

Slip Roll (Jet 50 inch Electrical Slip Roll Machine)

METHOD OF OPERATION

*Material is placed in between steel rollers. After adjusting rollers, a foot pedal is pressed to rotate them and manipulate the material into a curved profile.

MACHINE HAZARDS

*Pinch and Crush hazard

-Controls: Proper hand placement—Never place hands in close proximity while the rolls are operating.

-Controls- NO loose fitting clothing. The user should remove any ties, jewelry, watches, and secure any long hair before operating this machine.

PPE/Safety Measures

*Closed Toed Shoes	*Safety Glasses
*Ear protection	*Form fitting clothing

Guards and Devices

*Safety Brake

-This machine is equipped with a Safety Brake, in the form of a long red bar, located directly underneath the pinch roll. Should entanglement occur, actuating the safety brake will stop the machine.

*Mobile foot pedal unit, with Emergency Stop button.

-The rollers can be controlled with the use of the mobile foot pedal unit. This unit has an Emergency stop switch at the top. Should entanglement occur, pressing the Emergency stop switch will stop the machine.

*Emergency stop button on Slip roll Panel

-The panel on the machine can also be used to control the rollers. There is an Emergency stop button on this panel. Should entanglement occur, pressing the Emergency stop button will stop the machine.

Operational Notes

Flat rolling

Should only be performed with softer metals (copper, aluminum, brass, etc)

Bending rod

Should you need to bend pencil rod, use the smallest groove into which the rod will comfortably fit. The machine is equipped with a 5/16" groove, a 3/8" groove, and a 1/2 " groove.

Capacity

Do not try to process materials thicker than 16 gauge. (1.5mm, or about 1/16 of an inch thick.

Sequence of Operation

Forming a radius

1. To form a radius, adjust the pinch roll evenly to the width of your piece. Insert your workpiece from the front, ensure the stationary roll is rotating counter clockwise.
2. When the material reaches the point where the radius is to begin, stop the machine and raise the idler roll an equal amount on each end to achieve the desired bend.
3. Restart the rolls and continue until the bend is completed.

Forming a tube.

4. Adjust the pinch roller as needed to accommodate workpiece thickness.
5. Feed the workpiece into the machine. As it nears the end, stop the machine and reverse direction.
6. To remove the tube from the stationary roll, pull the sleeve outward until it clears the bracket. You may then pivot the roll outward. Once you have removed your workpiece, reposition the stationary roll and push back the sleeve completely.

Flat roll

7. To flat roll a workpiece, scroll down the fly wheels for the idler roll, as far as they will go.
8. Feed your workpiece in from the front. After you send it through, try flipping it over and feeding it in from the front again. The idler roll will not descend entirely out of the way, so there still may be a slight bend in your workpiece.

Never

- *Use faulty equipment. Immediately report suspect equipment.
- *Use the machine while wearing rings or other jewelry
- *Try to process materials thicker than 16 gauge

Maintenance Notes/Service by Operator

- *Contact Shop Supervisor/qualified person:
- *If you require any additional support.