Engel Rollformer
HB-1246

Features
~ Twelve (12) forming stations with tooling mounted on turned, ground and polished 1-1/4", stress-proof spindles
~ Extra large bearings with inner races
~ 5 HP, 230-460 volt, 60 cycle motor standard, producing approximately 50 FPM speed
~ Hardened steel in-feed guides to handle rough plasma cut edges
~ No opening rolls required on any set of tooling
~ Dual head units available, POR
~ Requires crimping of corners
~ Small parts feeder included for minimum parts of 6-inch length

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Roll Machine Instruction
Single Head Roll former M-1246
Index

I. Receiving Machine – p.1
   1. Unloading Procedure – p.1
   2. Positioning Machine – p.1
   3. Electrical Connections – p.2
   4. Lubrication – p.2
      A. Disconnection
      B. Roll Cover
      C. Gear grease
      D. Light oil
      E. Returning power
      F. Units with oil bath reducers

II. Roll Capacities and Material Requirements – p.2
    1. TDF – NB
    2. Clip Alternate

III. Operation – p.3

IV. Roll Clearance Setting and Head Tension – p.4
    1. Head Tension

V. Maintenance of Engel Roll Formers – p.5-6
    1. Forming heads
    2. Speed reduction
       A. Open gear type
       B. Right angle type
       C. Jackshaft
    3. General
    4. Suggested Lubricants

VI. Starting Gauge – p.7

VII. Setting for TDF – NB Rolls – p.8
1. #11 and #12 side rolls

VIII. Small Parts Feeder – p.9

IX. 1246 TDF – NB Side Roll Adjustment – p.8

X. Trouble – Shooting Guide

XI. Parts List/Assembly Drawing

XII. Assembly Drawing
ROLL MACHINE INSTRUCTIONS

Receiving Machine

- Visibly check machine for possible shipping damage
- When damage is evident, insist on the freight bill
- If repairs are necessary, contact Engel Industries, Inc.

Unloading Procedure

- When it is necessary to lift the machine off the transport vehicle and lower it to the ground, lift or support the machine by using the skids or by removing the side panels and lifting the machine by the bottom frame members. (NOTE: Lifting the machine by the load or cut-out table would result in extensive damage to the machine.) If the machine is extended onto a loading dock, then rubber can be put under the skids, or the machine can be slid or dropped on the skids.

Positioning Machine

- Move the machine to its desired location
- Remove the skids.
- Level machine before operation (leveling feet are provided) Once leveled, lock the jam nut at each corner as leg of the machine.
Electrical Connections

Supply electrical service to the starter box (located under the in-feed table) in accordance with local electrical codes. Refer to the connecting instructions on the inside of the starter box. (NOTE: If the machine is powered by a three (3) phase motor, it is possible to initially wire the motor in reverse. If this happens, switch two (2) of the three (3) supply wires. This will correct the rotation of the motor. Be certain that the machine is wired with a ground connection.)

Lubrication

After approximately every 400-500 hours of use, or every three (3) months, lubricate the machine in the following manner:

1. As a safety precaution, disconnect electrical supply.

2. Open the top roll cover (guard).

3. If the gears appear dry, apply open type gear grease to the exposed surfaces of all the gears. Recommended: Chem-A-Lube (made by National Chemsearch Corp., in Dallas, St. Louis, New York, Los Angeles and Montreal) or equivalent.

4. Apply light oil to the forming rolls to prevent galvanized build-up. This should be done as required.

5. Connect power, turn machine on, and with a pressure-type grease gun, and apply grease to lube fittings. (NOTE: Look under the right apron for access to fittings on side plate for idler gears). Recommended: Lubriko Grease (made by Master Lubricants Co., in Philadelphia, Boston, Chicago, San Francisco, Los Angeles, and Montreal) or equivalent.

6. For units with oil bath reducers, change oil at least every one (1) to two (2) years. Check gear reducer manufacturer’s recommendations.

Important: Do not use hypoid grease, as it will cause extensive damage to reducer gears.

Roll Capacities and Material requirements

<table>
<thead>
<tr>
<th>Shape</th>
<th>Material Required</th>
<th>Capacity</th>
</tr>
</thead>
<tbody>
<tr>
<td>&quot;TDF-NB&quot;</td>
<td>1 7/8&quot;</td>
<td>18-26 Gauge</td>
</tr>
<tr>
<td>Clip Alternate</td>
<td>2 1/4&quot;</td>
<td>20 Gauge</td>
</tr>
</tbody>
</table>
Operation

Press the start button on the starter control. The machine will start with an initial noise that of a slightly loud contact closure on the electric starter. It will then run very quietly.

1. Prepare sheet metal duct pieces as follows:
   A. Cut the flat sheet panel and notch it as required for the lock seam (Pittsburgh or Snaplock).
   
   CAUTION: The corner notch depth for the TDF-NB flange must be 2 1/2" deep in order to keep double or triple thickness of metal from passing through the TDF-NB rolls. If this happens the machine can be damaged and also the warranty ends.
   
   B. Roll-form the lock seams on the sheets with the beads or cross breaks facing down.

2. Hold the ends to the formed against the in-feed guide and feed the metal into the rolls. Be sure to keep the metal securely against the in-feed guide as it is being formed. Support the metal as it comes out of the forming rolls so that it does not fall to the floor.

DANGER: Be sure to keep clear of the part as it forms. Harm could occur if you were in front of the part, as it would press into anything in its way with great force.
M-1246 Style Machine
And
Head Tension

The 1246 Roll former is factory set and should not require adjustment. Should it be necessary to adjust the machine, the following procedure should be used.

Head Tension

Spring deflection is designed into the machine for running 26-18 Gauge without the need for adjustment. To adjust head tension, loosen top jam nut #52.

**NOTE:** Do not make any adjustments by loosening or tightening socket head bolt #51. After loosening top jam nut #52, tighten bottom jam nut #52 by hand using 3/8" open or box end wrench. Tighten down as snug as possible. Back bottom jam nut off 3 flats. Use two (2) wrenches to lock jam nuts together.
1. Forming Heads:

The forming heads of all standard Bigel Roll Forming machines are the same basic construction, and the lubrication procedure is common to all models. Roll shafts have Torrington Inner Races fitted on each end and rotate in Torrington Needle Bearing pressed into the side frame. These bearings are packed with the proper lubricant at assembly and need no further attention for approximately two thousand (2000) to three thousand (3000) hours of normal service.

The roll shaft bearings can be repacked by removing the outboard rolls, sliding the inner races toward the ends of the shafts and filling the void between the shafts and the bearings with a proper bearing grease*, by means of a grease gun equipped with nozzle that can be inserted in this void. The inner races are then slid back into place and the roller dies reinstalled in their proper relation.

WARNING: It will be noted that the extended spindles on one side of the machine will be flushed with the outer face of the rolls, and also the end cap washers “bottomed out”. Be sure that this is the case before attempting to operate the machine.

The idler, or transfer gears, that complete the gear train of the lower shafts rotate on Torrington Bearings and are lubricated through grease fittings located in the side plate underneath the outboard rolls on the right (gear side) of the machine. These should be lubricated with the same grade of bearing grease* used on the roll shafts every forty (40) to every eighty (80) hours.

2. Speed Reduction:

All models come equipped with the open gear type speed reducer bolted to the forming head, are lubricated through grease fittings located in the sheet metal panel on the left side of the machine. These should be lubricated every (8) hours of operation with the same grease* used on roll shafts.

All models equipped with right angle oil bath reducers have oil level plugs. This level should be maintained by adding, when necessary, manufacturer’s recommended oil that contains no harmful additives. H.P. or hypoid gear is not to be used.

Power is transmitted from the reducer to a jackshaft mounted to the underside of the forming head by a roller chain. This chain should be lubricated sparingly with 10-20W engine oil when signs of dryness appear.

The transfer shafts are in heavy-duty needle bearing assemblies and require the same lubrication schedule as the idler shafts.

3. General:

A. Keep all fasteners tight, with particular attention to cap screw that retain rolls on shafts and vertical roll adjustments. Check clearance between top and bottom rolls and see that they are maintained.

B. Keep all roller dies clean, with special attention to zinc and chip build-up.

C. Oil rolls daily with light machine oil. Keep all roller chains tensioned properly. Replace when excessively worn.

D. Avoid impact or heavy loading on entrance and exit tables.
4. **Suggested Lubricants:**

   *Lubriko™ density M-6 — for all shaft bearings*
   **Manufacturer's recommended oil — for all oil bush reducers**
   Molykote for all open gears

   In the event the above are not readily available, consult your local supplier for equivalents.

5. If trouble shooting is unsuccessful or additional information is needed, simply call the factory for assistance at (714) 038-0100
If material runs out along the edge being formed, proceed as follows:

1. Check the straightness of the sheared edge of the metal. Any bow or camber along the sheared edge will cause the material to run erratic through the rolls.
2. Check the starting gauge to be sure that it is straight and not bowed.

**Correct**

- Starting Gauge
- Straight Edge

**Incorrect**

- Starting Gauge
- Straight Edge

**Drawing No. 3**

Check the alignment of the starting gauge with the rolls.

(Note: Mis-alignment of the starting is the most common cause of run-out. This gauge must be aligned to control the amount of metal as to width to be passed through the roller dies. It must also guide and hold the metal in a straight line as the metal is passing through the roller dies).

Instructions for aligning starting gauge: Refer to drawing No. 4

Set the in-feed guide off outside end of tooling using straight edge, measure from straight edge to in-feed guide. **Note:** 2 9/16" for dimension "A" and 2 19/32" for dimension "B".

**Diagram 4**

1) Place straight edge against roller dies as shown
2) Set in-feed guide to dimensions shown with respect to the straight edge
1. Set side rolls 11 and 12 as shown. If overhead runner cushion rolls are not adjusted properly (approximately .120) above the tie plate, you will not be able to obtain 90°.

Note: Front of part is over bent approx. 2 degrees
Center should be 90 degrees
Rear of part is under bent 1-2 degrees
Use of Small Parts Feeder

The 1246 TDF-NB comes from the factory equipped with a small-part-feed system. A small part is anything less than 18 inches in length (direction of flow). (NOTE: Nothing less than 18 inches can be run independently of any TDF roll form machine).

1. To feed small parts through the 1246 TDF-NB, move small parts feeder up to the in-feed guide on the tie plate.

2. Place small part on the feed assembly with the raw edge against the in-feed guide.

3. Use two (2) clamps, one (1) at each end of small parts, always clamp small parts to small parts feeder as far away from the rolls as possible, to insure there will be no interference with guard or overhead rubber cushion rolls.

4. Push feeder and part into the first station. If part is smaller than eight (8) inches, you will need to push the part completely through from start to finish. If larger than eight (8) inches, you will have to help it out of station #15 and #16.

If overhead rubber cushion rolls are not adjusted properly (approximately .120) above tie plate, you will not be able to obtain 90° at point #5.
Troubleshooting

1. **Metal runs away from in-feed guide**
   A. Fasteners may have come loose
   B. Check in-feed guide adjustment (p.7)
   C. Machine must be level
   D. Roll adjustment (p.8)

2. **Flanges are not 90°**
   A. See page 8 for side rolls
   B. See page 8 for rubber cushion rolls

3. **Hem is too short or too long**
   Move the in-feed guide in accordance with instructions on page 7

4. **Machining will not start or motor makes loud humming noise**
   See page 11

5. **Severe jam occurs and parts are broken**
   Call the factory for assistance
3 Phase Pre-wired Starter

DISCONNECT SUPPLIED BY CUSTOMER

GREEN GROUND

PENDANT CORD IS 16/4
**WARNING**

NEVER PUT YOUR HANDS IN THE POINT OF OPERATION OF ANY MECHANICAL OR ELECTRICAL DEVICE.

IF A MACHINE IS JAMMED, NEEDS ADJUSTMENTS, NEEDS DIE CHANGES, ETC., ALWAYS DO A LOCK-OUT/TAG-OUT PROCEDURE WHICH MEANS THE POWER MUST BE OFF AND LOCKED-OUT AND ANY RAMS OR RAMS WILL BE BLOCKED TO ENSURE SAFETY. THIS IS A FEDERAL OSHA REQUIREMENTS AND MUST BE A WRITTEN AND TRAINING TYPE OF PROGRAM.