 |
| 17-406 | Top 6 RAF Roll | 1 |
| 17-408 | Bottom 1 RAF Roll | 1 |
| 17-409 | Bottom 2 RAF Roll | 1 |
| 17-410 | Bottom 3 RAF Roll | 1 |
| 17-411 | Bottom 4 RAF Roll | 1 |
| 17-412 | Bottom 5 RAF Roll | 1 |
| 17-413 | Bottom 6 RAF Roll | 1 |
| 17-048 | Feed Gage | 1 |
| 17-049 | Take-Off Gage | 1 |



16-003

16-004



16-001

16-002



16-062



16-064



16-066



16-068



16-070



16-072



16-063



16-065



16-067



16-069



16-071



16-073



17-010



17-013



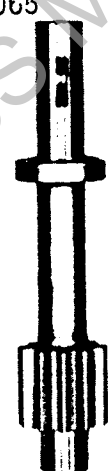
17-014



17-012



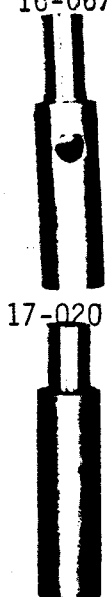
16-005



17-007



17-008



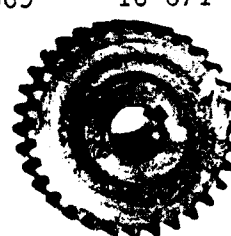
17-020

17-017

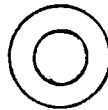


17-019

17-015



17-009



TT-1709-01



17-038



17-023



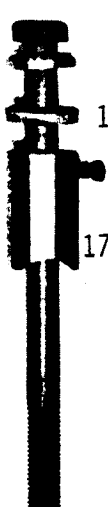
17-082



17-059

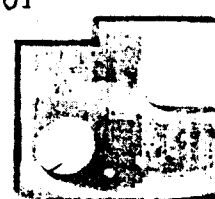


17-059

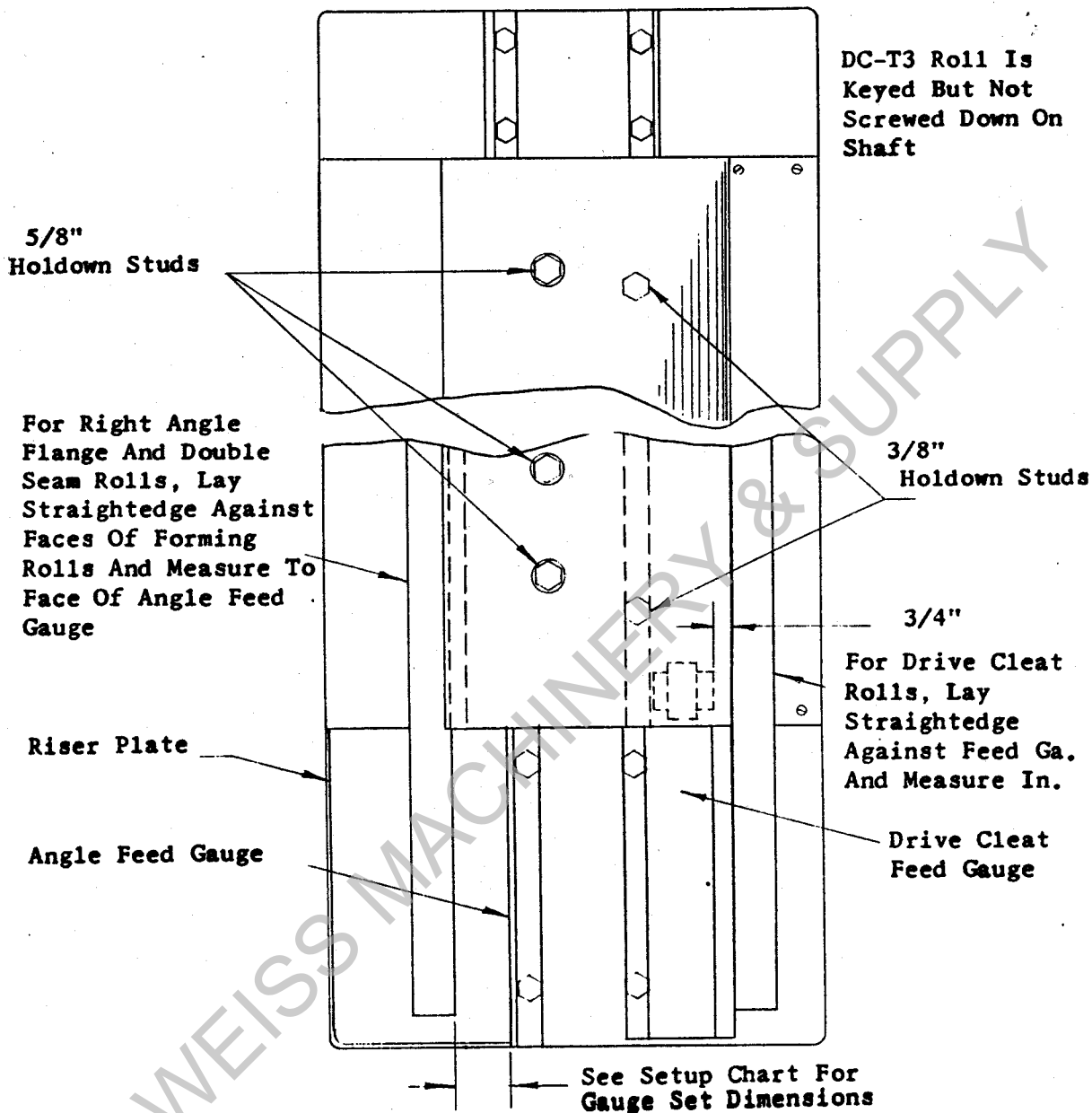


17

17



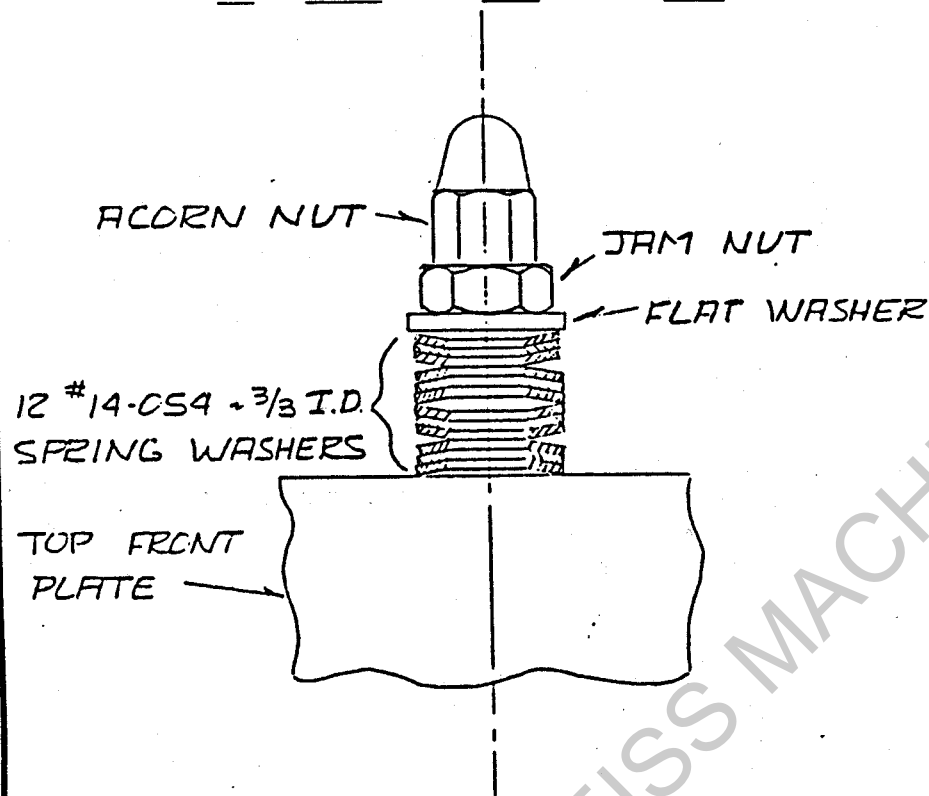
17-024



| GAUGE SET UP CHART | | | |
|---|--------|--------|----------|
| | Pitts. | D. S. | R. A. F. |
| Material Allowance (Appx.) | 1" | 1" | To suit |
| 20-22 Gauge Set (Appx.) | 2-3/8" | 1 1/4" | 1-1/16" |
| For Drive Cleat Rolls Shear Mat'l. 2-1/8" Max. Set Feed Ga. Straightedge 3/4" From Edges of Rolls (Fig 1) | | | |

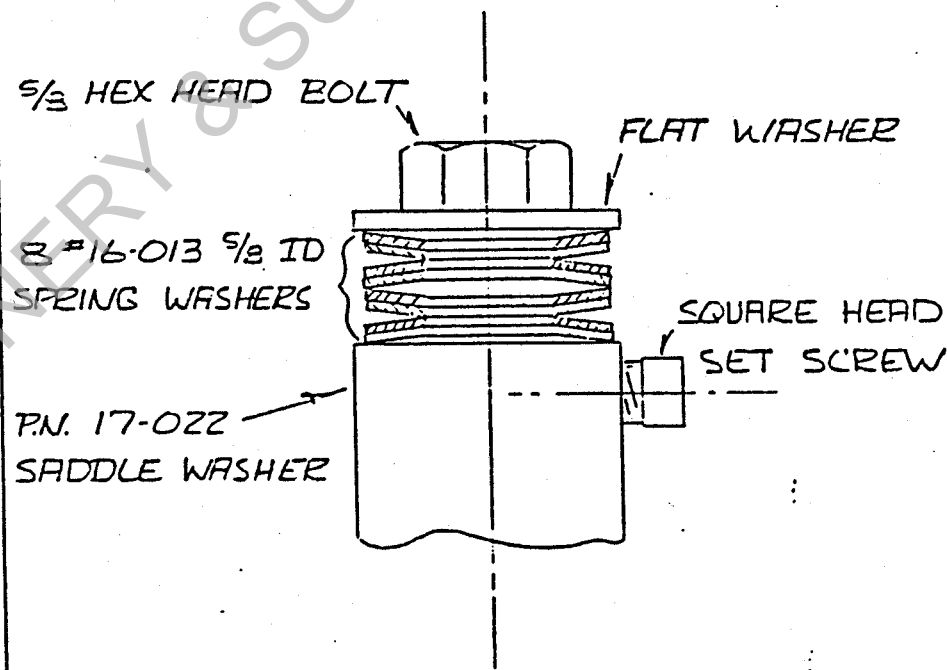
20 GA. HI-SPEED SPRING WASHER ASSY. INSTRUCTIONS
TO WORK PROPERLY THE ASSYS. MUST BE STACKED AS SHOWN

3/8 HOLD DOWN STUDS



WHEN INSTALLING TIGHTEN JAM NUT UNTIL SPRING WASHERS ARE FLAT THEN BACK OFF ONE TURN AND TIGHTEN ACORN NUT.

5/8 HOLD DOWN



WHEN INSTALLING TIGHTEN 5/8 BOLT UNTIL SPRING WASHERS ARE FLAT THEN BACK OFF 3/4 TURN AND TIGHTEN SQUARE HEAD SET SCREW