1.3.7. 90° Transfer Table

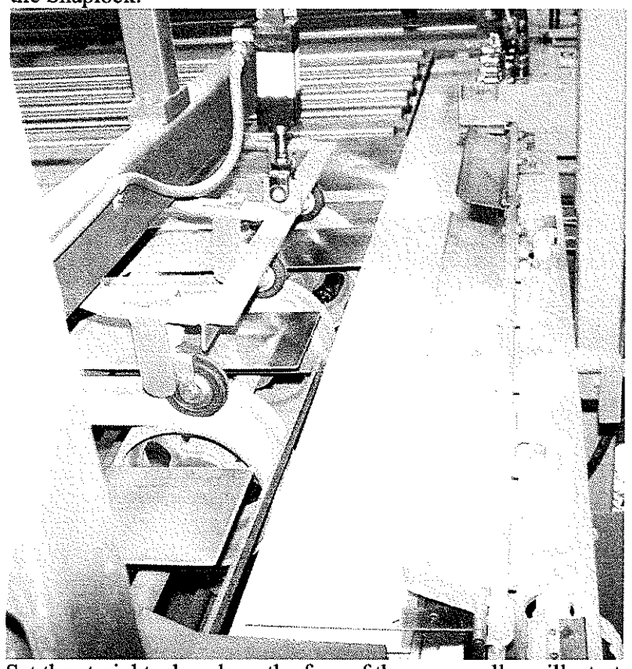
Table height is set for the 90° table at 36" from the floor to the top of the belts. Attach the 90° table to table #2 utilizing the roller attachment.

1.3.8. Female Lock (Turn Around Head)

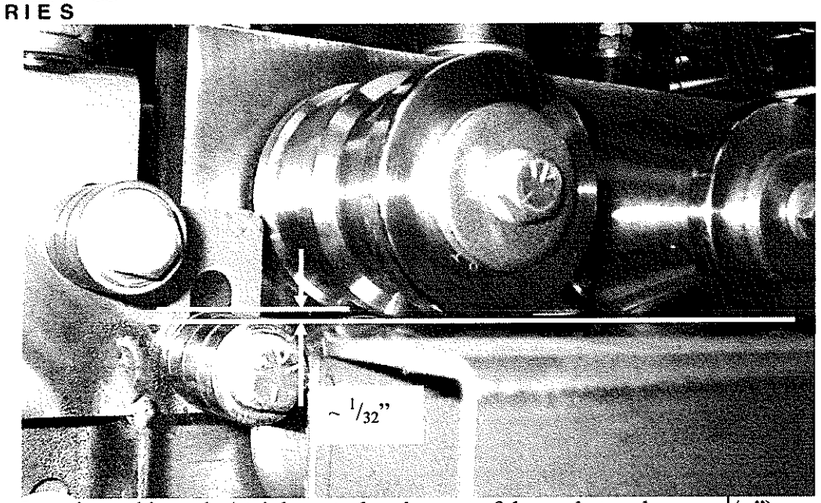
Attach the female lock to table #2 & #3 by aligning the chisel marks. The height may need to be adjusted to ensure a proper alignment.

1.3.8.1. Setting In-Feed Guides

Snap-Lock: 2 $^{5}/_{16}$" from the face of the rolls to the infeed guide (Roll Clearance: 0.010")
Pittsburg: 2 ¼" from the face of the rolls to the infeed guide (Roll Clearance: 0.015")
Set out feed adjustment with approximately $^{1}/_{32}$" elevation on part coming out on the Snaplock.



Set the straight edge along the face of the upper rolls as illustrated above. Using a square set the guide for a straight infeed for the female rollformer to the dimensions above (Snap-Lock: 2 $^{5}/_{16}$" Pittsburg: 2 ¼") this form does not always require a taper in.



Inserting a thin scale (stainless steel scale most of the pocket scales are ~$^{1}/_{32}$") between the rolls on station 7 & 8 by increasing the gap to allow insertion and then set another scale on top of that one and raise the discharge roll up to touch the top scale. This should set the discharge roll at the right height. Ensure that there is sufficient travel on the top roll to push the material back down while running. Then remove the scale and regap the rolls.

1.3.8.2. Engel Automatic Dispensing Unit

(Glue insertion on turnaround head)

1. Remove cover from roll forming machine.
2. Copper tubing provided as nozzle. Locate nozzle as close as possible to metal being formed.
3. Adjust the photo cell approximately $^{1}/_{4}$" over the sheet metal
4. Start a short piece of metal into the rolls and jog it through until the lead end is just up to the dispensing nozzle. Make any necessary final adjustments for perfect nozzle alignment.
5. Make sure dispensing tube is not hitting or touching formed metal by making minor adjustments to the tubing if necessary.
6. Run the partially formed metal the rest of the way through the machine.
7. Connect 110V power supply and air supply (approximately 50 psi on regulator gauge) (see drawing #KC8-61486). DO NOT CONNECT FLUID LINE AT THIS TIME.
8. Turn POWER SWITCH ON (pilot light should light).
9. Using a small scrap of sheet metal, slide it over the photo cells. After a few seconds a "click" will be heard and the pilot light on top of the timer unit will light. (This indicates that the extrusion gun is dispensing sealant.)
10. Remove the scrap piece of metal from over the photo cell. Within a few seconds another "click" will be heard and the time light will go off. (This indicates the extrusion gun has stopped dispensing sealant.)
11. Connect the fluid line from extrusion pump (see drawing KCS-61486) and make sure the pump has the proper air supply (approximately 50 psi on

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HALF

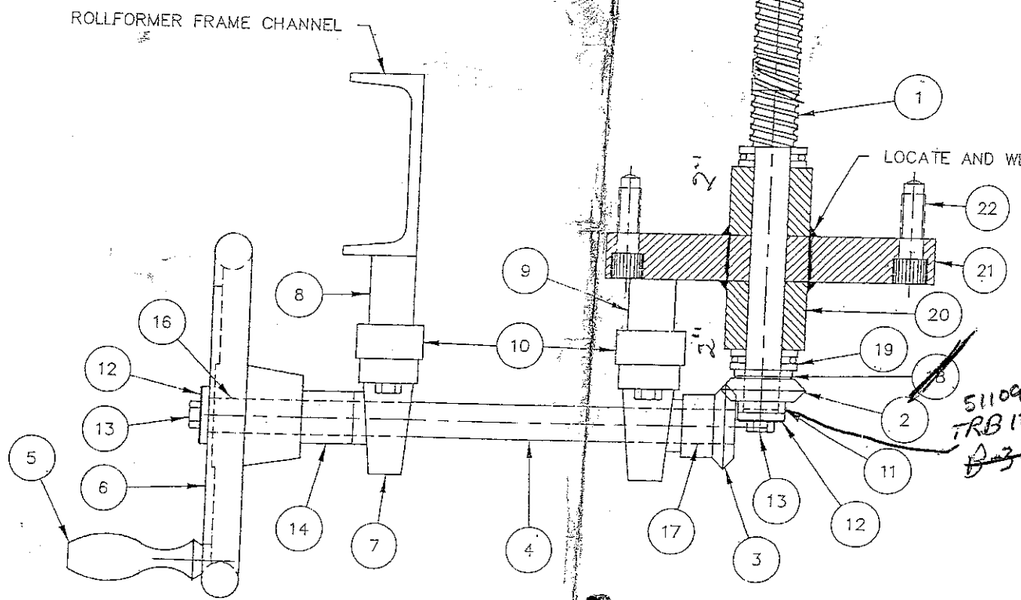
ITEM	REQ'D.	SYMBOL	P	M	DESCRIPTION
40	1	4920		X	RISER BLOCK
39	1	9994		X	CLAMP-SAGINAL LEAD SCREW
38	1	VF2S-116	X		FLANGE BEARING
37	8				SPRING PIN 1/4 X 1" LG.
36	8	EP 50000	X		TAP BOLT 1/2-20 X 4 LG. HHCS
35	8		X		BOLT 1/2-20 X 1 3/4 LG. SHCS
34	24		X		NUT 1/2-20 JAM
33					
32	8		X		BOLT 3/8-24 X 1 1/2 LG. HHCS
31	4		X		BOLT 3/8-24 X 1" LG. HHCS
30	32		X		BOLT 3/8-24 X 3/4" LG. HHCS
29	32	NO. 607	X		WOODRUFF KEY
28	16	NO. 808	X		WOODRUFF KEY
27	16	Z-16	X		DISC SPRINGS SCHNOOR
26	32	AMPLEX	X		BRONZE WASHER
25	7	TRB-2031	X		THRUST RACE
24	7	TRC-2031	X		THRUST RACE
23	23	IR-162020	X		INNER RACE
22	16	IR-1616	X		INNER RACE
21	39	B-2016	X		NEEDLE BEARING
20					
19	AR	4267-4		X	SPACER-INBOARD
18				X	
17				X	
16				X	
15				X	
14	8	4820-2		X	SPACER-POST
13	8	4219-21		X	END CAP WASHER
12	39	4219-1		X	END CAP WASHER
11	16	4211		X	GEAR-SPINDLE
10	7	4994-1		X	GEAR-IDLER
9	1	A-9920		X	MOUNT PLATE FLANGE BEARING
8	7	4165-1		X	GREASE BOLT
7	7	9512		X	IDLER SHAFT
6	16	4401		X	SPINDLE--ROLLER DIE
5	2	4173-3		X	SPREADER-LOWER
4	1	9876-1		X	SUPPORT PLATE
3	4	9664		X	UPPER BEARING CAGE
2	8	4167-9		X	POST
1	2	9912		X	BOTTOM SPINDLE HOUSING

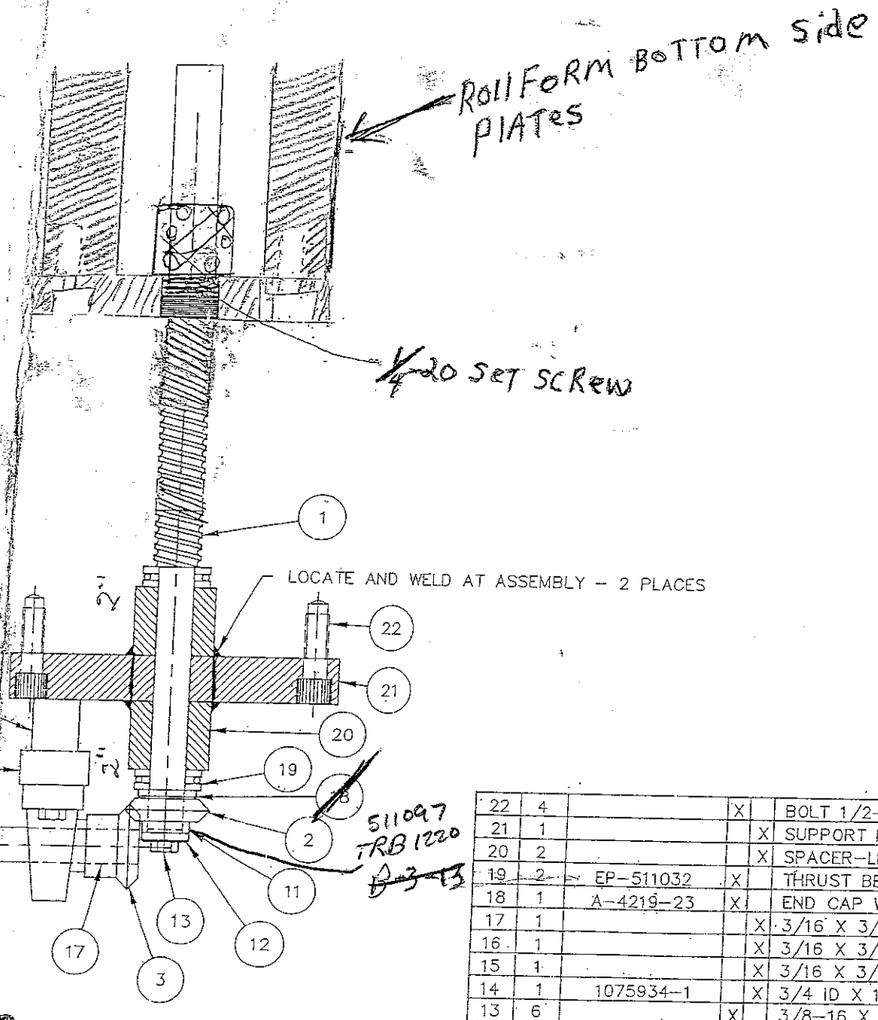
ENGEL INDUSTRIES, INC.
ST. LOUIS, MISSOURI

DATE 3/16/89
SCALE AS NOTED
DRAWN JERRY
CHECKED

SPINDLE HOUSING ASS'Y.
DH 800-U FIXED HD.

ASSY. NO. DISK #78 | DWG. NO. D-9890





ITEM	REQ'D		PUR	MAKE	DESCRIPTION
22	4			X	BOLT 1/2–20 X 1 LONG SHCS
21	1			X	SUPPORT PLATE
20	2			X	SPACER–LEAD SCREW
19	2	EP–511032	X		THRUST BEARING ANDREWS 2904
18	1	A–4219–23	X		END CAP WASHER
17	1			X	3/16 X 3/16 X 1 1/8 LONG KEY STOCK
16	1			X	3/16 X 3/16 X 1 1/2 LONG KEY STOCK
15	1			X	3/16 X 3/16 X 1/2 LONG KEY STOCK
14	1	1075934–1		X	3/4 ID X 1 1/4 OD X 1 1/8 LONG SPACER
13	6		X		3/8–16 X 1 1/4 LONG HEX HEAD BOLT
12	2	A–4219–1		X	END CAP
11	1	1073648		X	3/4 ID X 1/8 WALL X 1/4 LONG SPACER
10	2	4663–1		X	PILLOW BLOCK MOUNT
9	1			X	1 X 1 X 1 1/8 LONG CRS
8	1			X	1 X 1 X 1 1/2 LONG CRS
7	2	EP–511077	X		VPS 112 PILLOW BEARING
6	1	B–1072563		X	HAND WHEEL
5	1	EP–572046	X		CARR LANE HAND WHEEL KNOB
4	1	B–1078531		X	HAND WHEEL SHAFT
3	1	A–1078530		X	MACHINED MITER GEAR
2	1	EP–514009	X		MITER GEAR
1	1	B–1078529		X	LEAD SCREW

ENGEL INDUSTRIES
ST. LOUIS, MISSOURI

DATE 8/15/91
SCALE 1/2
DRAWN BENDER
CHECKED

TURN AROUND HEAD LIFT ASSEMBLY

ASSY. NO.
DWG. NO. C–10785