



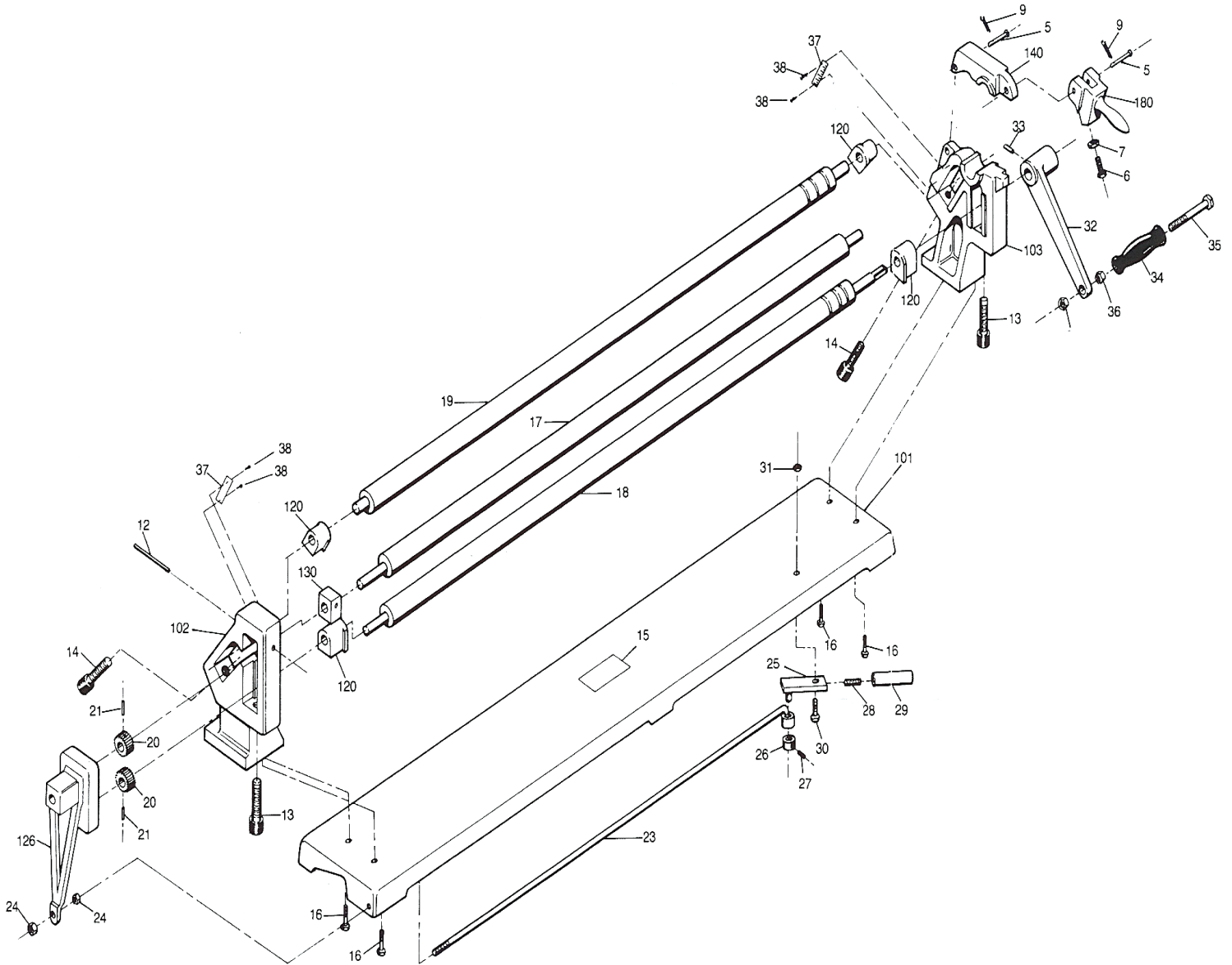
Model SR36 Shown

Models SR24, SR36 & SR42 Slip Rolls Operation, Parts and Maintenance Manual

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|------------------|------------------------|
| Model: | Purchased From: |
| Serial #: | Date Received: |

USA  MADE

SR24 SR36 SR42 PARTS



SR24 SR 36 SR42 / Parts List

| PART # | DESCRIPTION | REQ'D # | PART NO. | DESCRIPTION | REQ'D # |
|---------|------------------------|---------|----------|------------------------|---------|
| SR-101 | BASE | 1 | SR-21* | SPLIT PIN, GEAR | 2 |
| SR-102* | LEFT HAND, SIDE FRAME | 1 | SR-126* | GEAR COVER | 1 |
| SR-103* | RIGHT HAND SIDE FRAME | 1 | SR-23 | ROD, ROLL LIFT | 1 |
| SR-140* | TOP LATCH | 1 | SR-24* | NUT, ROLL LIFT ROD | 2 |
| SR-5* | PIN, LATCH | 2 | SR-25* | BRKT, ROLL LIFT | 1 |
| SR-6* | BOLT, TOP LATCH | 1 | SR-26* | LOCK, COLLAR | 1 |
| SR-7* | NUT, TOP LATCH | 1 | SR-27* | SCREW, COLLAR LOCK | 1 |
| SR-180* | LOCK, TOP LATCH | 1 | SR-28* | STUD, HANDLE | 1 |
| SR-9* | COTTER KEY | 2 | SR-29* | HANDLE, ROLL LIFT | 1 |
| SR120* | BLOCK, ROLL ADJ | 4 | SR-30* | SCREW, LIFT BRKT. MTG. | 1 |
| SR-130* | BLOCK, TOP ROLL SWIVEL | 1 | SR-31* | NUT, LIFT BRKT. SCREW | 1 |
| SR-12* | PIN, SWIVEL BLOCK | 1 | SR-32* | CRANK | 1 |
| SR-13* | SCREW, PINCH ROLL ADJ | 2 | SR-33* | SCREW, CRANK LOCK | 1 |
| SR-14 | SCREW, IDLER ROLL ADJ | 2 | SR-34* | HANDLE, ROLL CRANK | 1 |
| SR-15* | NAME PLATE | 1 | SR-35* | SCREW, CRANK HANDLE | 1 |
| SR-16* | SCREW SIDE FRAME MTG. | 4 | SR-36* | NUT, HANDLE SCREW | 2 |
| SR-17 | TOP ROLL | 1 | SR-37* | SCALE | 2 |
| SR-18 | LOWER PINCH ROLL | 1 | SR-38* | DRIVE SCREW, SCALE | 4 |
| SR-19 | IDLER ROLL | 1 | SR-39 | FLOOR STAND (OPTIONAL) | 1 |
| SR-20* | GEAR, ROLL DRIVE | 2 | | | |

FORWARD

This manual has been prepared for the owner and operators of the TENNSMITH Slip Rolls. Its purpose, aside from operational instructions, is to promote safety through the use of accepted operating procedures. Read all instructions thoroughly before operating the slip roll.

Also contained in this manual is the parts list for your slip roll. It is recommended that only TENNSMITH or factory authorized parts be used for replacement parts.

3-YEAR LIMITED WARRANTY

TENNSMITH machinery and component parts are carefully inspected at various stages of production and are tested and inspected prior to shipment. We agree that for a period of twelve (12) months from the date of delivery from our authorized distributor to replace, at our option, any machine (or component part thereof) proving defective within the above period. Additionally, we agree that for a period of thirty-six (36) months from date of delivery to replace component parts proving defective within the stated period. All warranty claims are made F.O.B. our plant, providing such machine (or component part) is returned freight prepaid to our plant, or a designated service center of the undersigned, for our examination. This warranty does not include repair or replacement required because of misuse, abuse, or because of normal wear and tear; or electrical components which are warranty by their manufacturer. Further, we cannot be responsible for the cost of repairs made or attempted outside our factory or designated service center without our authorization. No claims for defects will be honored if the name and data plate has been remove. This warranty is made expressly in place of all other warranties or guarantees express or implied, with respect to fitness, merchantability, quality or operative ness. This warranty becomes effective only when the accompanying warranty card is fully and properly filled out returned to the factory within ten (10) days from date of delivery.

SAFETY PRECAUTIONS

1. Know the safety and operating instructions contained in this brochure. Become familiar with and understand the limitations of this slip roll. Always practice safety.
2. Wear approved eye safety protection such as glasses, goggles, etc. when operating the cleat bender to protect your eyes.
3. Wear protective foot wear or safety shoes. Jewelry such as rings and watches should be removed when operating the machine.
4. Rolls should be securely bolted to a work table or bench. The bench should be bolted to the floor.
5. Always keep hands clear of entry area to rolls while operating.
6. Do not misuse the slip rolls by using them for other than their intended use.
7. Keep the work area clear and clean to avoid tripping or slipping.

THESE INSTRUCTIONS MUST BE FOLLOWED OR SERIOUS INJURY OR PROPERTY DAMAGE COULD OCCUR.



RECEIVING THE MACHINE

Remove the slip roll from its crate and inspect the unit for damage. Any loss or damage should be noted in detail on the delivery receipt and reported to your distributor immediately.

INSTALLING THE MACHINE

Locate the slip roll in a well lighted area on a solid, level floor. The slip roll must be securely bolted to a work bench or TENNSMITH manufactured optional stand. The work bench or stand must be securely mounted to the floor. Use lag screws or bolts with expandable shields or similar holding devices thru the mounting feet located on the bottom of the side panels to mount work bench to floor.

OPERATING THE MACHINE

The full-length capacities of the various models are shown in the chart below. The chart (Figure 1) should be used as an approximate material conversion comparison to show equivalent capacities of material other than mild steel. Do not exceed the capacity of your slip roll as permanent damage to the machine may result.

Figure 1

| MAXIMUM CAPACITIES | SR24 | SR36 | SR42 |
|---------------------------|--------------|--------------|--------------|
| Mild Steel | 20 ga / .036 | 22 ga / .030 | 24 ga / .024 |
| Stainless Steel | 24 ga / .024 | 26 ga / .018 | 28 ga / .015 |
| Cold Roll Steel | 20 ga / .036 | 22 ga / .030 | 24 ga / .024 |
| Aluminum, Soft | .060 | .048 | .036 |
| Aluminum, Hard | .036 | .030 | .024 |
| Brass, Soft Yellow | .048 | .036 | .030 |
| Bronze, Phosphor Annealed | .036 | .030 | .024 |
| Copper, Soft | .048 | .036 | .030 |
| Copper, Hard | .036 | .030 | .024 |

MAINTENANCE

The machine must be lubricated every day of service. The bottom and rear rolls are contained at each end by the adjusting blocks (14). An oil pin hole is located on the top of each of these blocks. Lubricate these blocks daily with two to three drops of oil. The upper roll is lubricated on the left hand side at the pin hole on the top of the gear cover (126) and on the right hand side by the latch assembly and oiling lightly the end of the roll shaft. We recommend a good grade of light machine oil with a viscosity of 300 SSU.

After every thirty days of operation, apply grease to the gears (20) by removing the gear cover (126).

We recommend that the rolls be lightly oiled when not in use to prevent rusting.

ORDERING PARTS

When ordering parts please furnish the model number and the serial number of you machine.



Slip Roll Specification

| Model | SR24 | SR36 | SR42 |
|------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|
| Maximum capacity, mild steel | 20 ga / 1,0 mm | 22 ga / 0,75 mm | 24 ga / 0,60 mm |
| Maximum Forming Length | 24 in / 610 mm | 36 in / 914 mm | 42 in / 1067 mm |
| Diameter of Rolls | 2 in / 51 mm | 2 in / 51 mm | 2 in / 51 mm |
| Minimum Forming Radius | 1 in / .25 mm | 1 in / .25 mm | 1 in / .25 mm |
| Wire Grooves | 3/16, 1/4, 5/16 in 5, 6.5 , 8 mm | 3/16, 1/4, 5/16 in 5, 6.5 , 8 mm | 3/16, 1/4, 5/16 in 5, 6.5 , 8 mm |
| Shipping Weight | 190 lbs / 86 kg | 250 lbs / 113 kg | 270 lbs / 122 kg |