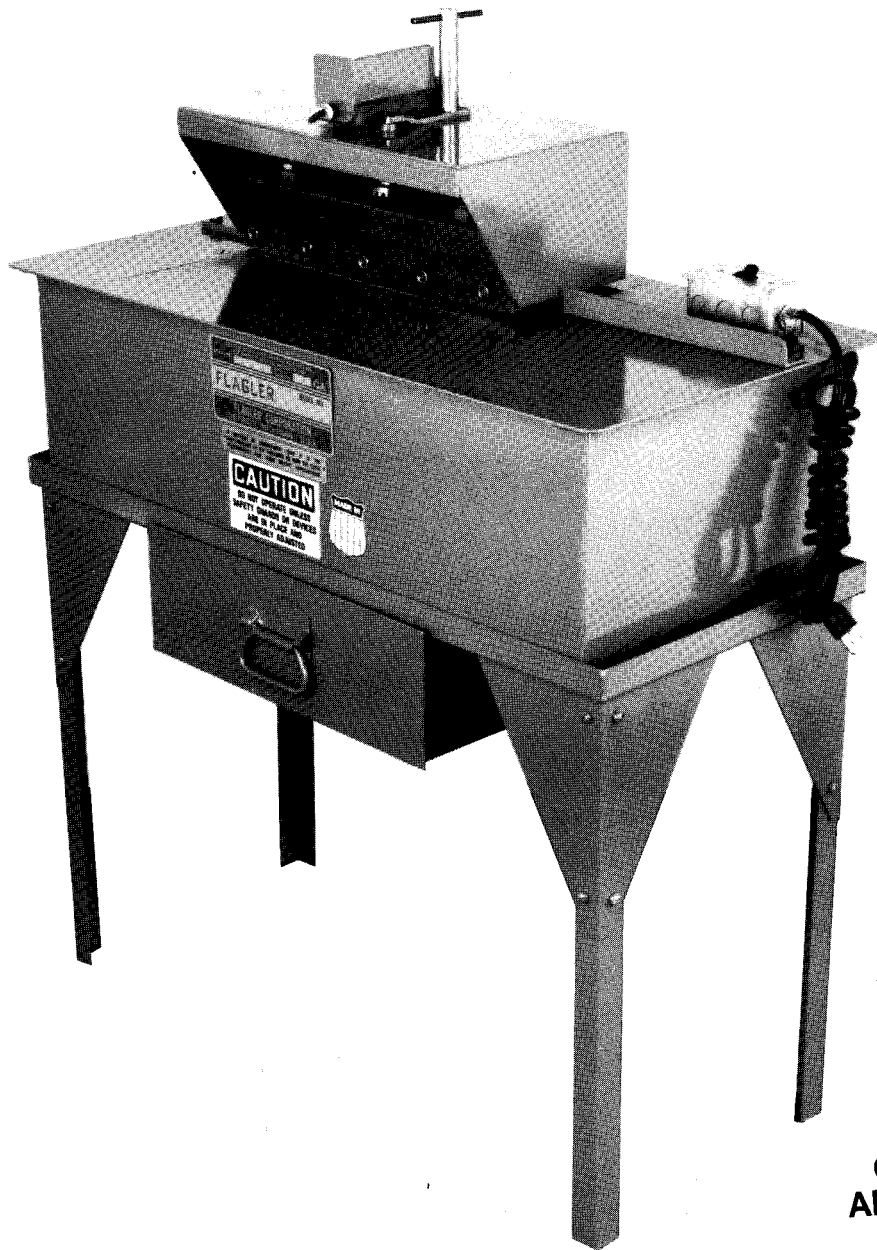


flagler

Designers and Manufacturers of Sheet Metal Roll Forming Machinery

24 Junior Pittsburgh Machine

Operating Instructions and Parts List



OUR NEW
AREA CODE IS
586

56513 Precision Drive., Chesterfield, MI 48051

Phone (810) 749-6300

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Operating Instructions

A feed gauge is located on the entrance end of the machine. Place the metal (24 Ga. Max) against this gauge and slide it into the forming head of the machine. The machine has been tested and adjusted at the factory, however to compensate for variations in material, it is necessary to make certain adjustments from time to time.

1. If the material pulls away from the feed gage, tighten the hold down stud at the entrance end until it corrects itself.
2. If the material slips or sticks upon exiting the forming head, tighten the hold down stud at the exit end slightly.

In feeding long sheets through the machine, be sure that they are flat against the table as well as against the feed gage, especially when the metal enters the roller dies.

COVER MUST BE IN PLACE WHEN IN OPERATION

CAUTION

Burrs and jagged edges should be flattened out so that they do not hit the opening roll, which might cause breakage. If the edge of the sheet to be formed is kept smooth, the blade-edged roll, which holds open the pocket in the Pittsburgh lock, will not chip or break.

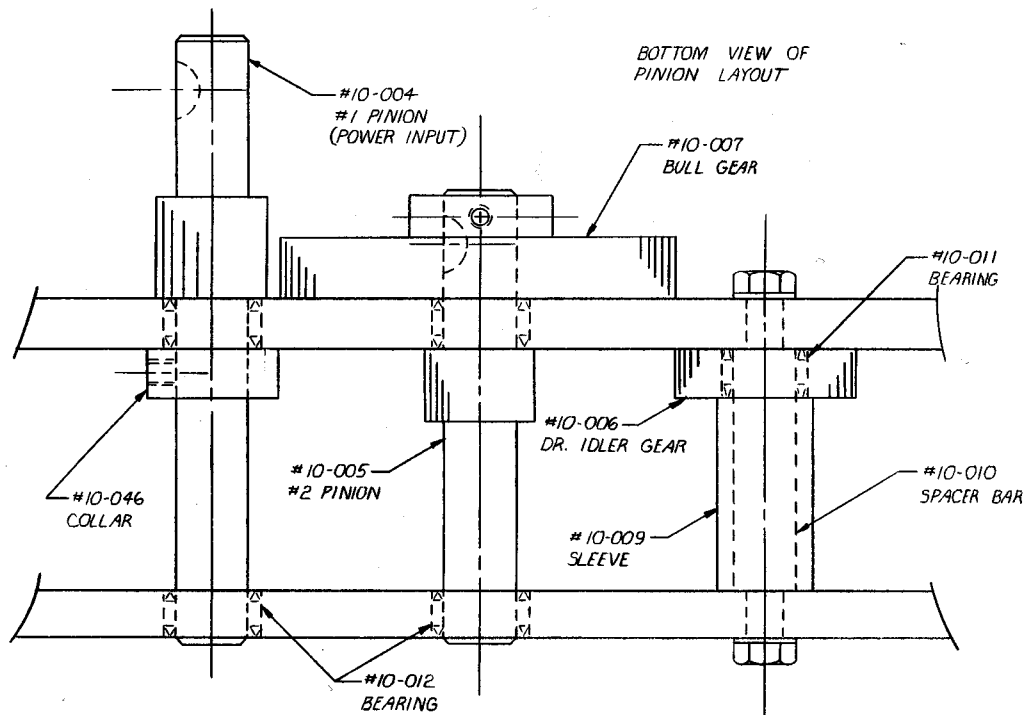
LUBRICATION

Due to the low speed of this machine, the shafts do not require lubrication. However if galvanized metal is to be used, the roller dies must be periodically lubricated to remove any galvanized buildup. Specifically, the opening roll should be kept free of any type of buildup. This can be accomplished using Flagler Lubaroll. Also, the motor should be oiled periodically and not less than three times a year.

SPECIFICATIONS

Length 30" x Width 14" x Height 12", or 16-1/2" with the optional Flanging Attachment. Approximate weight 150 lbs. Needle bearings throughout. Motor, standard 1/2 HP 115 volt. AC Drive, single "V" belt. One piece machine cut, and hardened Pittsburgh lock rolls, gears, and shafts.

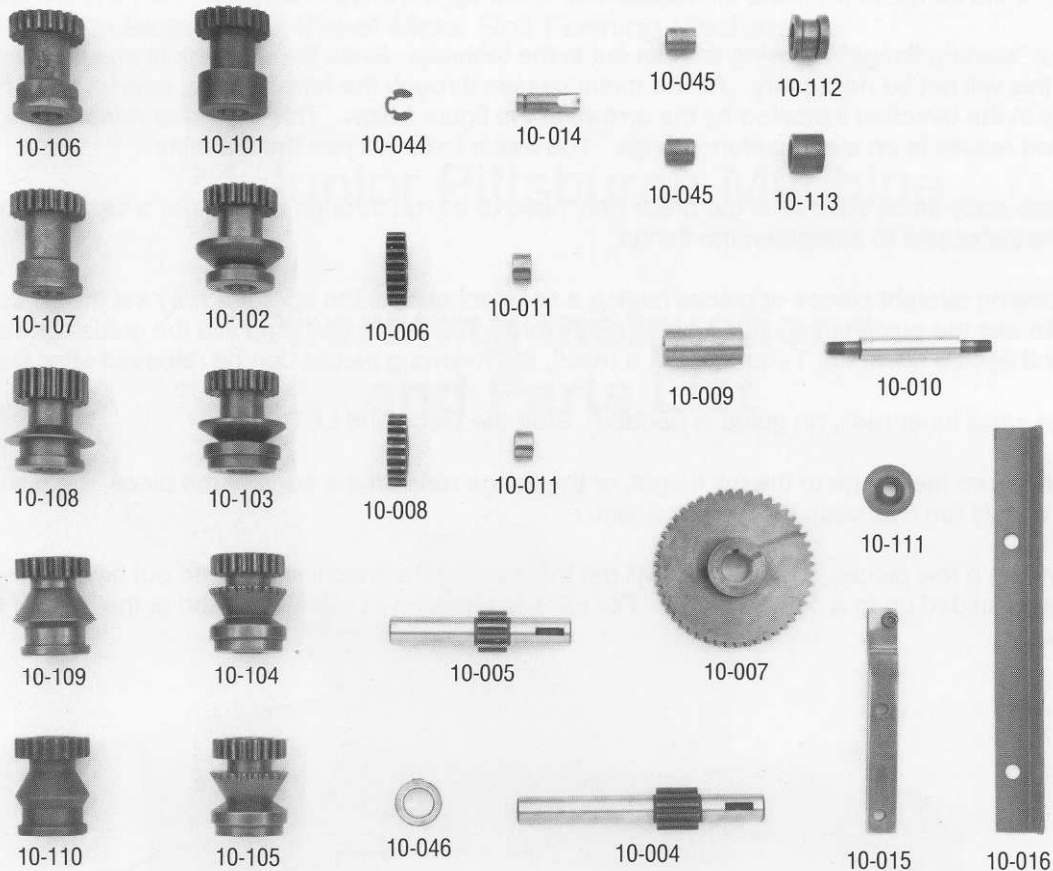
Capacity, 24 to 30 gauge mild or galvanized sheet metal. The Pittsburgh lock takes 7/8" to 1" material. Depth of pocket is 5/16". Flanging Attachment produces 1/4" right angle flange on straight pieces or on curved pieces to a radius as small as 1-3/4".



Machine on cover shown with optional Flanging Attachment and Floor Stand

Important: Disconnect Power Before Removing Covers for Any Reason

Parts List for Flagler Model 24 Junior



| Part # | Description | Qty | Part # | Description | Qty |
|--------|----------------------------------|-----|--------|---------------------------|-----|
| 10-001 | Back Plate | 1 | 10-034 | Pulley (Driven) | 1 |
| 10-002 | Lower Front Plate | 1 | 10-035 | "V" Belt | 1 |
| 10-003 | Upper Front Plate | 1 | 10-036 | Power Cord | 1 |
| 10-004 | #1 Pinion Gear* | 1 | 10-038 | Manual Switch | 1 |
| 10-005 | #2 Pinion Gear* | 1 | 10-044 | Snap Ring* | 2 |
| 10-006 | Driver Idler Gear* | 1 | 10-045 | Bushing* | 2 |
| 10-007 | Bull Gear* | 1 | 10-046 | Pinion Collar* | 1 |
| 10-008 | Idler Gear* | 3 | 10-101 | Bottom 5 Pittsburgh Roll* | 1 |
| 10-009 | Sleeve* | 4 | 10-102 | Bottom 4 Pittsburgh Roll* | 1 |
| 10-010 | Spacer Bar* | 14 | 10-103 | Bottom 3 Pittsburgh Roll* | 1 |
| 10-011 | Bearing 108* | 24 | 10-104 | Bottom 2 Pittsburgh Roll* | 1 |
| 10-012 | Bearing 128-OH | 4 | 10-105 | Bottom 1 Pittsburgh Roll* | 1 |
| 10-014 | Idler Roll Pin* | 2 | 10-106 | Top 5 Pittsburgh Roll* | 1 |
| 10-015 | Opening Roll Bracket (with pin)* | 1 | 10-107 | Top 4 Pittsburgh Roll* | 1 |
| 10-016 | Feed Gage* | 1 | 10-108 | Top 3 Pittsburgh Roll* | 1 |
| 10-017 | Angle Iron Head Support | 2 | 10-109 | Top 2 Pittsburgh Roll* | 1 |
| 10-018 | Pressure Bracket (Casting) | 2 | 10-110 | Top 1 Pittsburgh Roll* | 1 |
| 10-019 | Cover Assembly | 1 | 10-111 | Opening Roll* | 1 |
| 10-022 | Cabinet Assembly | 1 | 10-112 | Top Idler Roll* | 1 |
| 10-032 | ½ HP Motor | 1 | 10-113 | Bottom Idler Roll* | 1 |
| 10-033 | Pulley (Motor) | 1 | | | |

*Denotes illustrated part.

Contact your Flagler Distributor for price and availability of these and other Flagler Products.

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