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General Operating Instructions For Flagler 18 Ga. Duct Bender



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Installation Instructions:

Make sure that all foreign matter has been removed from the machine which may have accumulated during transit.

Thoroughly inspect the machine for any physical damage.

Electrical Connection:

This machine is designed to run off of either 120 Volt, 1 Phase, and 60 Hertz Power. The machine is equipped with a $\frac{3}{4}$ HP motor.

It is recommended that the machine be plugged into a 20 amp plug.

Rotation of the machine has been set by the factory and should not have to be altered.

Once the electrical connection has been made, check to make sure that all of the electrical functions of the machine are in working order.

Lubrication and Maintenance:

Bearings: All bearing points on this machine have a grease fitting. It is recommended to use a #2 Lithium grease or equivalent. The bearing locations should be greased every 40 hours of operation.

NOTE: Some hard guarding may have to be removed to access all of the grease fittings.

Gears: A coating of open gear grease should be kept on the gears at all times. This can be monitored when removing the guarding to grease the bearings and apply when necessary.

Chain: Apply oil to chain once a month depending on usage. Using an oil can apply oil directly to chain while running.

Gear Motor: See the gear motor data from SEW in regards to gear motor maintenance. Normally it is recommended to change the oil in the gear motor once a year.

All material run through this machine should be free of all foreign matter, such as dirt and grime. This is important as it will minimize any unnecessary wear on the roller dies. A preventative maintenance schedule should be set immediately. This schedule should include the periodic lubrication of the machine and the periodic cleaning of the entire roller die set to remove any foreign matter. In general, a scheduled wiping off or cleaning of the entire machine.

Capacities:

The capacities of the standard Gang Bearer is 18-26 Ga. The machine is equipped with fixed location beads on 12" centers and 6" from either side.

The machine is equipped with a fixed gauge on the left side of the machine, set at 6" from first bead, and an adjustable gauge mounted on the right side of the machine.

To adjust the movable gauge, simply loosen the red handle toggle clamp, slide the gauge to the desired location and retighten.

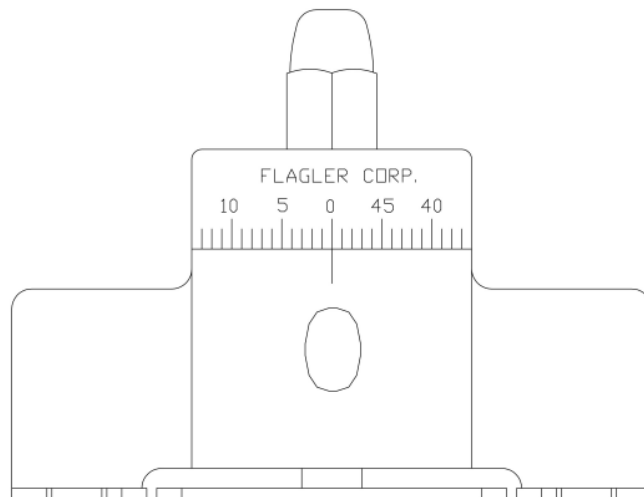


Fixed Gauge

Movable Gauge

Capacities and Adjustments:

This machine has been designed and tested for forming 26 Ga. galvanized. If heavier material is run through the machine it can cause damage to a number of parts in the machine.



The rollformer is equipped with micrometer adjustments on all of the top spindles. Each dial has been set to zero as the factory setting.

PLEASE NOTE: The hold down studs which connect the dial to the top bearing blocks have LEFT HAND threads.

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18 Beader #26-900

Part Number	Description	Size	Qty
24-001	Main Plate	1.250 x 6.000 x 10.000	1
24-002	Outboard Support	1.250 x 6.000 x 10.000	1
26-901	Top Shaft	4.250 rd. x 65.750	1
29-902	Bottom Shaft	4.000 rd. x 67.000	1
26-903	Alignment Plate	0.750 x 8.000 x 65.000	1
26-904	Alignment Key	0.50 x 0.750 x 1.500	2
24-007	Gear	4.200 rd. x 0.938	2
24-023	Bearing Race	2.485 rd. x 1.563	2
17-048	Fixed Side Feed Gauge	0.625 x 1.000 x 17.500	1
26-905	Movable Side Feed Gauge Assembly	0.625 x 1.000 x 17.500	1
		0.625 x 1.000 x 1.000	1
		0.125 x 3.000 x 17.500	1
		2.000 x 3.000 x 0.50 x 1.000 AI	1
	Toggle Clamp	5093A56	
	Tip	5147A59	1
24-017	Roll Bridge Assemblies		2
24-018	Casting	#RB-65	2
24-021	Stud	1/2-20 LH x 4.250	2
24-019	Adjustment Collar	1.375 rd. x 2.750	2
24-020	Collar Nut	1.500 rd. x 0.625	2
24-022	Dial	2.250 rd. x 0.625	2
24-025	Acorn Nut	3/4" Hex x 1.000	2
	--CABINET ASSEMBLY--		1
26-906	Top Front Plate	0.250 x 18.000 x 64.562	1
26-907	Top Take-Off Plate	0.250 x 4.000 x 64.562	1
26-908	Right Side Skirt	0.125 x 30.50 x 36.00	1
26-909	Left Side Skirt	0.125 x 30.50 x 36.00	1
26-910	Support Angle	4.00 x 4.00 x 0.250 x 60.562	1
26-911A	Table Support Angle	1.25 x 1.25 x .25 x 60.562	1
26-911	Bottom Angle	2.00 x 2.00 x .188 x 56.562	2
26-916	Lower Panel	20 Ga. x 14.50 x 50.438	2
26-912	Upper Side Front Panel	0.125 x 14.438 x 50.562	1
26-913	Upper Side Rear Panel	0.125 x 8.750 x 50.562	1
23-020	Feet	0.250 x 5.00 x 23.00	4
26-914	Motor Mount	0.50 x 12.00 x 22.00	1

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Part Number	Description	Size	Qty
26-915	Top Cover		1
59-917	Chanin Cover		1
	Motor (main)	3/4 HP CEL11307	1
	Gear Box	SEW R27 AM56	1
	Sprockets	50B19 x 1"	2
	--BEARINGS AND OILITES--		
24-024	Bearing	B-248	4
24-026	Bearing Cup	#19268-B	4
24-027	Bearing Cone	#19150	4