

flagler

Designers and Manufacturers of Sheet Metal Roll Forming Machinery

24 Junior Pittsburgh Machine

Operating Instructions and Parts List



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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 gauge, 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 gauge, 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.

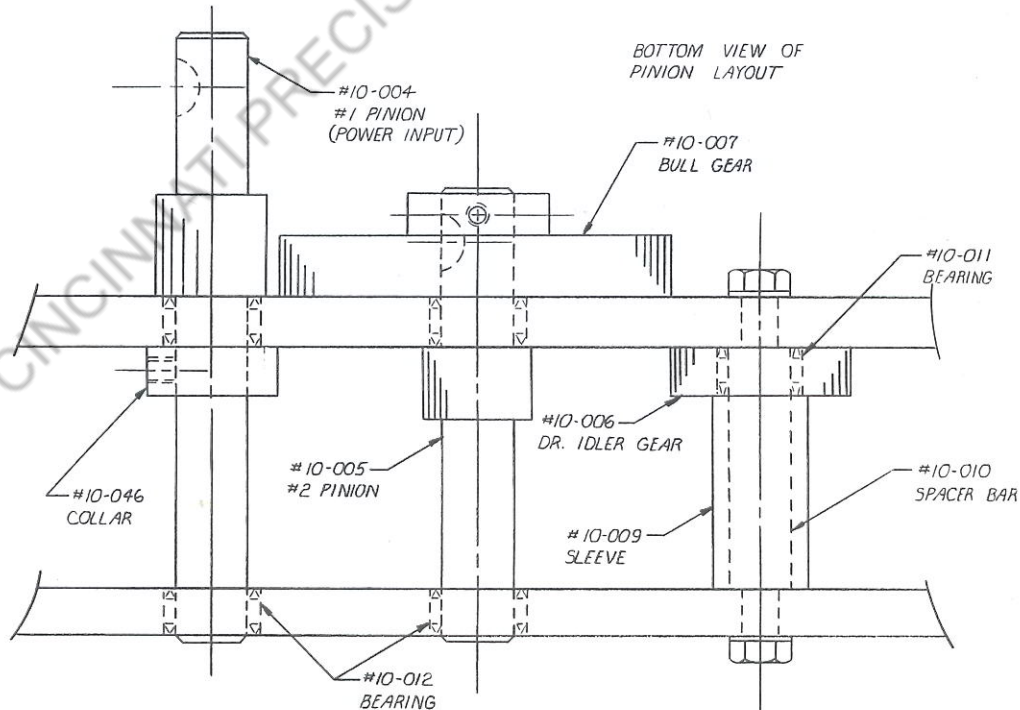
LUBRICATION

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.

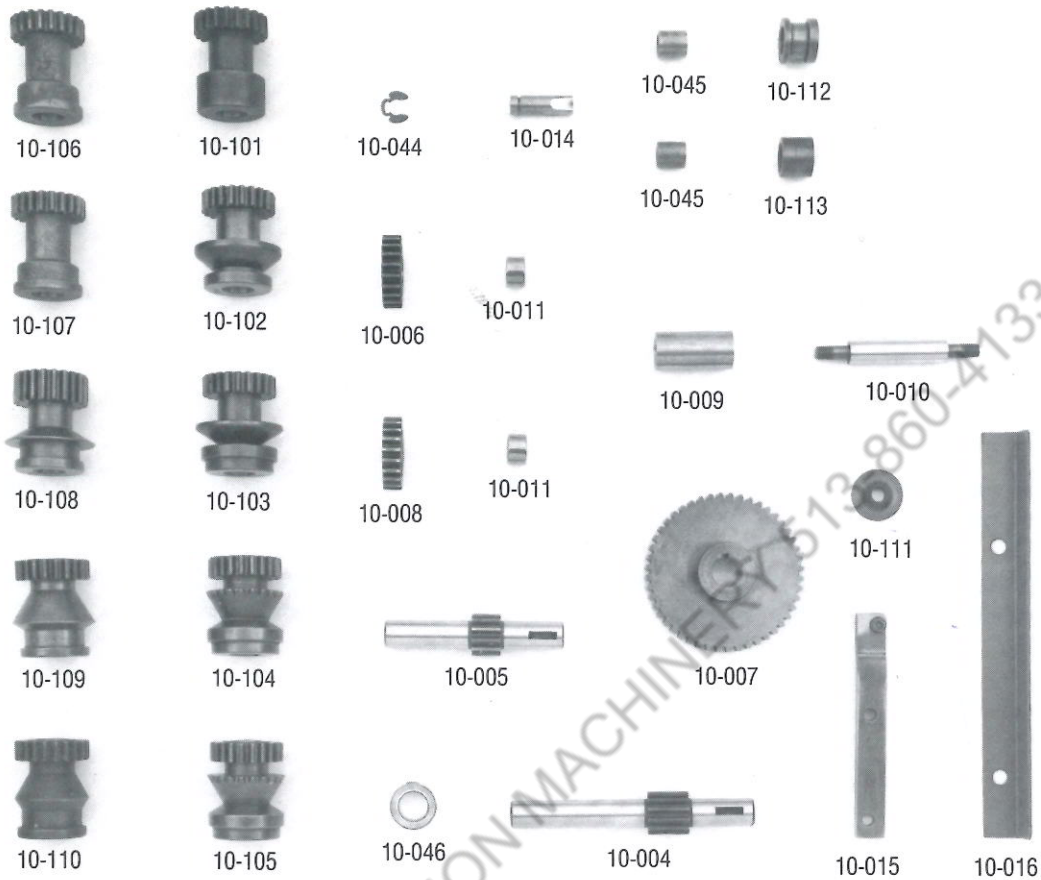
Capacity, 24 to 30 gauge mild or galvanized sheet metal. The Pittsburgh lock takes 7/8" to 1" material. Depth of pocket is 5/16". Flanging Attachment produces 1/4" right angle flange on straight pieces or on curved pieces to a radius as small as 1-3/4".



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.

Important: Disconnect Power Before Removing Covers for Any Reason

Operating Instructions for Power Flanging Attachment

1. Tighten the gauge adjustment screw and loosen it a quarter turn (this setting is correct for 26 gauge material). If the flange is wrinkled, the adjustment is too tight; if there is slippage, then it is too loose.
2. Turn up a "starting flange" by using the slot cut in the tabletop. Once the operator is accustomed to the flanger, this will not be necessary. As the metal passes through the forming rolls, exert a small force on the piece in the direction indicated by the arrows in the figure below. This holds the metal to the height gauge and results in an even, uniform flange. Too much force will jam the machine.
3. On exceptionally small outer radii the piece may need to be run through the flanger a second time to remove wrinkles and to straighten the flange.
4. When flanging straight pieces or pieces having a constant radius, the operator may set the adjustable guide. To use the guide simply run a piece partly through the rolls and then slid the guide against the flange and tighten down the T-handle. As a result, the following pieces can be released after started.
5. To flange small inner radii, no guide is needed. Start the piece and LET GO.
6. If you fail to turn the flange to the full height, or the flange runs off the edge of the piece, the piece is not spoiled; simply run it through the flanger again.
7. After flanging a few pieces, the operator will get the "feel" of the machine and find out how easily that the metal is guided up to a perfect flange. For ease in handling of material, stand at the front of the machine.

