Engel Rollformer
800 Series

Features
~ Optional electricals available including single phase for job site applications.
~ No opening rolls required on any set of tooling.
~ All units have eight (8) forming stations with tooling mounted on turned, ground and polished 1” spindles.
~ Extra large bearings with inner races.
~ Standard with 5HP motor producing approximately 90 FPM pitchline speed.
~ Hardened steel in-feed guides to handle rough plasma cut edges.

Tooling Profiles
~ Flat “S”
~ Drive Cleat
~ Male Button Lock
~ Female Button Lock
~ Drop Edge
~ Pittsburgh Lock
~ Double Seam (Acme)
~ Duplex
~ Triplex
~ 180° Hem
~ 45° Drip Edge with Hem

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Roll Machine Instructions
Series 800 Roll Formers
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NOTICE
Some materials in this manual may not pertain to your specific machine.

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IMPORTANT CAUTION FOR RUNNING “S” SLIPS

Roll-formers with “S” slip capabilities (ex. 800-S, 825), can be easily damaged or jammed by feeding one part after another too quickly. The “S” slip slows down as it progresses through the roller dies. If a part is in the machine such that the tail end is not clear of station #6, the next part in can catch up and even overlap the previous part before it exits the machine. This will result in a potentially serious jammed condition. See instruction manual.

Jamming of this nature can cause the warranty to be voided.
ENGEL INDUSTRIES, INC.

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 lifting the machine by the bottom frame members (NOTE: Lifting the machine by the in-feed or out-feed table would result in extensive damage to the machine.) If the machine is unloaded onto a loading dock, then rollers can be put under the skids, or the machine can be slid or dragged 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 or leg of the machine.
Electrical Connections

Supply electrical service to the starter box (located under the in-feed table) in accordance with local electrical supply 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.)

Lubrication

After approximately every 80-100 hours of use, or every two (2) weeks, lubricate the machine in the following manner:

1. As a safety precaution, disconnect electrical supply
2. Remove top roll cover (guard)
3. 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 as required. (Applying oil to both sides of a strip of metal and passing it through all the rolls is an excellent way to lube the rolls when heavy use occurs.)

5. Connect power, turn machine on and with a pressure type grease gun, apply grease to lube fittings. (NOTE: Remove right apron for access to fittings on side plate for idle gears.) Grease fittings are located on the gear reduce under the machine also.

6. For units with oil bath reducers, change oil at least once a year.

   Recommended: Lubriplate #8 (made by Fiske Bros. Refining Co., in Toledo and Newark) or equivalent

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

Models
Roll Capacities and Material Requirements

<table>
<thead>
<tr>
<th>Shape</th>
<th>Material Required</th>
<th>Capacity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pittsburgh Lock</td>
<td>15/16&quot;</td>
<td>20-28 Gauge</td>
</tr>
<tr>
<td>Female Button Lock (20 Ga.)</td>
<td>1 3/8&quot;</td>
<td>20-24 Gauge</td>
</tr>
<tr>
<td>Female Button Lock (24 Ga)</td>
<td>1 1/8&quot;</td>
<td>24-26 Gauge</td>
</tr>
</tbody>
</table>
# Model 800-825

## Roll Capacities and Material Requirements

<table>
<thead>
<tr>
<th>Shape</th>
<th>Material Required</th>
<th>Capacity</th>
</tr>
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<tbody>
<tr>
<td>Pittsburgh Lock</td>
<td>15/16&quot;</td>
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</tr>
<tr>
<td>Female Button Lock (20 Ga )</td>
<td>1 3/8&quot;</td>
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</tr>
<tr>
<td>Female Button Lock (24 Ga )</td>
<td>1 1/8&quot;</td>
<td>24-26 Gauge</td>
</tr>
<tr>
<td>Male Button Lock (20 Ga )</td>
<td>7/16&quot;</td>
<td>20-26 Gauge</td>
</tr>
<tr>
<td>Male Button Lock (24 Ga )</td>
<td>7/16&quot;</td>
<td>24-26 Gauge</td>
</tr>
<tr>
<td>Acme (Double Seam)</td>
<td>7/16&quot;</td>
<td>20-28 Gauge</td>
</tr>
<tr>
<td>Drive Cleat</td>
<td>2 1/8&quot;</td>
<td>20-28 Gauge</td>
</tr>
<tr>
<td>Reinforced Flat “S”</td>
<td>3 3/4&quot;</td>
<td>22-28 Gauge</td>
</tr>
<tr>
<td>Tap-In-Lock</td>
<td>1 3/4&quot;</td>
<td>22-28 Gauge</td>
</tr>
<tr>
<td>Standing Seam</td>
<td>1 1/8&quot;</td>
<td>22-28 Gauge</td>
</tr>
<tr>
<td>Right Angle Flange</td>
<td>9/16&quot;</td>
<td>20-28 Gauge</td>
</tr>
</tbody>
</table>

# Models 835, 1000, S-5-10, 1240, 1535 and 1640

## Outboard Roll Sets

<table>
<thead>
<tr>
<th>Shape</th>
<th>Materials Required</th>
<th>Capacity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pittsburgh (18 Ga ) 1/2&quot; Pocket</td>
<td>1 1/4&quot;—notch 1 1/8&quot;</td>
<td>18-24 Gauge</td>
</tr>
<tr>
<td>Pittsburgh (16 Ga ) 3/4&quot; Pocket</td>
<td>1 1/2&quot;—notch 1 3/8&quot;</td>
<td>16-20 Gauge</td>
</tr>
<tr>
<td>Female Button Lock (20 Ga )</td>
<td>1 3/8&quot;</td>
<td>20-24 Gauge</td>
</tr>
<tr>
<td>Male Button Lock (20 Ga )</td>
<td>7/16&quot;</td>
<td>20-24 Gauge</td>
</tr>
<tr>
<td>Standing Seam—Duplex</td>
<td>2 1/8&quot;</td>
<td>16-20 Gauge</td>
</tr>
<tr>
<td>Right Angle Flange (16 Ga )</td>
<td>1&quot;</td>
<td>16-20 Gauge</td>
</tr>
<tr>
<td>Tap-In-Lock</td>
<td>3 1/2&quot;</td>
<td>18-24 Gauge</td>
</tr>
<tr>
<td>Standing Seam—Triplex</td>
<td>2 1/8&quot;</td>
<td>18-24 Gauge</td>
</tr>
<tr>
<td>Right Angle Flange (18 Ga )</td>
<td>1&quot;</td>
<td>18-24 Gauge</td>
</tr>
<tr>
<td>Duplex</td>
<td>1 5/8&quot;</td>
<td>16-20 Gauge</td>
</tr>
<tr>
<td>Right Angle</td>
<td>1 1/2&quot;</td>
<td>16-20 Gauge</td>
</tr>
</tbody>
</table>
Adjustments

This machine is factory adjusted, however, after much usage adjustments may be necessary.

Roll Clearance
Models 825, 835, 1030, 1240 and 1535

The gaps or clearances between the top and bottom outboard roller dies should be approximately .010 on all roll sets, with the exception of the 16 Gauge Duplex and Pittsburgh roll sets which are set at .036. Also, 18 Gauge Triplex roll sets, which are set at .025 and 18 Gauge Pittsburgh roll sets which are set at .015. The adjusting nuts must be locked. Then check to see that the clearances are as stated above.

Roll Clearance Standard Tooling
(right or left outboard installation)

| Pittsburgh | 16 Gauge .035 |
| 18 Gauge .015 |
| 20 Gauge .010 |
| Male-Button | 18 Gauge .025 |
| Lock | 20 Gauge .010 |

| Triplex | 18 Gauge .025 |
| 22 Gauge .015 |

| Right- | 16 Gauge .035 |
| Angle | 18 Gauge .015 |
| 20 Gauge .010 |

| Acme- | 18 Gauge .010 |
| Lock | 20 Gauge .010 |

| Female- | 18 Gauge .025 |
| Button | 20 Gauge .010 |
| Lock | 24 Gauge .010 |

| Drive- | 18 Gauge .015 |
| Slip | 20 Gauge .010 |

Drive Cleat-20 Gauge
Outboard #1 .010
#4 .015
#5 .015
#8 .035

“U” Model Machines
Female Snap-Lock #8 Top

20 Gauge Capacity:
1. Use deep groove for 20 and 22 Gauge
2. Use shallow groove for 24 and lighter

24 Gauge Capacity:
1. Use deep groove for 24 Gauge
2. Use shallow groove for 26 and lighter

Female Pittsburgh #7 Top

16 Gauge Capacity:
1. Free Standing unit 16 to 20 Gauge Capacity only
2. 16 Gauge rolls on transfer system (18 Gauge Capacity)
3. Use deep groove for 18, 20 and 22 Gauge
4. Use shallow groove for 24 and lighter

18 Gauge Capacity:
1. Use deep groove for 18 and 20 Gauge.
2. Use shallow groove for 22 and lighter.

NOTE: This means the desired roll groove would be next to the end cap and bolt
Female Snap-Lock
20 and 24 Gauge
#8 Top

End Cap
Bolt
Spacer 24 Gauge Only

Pittsburgh
16 and 18 Gauge
#7 Top

End Cap
Bolt

¼" Spacer
18 Ga. Rolls Only

Sideplate

Sideplate
Female Button Lock

Used for 20 & 22 Ga

Used for 24 Ga and Lighter

End Cap Washer

Bolt

Inboard Side

Outboard Side
Instructions for changing Button Punches on Engel Snap-Lock Machine

1. Remove four (4) socket head screws holding head assembly to frame, and slide head back three (3) inches or so. On free standing unit, remove tie plate only.

2. Remove No. 2 bottom roll by removing hex head bolt and end cap washer. Slide Roll off of spindle.

3. On the backside of the roll there will be four (4) large socket head bolts, and four (4) small socket head set screws.
   A. Remove four (4) large bolts, and separate the two (2) parts of the roll.
   B. Loosen four (4) small socket set screws.
   C. Remove the four (4) punches, and replace with new ones.
   D. It may be necessary to lightly sand the sides of the new punches before they will fit in the slots.
   E. Be sure buttons are all the way to the back side of slot. If necessary, after putting roll back together, tap on the punches lightly with a brass hammer to seat to the proper depth.
   F. Tighten four (4) large bolts as tight as possible.
   G. Now tighten four (4) small socket set screws and replace roll on spindle, replace end cap and bolt.
   H. Slide head back into position and replace the four (4) bolts holding it into the frame. This applies to transfer system only.

4. Upper Slitting Wheel simply by removing end cap and bolt and removing the slitting half or upper roll.

WARNING: DO NOT LOOSEN BOLTS ON THE HEAD OF ANY FREE STANDING UNIT.

CAUTION: IF PRECISION (THIN) SHIMS ARE PRESENT BEHIND THE TOP OR BOTTOM ROLLS, BE SURE TO MAINTAIN THEIR POSITION WHEN RE-ASSEMBLING TAKES PLACE.

IF ALIGNMENT IS NOT MAINTAINED, THE KNIVES AND KNIFE ROLL CAN BE DESTROYED.

IT IS RECOMMENDED TO TURN THE MOTOR BELT BY HAND TO OBSERVE ANY POSSIBLE INTERFERENCE BETWEEN THE KNIVES AND KNIFE ROLL. NOTE: POWER MUST BE DISCONNECTED AND LOCKED OUT FOR SAFETY!!!
Model 800P Adjustments

To Set Roll Gap:

Loosen jam nut and set to clearance specified by turning adjusting screws until feeler gauge setting is obtained. Tighten the jam nut adjusting.

Spring tension is factory set. Should further changes be needed, more tension can be obtained by removing nut of tension screw and internal shims. It is recommended that you contact the factory for advice before doing so.

Additional Adjustments
Model 800B-18

The procedure to adjust the helper on the 2.5 station area is as follows. This applies to going from heavy to light gauge material.

By using the square head set screw protruding through the safety hood, turn adjustment out (to the right) for heavy material and in (to the left for light material).
In-feed Guide Settings

Pittsburgh

20 Gauge 2 1/8” with offset
18 Gauge 2 5/16” with offset
16 Gauge 2 3/8” with offset

Measurements shown are good starting positions, other settings maybe necessary by adding more or less material moving guide (in-feed) (+ or -)

Triplex

Set in-feed guide to 1 1/2”. If it will be necessary to lengthen material, take up by moving guide as needed

Male Button Lock

20 Gauge 1 1/32” (+ or -)
18 Gauge 1 1/32” (+ or -)

Drive cleat is center part in tooling

Female Button Lock

24 Gauge 2 5/16” (+ or -)
20 Gauge 2 5/16” (+ or -)
18 Gauge 2 3/8” (+ or -)

Drive Slip – Outboard

20 Gauge 1 1/8” (+ or -)
16 Gauge 1 1/2” (+ or -)

Acme Lock

20 Gauge 1” (+ or -)
18 Gauge 1 5/8” (+ or -)
16 Gauge 1 3/8” (+ or -)

Right Angle

20 Gauge 1 5/16” (+ or -)
18 Gauge 1” (+ or -)
T.I.L.

22 Gauge:  6<sup>T</sup> 015  7<sup>T</sup> 030  8<sup>T</sup> 045
           6<sup>B</sup> 015  7<sup>B</sup> 030  8<sup>B</sup> 045

It may be necessary to add additional 0.020 to 6<sup>B</sup> in order to get 90° on right angle.

**Male Button Lock**

20-24-18 Gauge Capacity

8<sup>T</sup> 030  8<sup>B</sup> 030

Sometimes it will be necessary to shim #2<sup>B</sup> as needed to get button punches at proper depth.

T.I.L.

18 and 16 Gauge (S-5-10/W)

8<sup>T</sup> 015  9<sup>T</sup> 030  10<sup>T</sup> 045
8<sup>B</sup> 015  8<sup>B</sup> 030  10<sup>B</sup> 045
+ 0.020 #9<sup>B</sup> to get 90° on right angle.

**Duplex**

16 and 18 Gauge (164CU)

10<sup>T</sup> 015  11<sup>T</sup> 030  12<sup>T</sup> 045
10<sup>B</sup> 015  11<sup>B</sup> 030  12<sup>B</sup> 045

**Female Button Lock**

20, 24 and 18 Gauge

(2<sup>T</sup>) It may be necessary to shim 2<sup>T</sup> to better 90° bend on the hem position. See drawing T5036

If lighter Gauges buckle in the length of the part or last turn over hem runs out, shim #4<sup>T</sup> out to meet #4<sup>B</sup>

See drawing T5039

M-800 with MR-CEF-800 (Drive Edge Only)

**Roll Setting and Head Adjustment (Tension)**

1. Set roll clearance 0.010 at station #1
2. Adjust head tension – 4 flats at #1
3. 3 flats at stations #4, #5 and #8 - 0.015 roll clearance at these stations
4. Recheck roll clearance
5. Set in-feed guide 13/16" off outside
6. Flat of tooling
   **NOTE:** It may be necessary to set in-feed guide 1/32" offset at front of machine to keep material from leaving in-feed guide
7. Side roll setting - #2, #3, #4 and #5
   0.025 on bottom
   0.010 on side
8. Station #6 and #7
   0.010 on bottom
   0.045 on side
To Adjust Head Tension

1. Loosen Top jam nut (located on socket head bolt)
2. Tighten bottom jam nut down flat
3. Loosen (back off) flats indicated in instructions at station locations
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 change, etc., always do a lock-out/tag-out procedure which means the power must be off and locked-out and any rams or beams will be blocked to ensure safety. This is a federal OSHA requirement and must be a written and training type of program.
3 Phase Pre-wired Starter
Dwg. EL-760-A

PENDANT CORD IS 16/4
1. HEAT TREAT-CARBON NITRIDE 0.020 - 0.025 DEEP
2. BORE 1.000 - 1.001 KEY: +0.003 / 0.001
3. BREAK ALL SHARP EDGES 0.03 R MAX
4. VERTICAL CENTERS ON SPRING LOADED MACHINES ARE 24"
Typical In-feed Guide
Setting Instructions

LEFT SIDE
FEMALE BUTTON LOCK
ROLLER DIE
HEAD RAIL
TO DRIVE MACHINe
DIRECTION OF MATERIAL FLOW

RIGHT SIDE
MALE BUTTON LOCK
ROLLER DIE
HEAD RAIL
ROLLER DIE

SHOULD NOT BE LONGER THAN 1/16"
MR-CEF800
Station #2, #3, #4, #5
Side Roll Setting

[Diagram with dimensions and markings]