

SLIP ROLL FORMERS 0381, 381, 382, 383



No. 381

These machines are available in four different sizes. All four models offer the standard front roll drive. These units may be mounted directly to a sturdy work bench or to an optional fabricated pedestal, designed specifically for each unit.

MODEL	0381	381	382	383
Capacity.....ga.	24	22	22	20
Max Length.....ins.	42	36	30	24
Min Diameter.....ins.	3	3	3	3
Shipping Weight Boxed..lbs.	270	250	225	190

INSTRUCTIONS

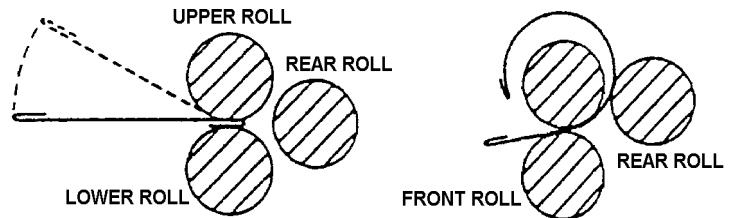
CAUTION: Be sure that the machine is securely bolted onto pedestal or to customer supplied bench. Pedestal or work bench should be bolted to floor.

1. Adjust Lower Roll (24) to grip the metal firmly and evenly but without straining the machine. Lower Roll (24) is adjusted up or down with the two lower Adjusting Screws (7).

2. Adjust Rear Roll (25) to form the metal up as it travels through the rollers. Rear Roll (25) is adjusted up or down with the two rear Adjusting Screws (7). Be sure Rear Roll (25) is parallel with Lower Roll (24). If rolls are not parallel, the formed metal will be conical in shape instead of cylindrical.

3. Feed the stock to the rolls only from the front.

4. As the front rolls grip the stock, lift the rear end of the metal upward. This will help reduce the flat spot on the leading edge of the sheet and will also cause the leading edge to pass over the rear roll readily.



5. The diameter of the formed cylinder is determined by the position of the Rear Roll (25). To increase the diameter of a cylinder, lower Rear Roll (25) by turning the two rear Adjusting Screws (7) counter clockwise. To reduce the diameter of a formed cylinder, raise Rear Roll (25) by turning the two rear adjusting Screws (7) clockwise. The two rear Adjusting Screws (7) should be turned an equal number of turns in order to keep the Rear Roll (25) parallel with the front gripping rolls.

6. To remove a cylindrical piece without distorting it, lift up Locking Handle (19), raise Right Hand Housing Cap (1/2) and turn Cam Handle (6) down. This raises the outboard end of the Upper Roll (23) and allows the formed cylinder to be slipped off of the Upper Roll (23).

7. The Lower Roll (24) and the Rear Roll (25) have grooves of varying widths in one end. These are for the purpose of accommodating a wired edge when forming a shape or when forming wire into a ring.

8. "X" points should be lubricated daily with a good grade machine oil. "Y" points should be greased weekly with Alemite #33 or equal.



ROPER WHITNEY OF ROCKFORD, INC.

2833 HUFFMAN BLVD., ROCKFORD, ILLINOIS 61103-3990 * 815/962-3011 * FAX 815/962-2227

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PEXTO FORMING MACHINES

Forming Machines, or Slip Roll formers, are intended for rolling sheet metal or forming cylinders of various diameters.

The two pinch rolls feed the sheet against the rear roll, curving the sheet and forming the cylinder. The rear or forming roll can be adjusted by screws on the rear of left and right end housings, varying the diameter of the required cylinder. Pinch rolls can be adjusted for stock thickness by screws on the front end of the housings.

The capacity ratings of **PEXTO** forming machines are based on forming mild steel, fully annealed, the full length of the rolls and are considered as standard by the sheet metal trade for forming rolls of a specified diameter and length. Definite capacities, however, depend upon the diameter and length of the cylinder to be formed and the number of passes through the rolls to obtain a given diameter. Stiffness of material and uniformity desired are also factors. When a forming machine is overloaded, the immediate result will be deflection in the center of the rolls, resulting in cylinders bulged in the center.

Three inch diameter forming rolls have longitudinal grooves in the rear forming roll to assist in starting the sheet. Forming rolls 3" in diameter and larger have all three rolls driven as standard. Three roll drive for rolls under 3" in diameter at extra cost.

In order to reduce the number of rear roll adjustments when sheets are of light gauge, proceed as follows:

1. Insert the sheet between two pinch rolls.
2. Bend the sheet upwards and slightly around the top roll.
3. Continue to pass the sheet through the machine.

This will also reduce the flat spot on the leading edge of the sheet.

The right-hand housing is provided with a hinged journal cap and lifting latch. After the cylinder is formed, the latch is lifted and the lever is pressed down. This raises the top roll and the cylinder can be slipped off the roll without distortion.

Forming machines are provided with grooves in the right end of the lower and rear rolls to allow for forming cylinders with a wired edge.

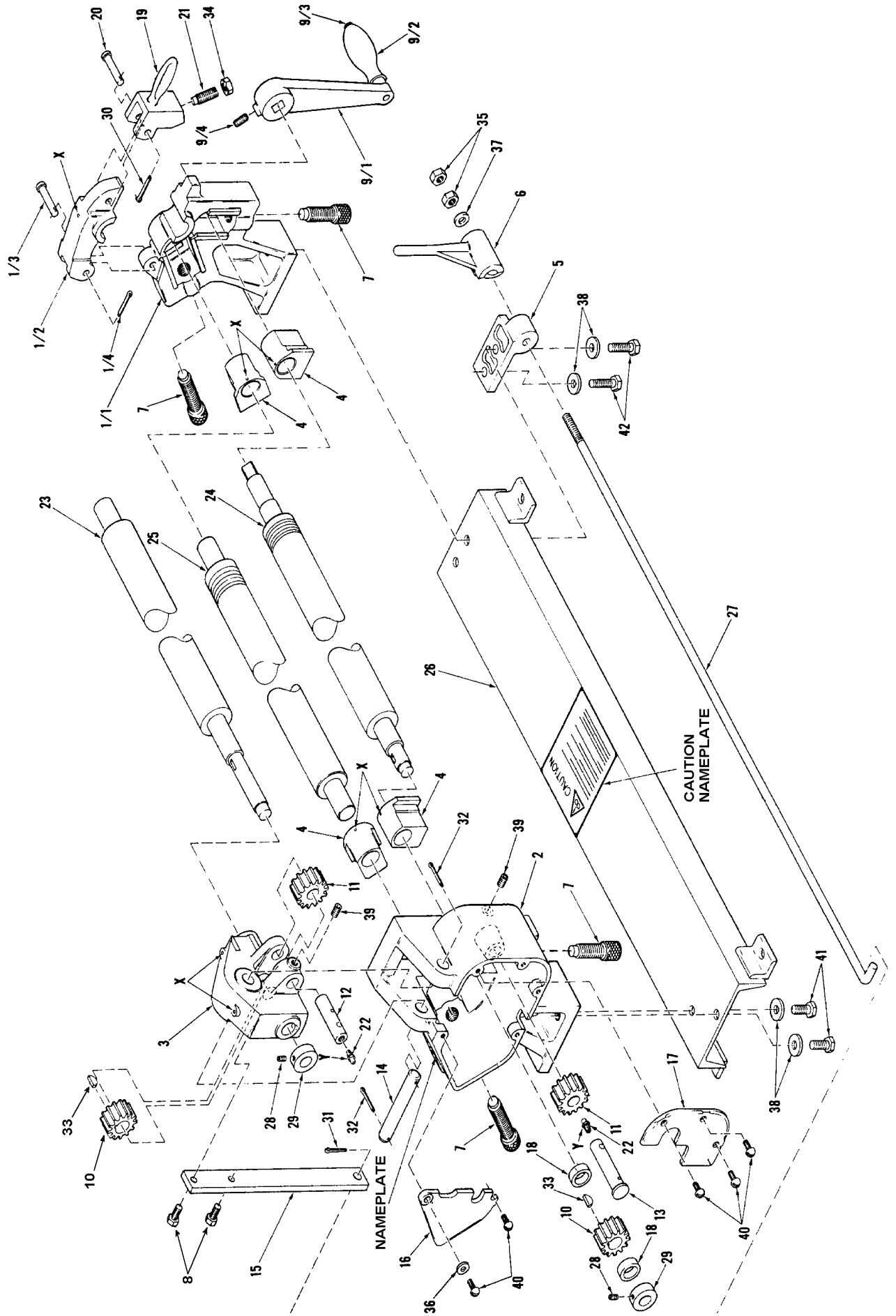
WARNING: Before operating, machines **must** be bolted to the work bench. If the floor stand has been provided, machine must be bolted to the floor stand with bolts provided. Stand **must** be securely lagged to the floor.



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PARTS IDENTIFICATION CHART - SLIP ROLL FORMERS 0381, 381, 382, 383



PARTS LIST --- 0381, 381, 382, 383

INDEX	CATALOG NO.	PART NAME	NO. REQ'D
1/1	267940011	Right Hand Housing Assembly	1
1/2	*	R. H. Housing Cap	1
1/3	*	Pin	1
1/4	*	Cotter Pin 3/32 x 5/8	1
2	767490101	Left Hand Housing	1
3	767170102	Rocking Box	1
4	767170103	Box	4
5	767210104	Cam	1
6	767210105	Cam Handle	1
7	767650175	Adjusting Screw	4
8	601012173	HHC Screw 3/8-16 x 3/4	2
9	230700008	Hand Crank Assembly	1
9/1	767460096	Crank	1
9/2	640356309	Handle	1
9/3	767210097	Crank Stale	1
9/4	621012132	Socket Set Screw 5/16-18 x 7/8	1
10	767380108	Roll Gear (10851)	2
11	767380109	Compensating Gear (10852)	2
12	767680111	Upper Compensating Gear Stud	1
13	767680112	Lower Compensating Gear Stud	1
14	767160113	Rocking Box Pin	1
15	767030114	Lifting Lever	1
16	767220115	Front Cover Plate	1
17	767220116	Rear Cover Plate	1
18	767630117	Lower Roll Spacer	2
19	267990001	Locking Handle	1
20	*	Pin	1
21	*	Locking Handle Screw	1
22	600134001	1/8 straight Alemite Fitting	2
23	767630080	Upper Roll - 0381	1
23	767630079	Upper Roll - 381	1
23	767630081	Upper Roll - 382	1
23	767630070	Upper Roll - 383	1
24	767630083	Lower Roll - 0381	1
24	767630082	Lower Roll - 381	1
24	767630084	Lower Roll - 382	1
24	767630071	Lower Roll - 383	1
25	767630086	Rear Roll - 0381	1
25	767630085	Rear Roll - 381	1
25	767630087	Rear Roll - 382	1
25	767630072	Rear Roll - 383	1

* Not Sold Separately - Part Of An Assembly

PARTS LIST --- 0381, 381, 382, 383

INDEX	CATALOG NO.	PART NAME	NO. REQ'D
26	767060089	Machine Base Assembly - 0381	1
26	767060088	Machine Base Assembly - 381	1
26	767060090	Machine Base Assembly - 382	1
26	767060073	Machine Base Assembly - 383	1
27	767030092	Cam Rod - 0381	1
27	767030091	Cam Rod - 381	1
27	767030093	Cam Rod - 382	1
27	767030074	Cam Rod - 383	1
28	621012126	Socket Set Screw 5/16-18 x 3/8	2
29	767260110	Collar	2
30	600073513	Cotter Pin 3/32 x 5/8**	1
31	600073514	Cotter Pin 3/32 x 3/4	1
32	600073527	Cotter Pin 1/8 x 1	2
33	600123909	#9 Woodruff Key	2
34	649023007	Check Nut 1/2-13**	1
35	649023006	Check Nut 7/16-14	2
36	678033104	Washer 5/16	1
37	678033106	Washer 7/16	1
38	678033107	Standard Washer 1/2	4
39	621012170	Socket Set Screw 3/8-16 x 1/2	2
40	615012130	Button Head Screw 5/16-18 x 5/8	5
41	601012271	Hex Head Cap Screw 1/2-13 x 1	2
42	601012275	Hex Head Cap Screw 1/2-13 x 1 1/2	2

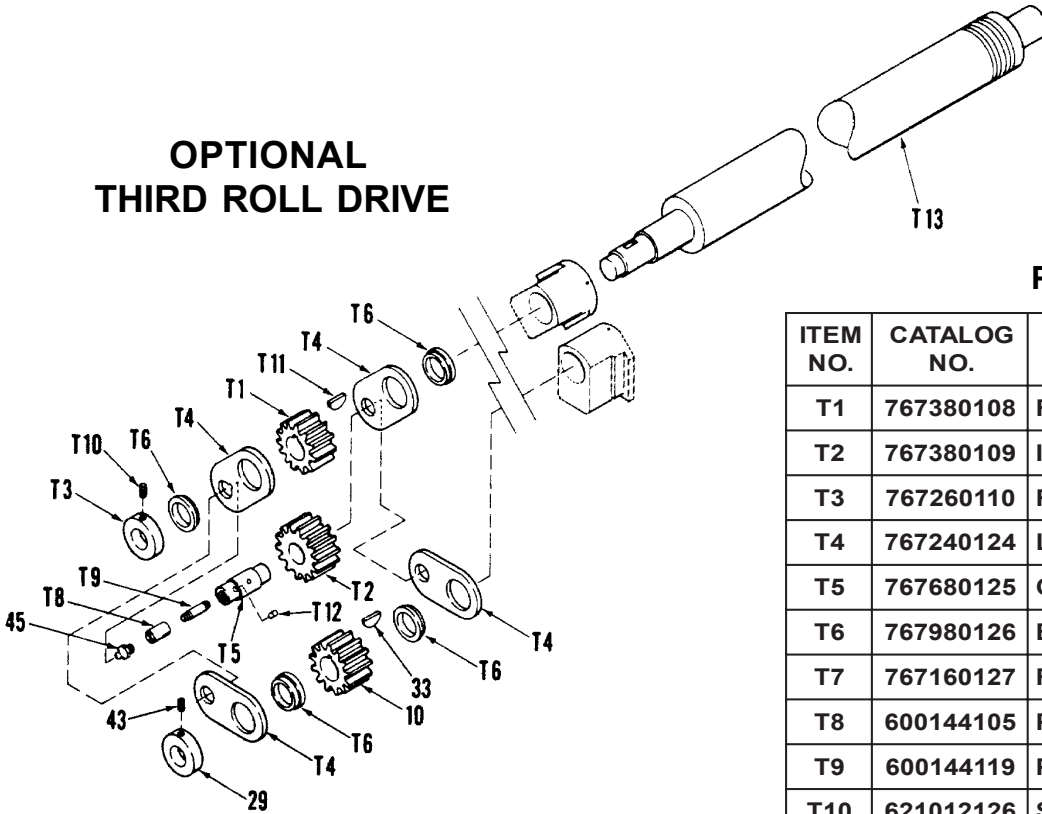
** Included in 267990001 Assembly

When ordering replacement parts, give model, letter, and serial number shown on machine nameplate, and part description shown on parts list.

We disclaim any responsibility whatsoever to the customer or to any person for injury to person, or damage to or loss of property or value, caused by any product which has been subjected to misuse, negligence or accident; or misapplied; or modified or repaired by unauthorized persons; or improperly installed. We shall in no event be liable for any consequential damage, loss or expense arising from the use of, or inability to use our product.

THIRD ROLL DRIVE PARTS LIST --- 0381, 381, 382, 383

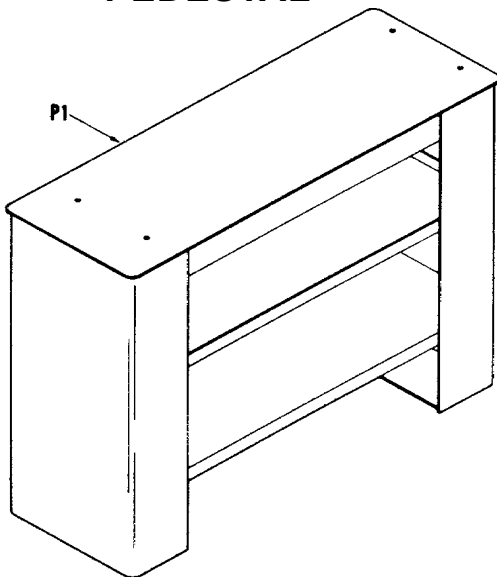
OPTIONAL THIRD ROLL DRIVE



PARTS LIST

ITEM NO.	CATALOG NO.	PART NAME	NO. REQ'D
T1	767380108	Rear Roll Gear	1
T2	767380109	Idler Gear	1
T3	767260110	Rear Roll Collar	1
T4	767240124	Link	4
T5	767680125	Gear Idler Shaft	1
T6	767980126	Bushing	4
T7	767160127	Roll Pin	1
T8	600144105	Pipe Coupling 1/8	1
T9	600144119	Pipe Nipple 1/8 x 1-1/2	1
T10	621012126	SS Screw 5/16-18 x 3/8	1
T11	600123909	#9 Woodruff Key	1
T12	767160128	Pin	1
T13	767630121	Rear Roll - 0381	1
T13	767630122	Rear Roll - 381	1
T13	767630123	Rear Roll - 382	1
T13	767630120	Rear Roll - 383	1
10	767380108	Roll Gear	1
29	767260110	Collar	1
33	600123909	#9 Woodruff Key	1
43	621012126	SS Screw 5/16-18 x 3/8	1
45	600134001	1/8 Alemite Fitting Straight	1

OPTIONAL PEDESTAL



PEDESTAL

ITEM NO.	CATALOG NO.	PART NAME	NO. REQ'D
P1	239006007	Pedestal - 0381	1
P1	239006007	Pedestal - 381	1
P1	239006006	Pedestal - 382	1
P1	239006006	Pedestal - 383	1