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 5/32” from the face of the rolls to the infeed guide (Roll Clearance: 0.010”)

Pittsburgh: 2 ¼” from the face of the rolls to the infeed guide (Roll Clearance: 0.015”)

Set out feed adjustment with approximately 1/16” 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 5/32” Pittsburgh: 2 ¼”) this form does not always require a taper in
1.3.8.2. Engel Automatic Dispensing Unit

(Procedure for dispensing 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 KCS-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. After 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...
<table>
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<th>M.N.</th>
<th>M.T.</th>
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ENGEL INDUSTRIES, INC.
ST. LOUIS, MISSOURI