

# MODELS 16 AND 18 GAUGE AUTO GUIDE PARTS LIST

# **LOCKFORMER**

Where the Machines of Tomorrow are Made Today<sup>SM</sup>

## 16/18 Auto-Guide **POWER FLANGER**

Instructions and Parts Diagram



New Part No.	Description	Pieces Per Unit	New Part No.	Description	Pieces Per Unit
40012	Gr. Hsg. AG 88010	1	40150	Topcvr. AG 88150	1
32037	Hsg. Cvr. AG 88020	1	66000	B88 Torr. Brg.	1
65602	Gskt. 15028	1	60309	1/4-20 x 1/2 SHCS	4
9951922	Stl. Worm Gr. Assy.	1	60761	5/16-18 x 3/4 Sq. HSS	1
66503	605 Thrust Brg.	1	*58514	Stand Assy.	1
66411	AA832-5 Amplx. Brg.	2	*29469	Mtr. Base	2
65240	7/8 Freeze Plg.	1	*80030	3/4 HP 1 60 18 66	1
65601	Oil Seal 6260	1	*70140	AC 33 x 5/8 Shv.	1
13116	Drv. Shft.	1	*70142	AC 53 x 5/8 Shv.	1
62103	7/8 x .025 Wshr.	1	*70027	4L580 Belt	1
43111	Worm Gr. Brz. 70854	1	*80481	Bx. Conn. 1/2	2
62401	9 Wdrf. Key	3	*80431	Bx. Cable 14-2 x 42	1
66080	B1412 Torr. Brg.	2	*60875	3/8-16 x 1CB	4
60005	1/4-20 x 3/4 HHCS	5	*61120	3/8-16 HN Hvy. Sf.	4
89100	Raw Lift Btttn.	1	*80204	Toggle Swch. 5011	1
11612	Pl. Form Roll	1	*80675	Handy Box Cvr.	1
14402	Gr. Bvl.	2	*60048	5/16-18 x 1 1/4 HHCS	4
62404	61 Wdrf. Key	2	*60576	10-24 x 1/2 RHMS	1
66310	NTA1018 Torr. Brg.	2	*60795	4 x 3/16 Dr. Scr. TP-U	4
40070	Comp. Arm AG 88070	1	*60797	4 x 1/4 D4 Scr. TP-U	8
66010	B108 Torr. Brg.	3	*60953	3/8-16 x 1 FHSCS	4
61353	5/8-18 Stop Nut	1	*61101	5/16-18 HN Hvy. SF.	4
40130	Form Hd. AG 88130	1	*62010	5/16 x 1/16 Wshr.	8
60099	3/8-16 x 2 1/4 HHCS	3	*62029	3/8 x 1/16 Wshr.	4
62363	3/8 Lck. Wshr.	7	*62362	5/16 Lck. Wshr.	4
11613	KnrL Roll	1	*62370	1/4 Lck. Wshr.	4
9956563	Inner Race Assy.	1	*66312	TRB1018 Torr. Race	4
61351	1/2-20 Stop Nut	1	*80483	Bx. Conn. 3/8	2
22592	Adj. Pvt. Nut	1	*80525	Cord Set 14-3 10	1
62650	1/2 x 1 DWL	2	*80602	Rg. Tng. Terminal	2
52601	Adj. Spring Tube	1	*80607	Insulating Cap	1
43412	Adj. Handle. 70912	1	*80608	Wire Joint	1
60680	3/8-16 x 3/8 SSS	1	*80650	Handy Box 4SS1	1
71012	Comp. Sprng.	1	*85151	AG Pt. Name Plate	1
19131	Spr Pvt. Rod	1	*85162	Instruction Plt	1
62440	Cncv. Key	1	*85164	Lckform Logo	1
14701	Adj. Dial	1	14702	Adj. Dial	1
60652	5/16-18 x 1/2 SSS	1	80020	1/2 HP-1-60-18-56	1
60406	3/8-16 x 1-3/4" SHCS	1			
62619	1/4 x 1" DW1	1			
11611	Adj. Guide Roll	1			
62633	3/8 x 1 DWL	1			
89104	Sensory Cstg.	1			
60712	7/16-20 x 3/8 SSS Cup	1			
60611	1/4-20 x 3/8 SSS	1			

\*Not Illustrated

CINCINNATI PRECISION MACHINERY 513-960-1788



# Operating Instructions

The operation of the machine is dependent upon proper gauge settings. The heavier materials require a greater spring pressure than the lighter and the settings can be made by turning the rear adjusting dial (43412) counter clockwise until a stop is reached. Then turn adjusting dial clockwise the proper amount of turns as indicated in chart #1, at right.

## CHART #1

*With Rear Adjusting Handle (43412) all the way out (counter clockwise movement), settings for gauges are as follows:*

<i>SETTINGS-Clockwise</i>	<i>TO-</i>
<i>1/2 to 1 turn</i>	<i>24-26 ga</i>
<i>1-1/2 to 2 turns</i>	<i>20-22 ga</i>
<i>2-1/2 to 3 turns</i>	<i>18 ga</i>
<i>3-1/2 to 4 turns*</i>	<i>16 ga</i>

*\*Adjustment for 16ga material only.*

The 14701 Adjusting Dial sets the proper clearance between the Knurled Forming Roll (11613) and Plain Forming Roll (11612). To operate machine properly, adjust the dial to thickness of material to be used and feed material with lead edge preformed into the rolls. (Preforming can be done by inserting material into slot cut into lower right of machine table top.) Proper adjustments will result with a smooth regular flange. Too much pressure will create a "buckled" flange showing a heavy knurl marking on flanged edge of the material. Insufficient pressure will cause material to slip in the rolls and not be powered through the machine.

The buckled flange can also be caused by too much pressure being exerted by the pressure arm (40070). Consult setting chart in manual or data on machine. A slight change of the above settings may have to be made to suit variances in material.

An irregular flange on curve surfaces would be caused by not enough pressure on the pressure arm and the dial setting should be increased by a clockwise adjustment.

A section of material formed with a buckled flange can be corrected by moving Auto Guide lever arm roller assembly back and out of position. Then start flange back through the machine. Do not apply any pressure to material - but only support piece as it goes through machine.

To eliminate galvanized accumulation on knurled forming roll it may be necessary from time to time to apply either kerosene or a light machine oil to the knurled roll. This will aid in keeping the roll from an over deposit of galvanized material. If galvanized material packs into knurl recesses it is

When running materials, other than cold roll steel or galvanized, e.g. aluminum stainless or copper, a slight modification of the standard settings may be required to operate properly.

For Running: Aluminum, Copper (soft) Materials:

The above materials will require a looser setting on both the front gauge (thickness) setting and pressure setting (spring pressure). Experience or test settings will be required. Should material shear at the corner, the damage could be caused by excessive pressure or metal pick-up and "galling" on the lifter button.

Where "galling" or metal pick-up is evident, the material will require lubrication to the part of the material being formed. Lubricants such as kerosene or a light machine oil should prove adequate.

For Running: Stainless Steel or Hard Brass Materials:

Increased spring pressure may be required for running certain types of stainless. A standard thickness setting is adequate. A drawing compound may be necessary to eliminate pick-up. A special aluminum bronze lifter button may be necessary for prolonged use of stainless materials. (A special quotation would be required for this button.)

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711 OGDEN AVENUE • LISLE, ILLINOIS 60532