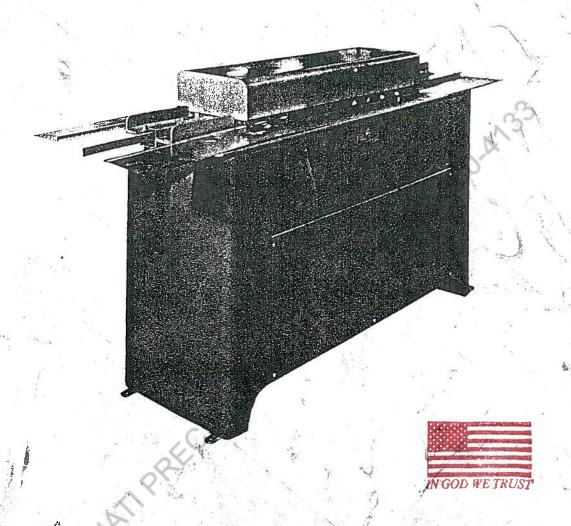
GENERAL OPERATING INSTRUCTIONS AND PARTS LIST



FEAGLER HIGH SPEED COMBINATION "L" BAR MACHINE

flagler

56513 PRECISION DRIVE, CHESTERFIELD, MICHIGAN 48051 TELEPHONE: (586) 749-6300 FAX: (586) 749-6363

ELECTRICALS:

5 H.P. 230/460/4/60 motor and controls. Standard machine wired for 230 volts unless otherwise specified.

OPERATION:

When machine has been wired to correct power source, check rotation. When rotation has been determined, place properly sheared blank between gage bars and feed material into the rolls. Check the end result and make changes accordingly.

ADJUSTMENTS:

Should the machine labor under load, the hold down studs are set too tight. To re-adjust, tighten the eight studs that pass through the machine plates and then loosen approximately one quarter of a turn (90°). Should the machine continue to labor, loosen the four studs on the lead end of the machine to three-eights (135°) or one half turn (180°). Downward bow can be compensated for by adjusting the hold down studs located at the exit end of the machine. Side bow is caused by an unbalance in the stud adjustment.

LUBRICATION:

Lubrication fitting for the high speed shafts are located on the side panel through a central lubrication system. The high speed bearings should be lubricated every eight hours of operation. A coating of good open gear grease should be kept on the gears at all times.

NOTE: If the machine is to be used or stored out of doors, an oil or grease film will prevent rusting of all surfaces.

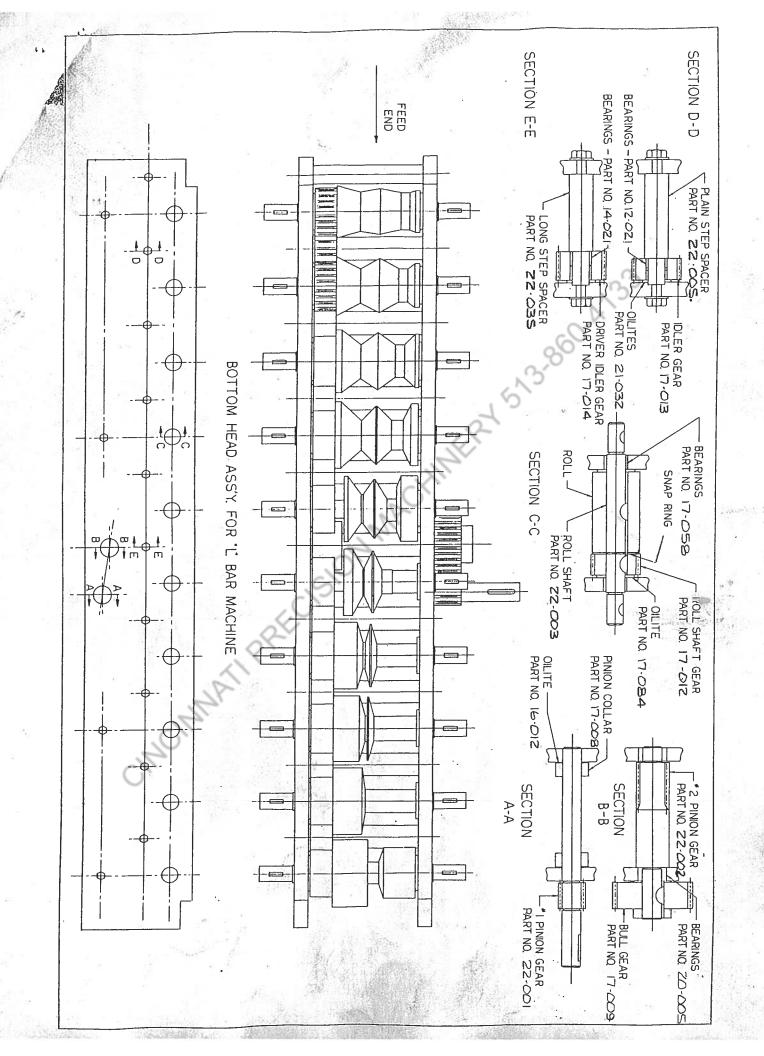
INSTRUCTIONS FOR MOUNTING AUXILIARY ROLLS:

Machine auxiliary shafts are designed to accommodate various auxiliary rolls listed below. To install these rolls, proceed as follows:

- 1. Remove the section for the table top side plate on the side of the machine which the rolls are to be mounted.
- 2. If auxiliary rolls are now on the machine, remove the retaining bolts and washers. Remove all parts not pertaining to the set to be used.
- 3. Place all woodruff keys in proper location.
- 4. Select the first pair of rolls which are marked "T-1" and "B-1" and place them on the shaft at the enterance end of the machine. Place the "T-1" roll on the upper shaft and the "B-1" roll on the lower. Repeat procedure through all roll stations.
- 5. After the rolls are installed, fasten the rolls with retaining screws and washers.
- 6. Mount entrance and exit gages to the stand, using the slotted holes provided in the table top. Set entrance gages by placing a straight edge along the outer edge of the auxiliary rolls, measure to the required amount in from the straight edge to the extreme ends of the entrance gage.

SUGGESTED PROCEDURE FOR REMOVING FORMING HEAD FROM CABINET

- 1. Remove the cover, top side plate and grease lines from the machine.
- 2. Remove the top head by removing the lock nuts and washers on the 3/8" hold down studs.
- 3. Move the feed gages as to allow access to the 1/2" flat head screws, which hold the bottom head in the cabinet.
- 4. Support the weight of the bottom head before removing the 1/2" flat head screws.
- 5. Remove the 1/2" flat head screws, lower the bottom head, remove the belts from the pully, tilt the head as to allow it to be raised up and out of the cabinet.
- 6. Lay the head on its side with the pulley side up. Remove the pulley, bull gear and the auxiliary rolls (if any) and all the 1/2" screws which will allow the removal of the top plate.
- 7. You will now be able to inspect for broken parts. See parts list and assembly print for ordering information. Please include serial number of machine when ordering parts.
- 8. For reassembly, reverse the above procedure, making sure all of the keys are up and in line.



FLAGLER HI-SPEED COMBINATION - "L" BAR

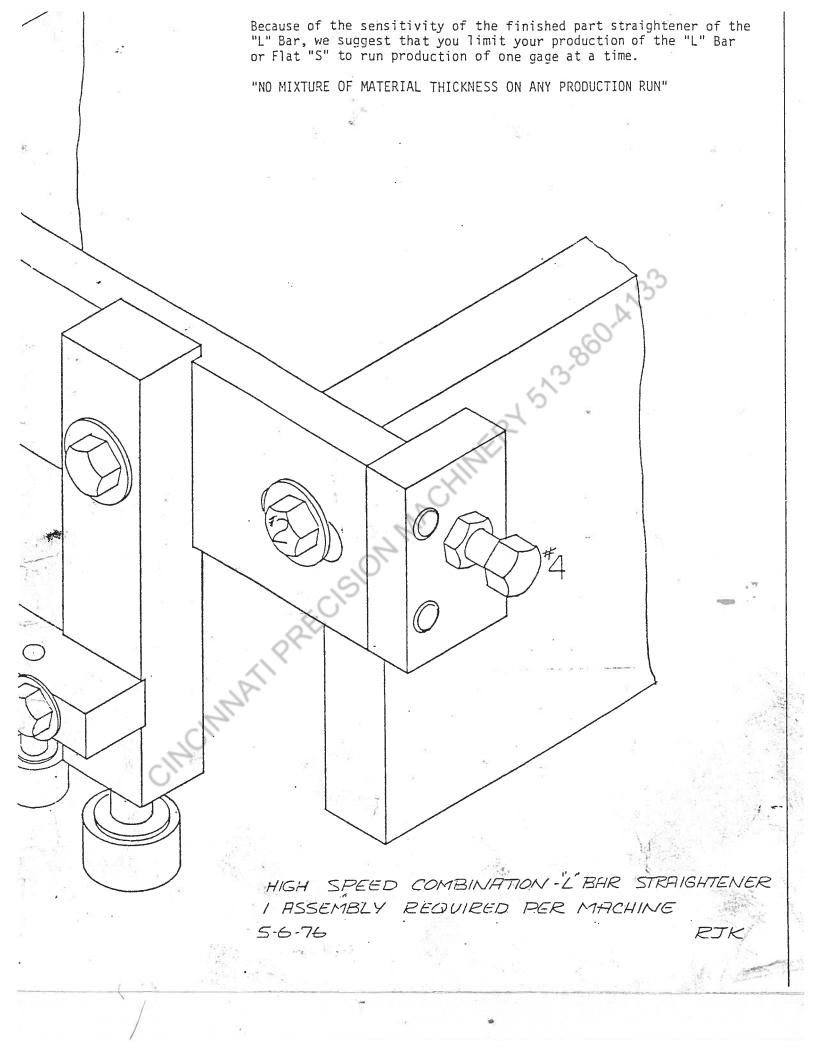
Part no.	Description	Quantity
21-001	Bottom Front Plate	1
21-002	Bottom Back Plate	1
21-003	Top Front Plate	1
21-004	Top Back Plate	1
22-001	#1 Pinion Gear	1
22-002	#2 Pinion Gear	1
17-062	Pinion Collar w/Keyway	1
20-040	Collar	2
17-009	Bull Gear	1.0
22-003	Roll Shaft	20
17-012	Roll Shaft Gear	20
17-013	Idler Gear	8
17-014	Driver Idler Gear	
22-004	Plain Spacer	14
22-005	Plain Step Spacer	4
22-005	Plain Step Spacer	4
22-035		1
14-054	Long Step Spacer	
17-058	Spring Washer # B-0750-040 Bearing 1612	96 40
12-021	-	
14-021	Bearing 148	16
16-012	Bearing 1412	2
	Oilite TT-1709-01	2
17-084	Oilite TT-1502	40
20-005	Bearing 162412	4
21-032	Oilite TT-1503	9
17-059	Hold Down Stud	8
17-025	Spacer Washers	8
17-031	Grease Bolt	1
22-007	Guide Block	1
22-008	Vert. Straightener Assy	1
22-009	Mounting Block	1
22-010	Adjustable Block	1
22-011	-Horiz. Straightener Assy	1
22-012	Mounting Bracket Bar	* 1
22-013	End	2
22-014	Large Cam Block	1
22-015	Cam Follower-CF-7/8-B	1
22-016	Small Cam Block	1
22-017	Cam Follower CF-5/8-B	2
22-026	Feed Gage Assy	1
22-027	Base	1
22-028	Side	1
12-215	Guide Rail	1
22-033	Strap	1
22-037	Feed Gage Insert Assy	1
22-030	Base	1

FLAGLER HI-SPEED COMBINATION - "L" BAR

22-031 Side 1 22-032 Stop 1 21-019 Riser 2 21-029 Riser 2 22-037 Stock Guide 1 22-025 Helper Block-Sta. #6 1 22-034Cover Assy 1 22-018 Top & Sides 1 22-019 End 2 21-013Cabinet Assy 1 17-037 Skirt 2 20-021 Upper Side Panel 2 20-022 Louver Panel 2 21-014 Left Take-Off Plate 1 21-015 Right Take-Off Plate 1 21-015 Right Take-Off Plate 1 21-016 Center Channel 1 21-017 Side Plate 2 21-018 Bottom Side Angle 2 21-048 House Screw Plate 4 21-050 Motor Support 2 21-040 House Side Angle 3 21-050 Motor Support 2 21-048 House Side Angle 3 21-050 Motor Support 3 21-050 Motor Support 3 21-050 Motor Support 4 21-050 Spacer 4 21-050 House Side Angle 3 21-050 Motor Support 3 21-050 Motor Support 3 21-050 Motor Support 4 21-050 House Side Angle 3 21-050 Motor Support 4 21-050 Spacer 4 21-050 Spacer 4 21-050 Spacer 4 21-050 Spacer 4 21-050 Motor (BL-5-184T Ajax) 1 21-050 Starter 1 21-027 Heater 3 20-026 Sheave (Driver) 1 21-054 Bushing 1 22-036 "V" Belt 2 20-036 "V" Belt 2 20-036 "V" Belt 2 20-037 Sheave (Driver) 1 22-076 Made In USA Label 1 22-077 Top 1 "L" Bar Roll 1 22-077 Top 2 "L" Bar Roll 1 22-077 Top 4 "L" Bar Roll 1 22-075 Top 4 "L" Bar Roll 1 22-076 Top 5-2 "L" Bar Roll 1	Part no.	Description	Quantity
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22-075 Top 4 "L" Bar Roll 1			
22-077 Top 5-1 "L" Bar Roll 1			
22-078 Top 6 "L" Bar Roll 1			
22-079 Top 6 Spacer 1			

FLAGLER HI-SPEED COMBINATION - "L" BAR

Part no.	Description	Quantity
22-080 22-081 22-082 22-083 22-084 22-085 22-086 22-087 22-088 22-090 22-091 22-092 22-093 22-094 22-095 22-095 22-096 22-097 22-098 22-099 22-099 22-099	Top 7 "L" Bar Roll Top 7 Spacer Top 8 "L" Bar Roll Top 8 Spacer Top 9 "L" Bar Roll Top 9 Spacer Top 10 "L" Bar Roll Top 10 Spacer Bottom 1 "L" Bar Roll Bottom 2 "L" Bar Roll Bottom 3 "L" Bar Roll Bottom 4 "L" Bar Roll Bottom 5 "L" Bar Roll Bottom 6-1 "L" Bar Roll Bottom 6-2 "L" Bar Roll Bottom 7-1 "L" Bar Roll Bottom 7-1 "L" Bar Roll Bottom 8-2 "L" Bar Roll Bottom 8-1 "L" Bar Roll Bottom 9-2 "L" Bar Roll Bottom 9-1 "L" Bar Roll Bottom 9-1 "L" Bar Roll Bottom 9-2 "L" Bar Roll Bottom 9-2 "L" Bar Roll	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
CINCINIA	III PRECISION	

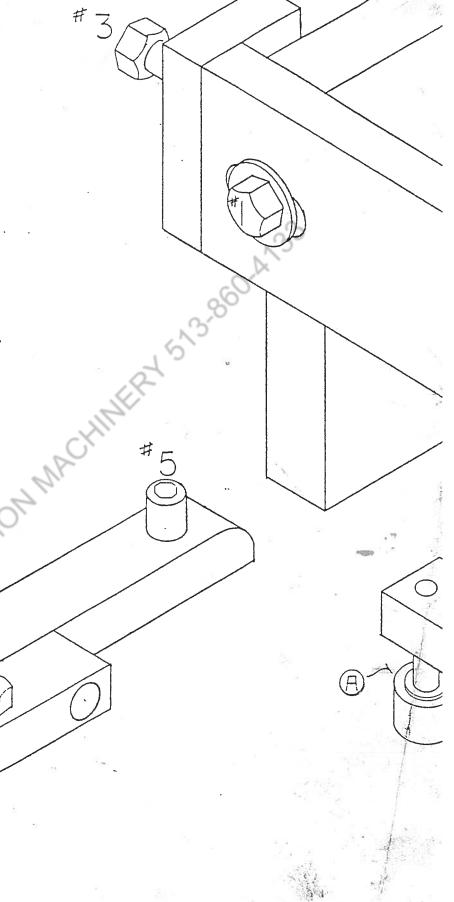


If the cleat is bowing to the right, loosen bolts #1 and #2 just enough to allow the whole assembly to slide. Now loosen bolt #4 slightly and tighten Bolt #3. This will move the entire assembly to the left. Tighten bolts #1 and #2.

If the cleat is bowing to the left, loosen bolts #1 and #2 just enough to allow the whole assembly to slide. Now loosen bolt #3 slightly and tighten bolt #4. This will move the entire assembly to the right. Tighten bolts #1 and #2.

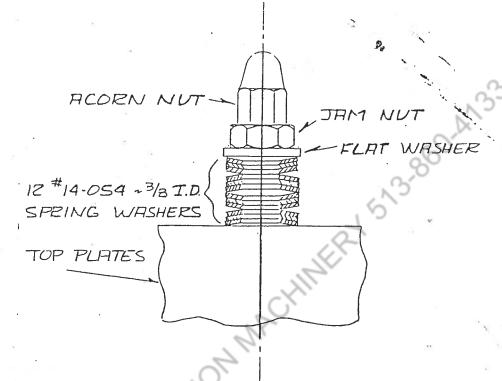
If the cleat is bowing up, lower the bottom slide with set screw #5; if it is bowing down, raise the bottom slide with set screw #5.

Material must be sheared accurately. Material that varies in width will also vary the straightness of the cleat.



TEN STATION SPRING WASHER ASSY. INSTRUCTIONS

3/8 HOLD DOWN STUDS



WHEN INSTALLING TIGHTEN JAM NUT UNTIL SPRING WASHERS ARE FLAT THEN BACK OFF ONE TURN AND TIGHTEN ACORIU NUT.

TO WORK PROPERLY SPRING WISHRS, MUST BE STACKED AS SHOWIN.

> THE FLAGLER CORP. 50600 E. Russell Schmidt Blvd. Mt. Clemens, Mich. 48045