# MODELS 16 AND 18 GAUGE AUTO GUIDE PARTS LIST

New Part No.	Description	Pieces Per Unit	New Part No.	Description	Pieces Per Unit
40012 32037 65602 9951922 66503	Gr. Hsg. AG 88010 Hsg. Cvr. AG 88020 Gskt. 15028 Stl. Worm Gr. Assy. 605 Thrust Brg.	1 1 1 1	40150 66000 60309 60761 *58514	Topcvr. AG 88150 B88 Torr Brg. 1/4-20 x 1/2 SHCS 5/16-18 x 3/4 Sq. HSS Stand Assy.	1 4 1
66411	AA832-5 Amplx. Brg.	2	*29469	Mtr. Base	2 1 1 1 1
65240	7/8 Freeze Plg.	1	*80030	3/4 HP 1 60 18 66.	
65601	Oil Seal 6260	1	*70140	AC 33 x 5/8 Shv.	
13116	Dry. Shft.	1	*70142	AC 53 x 5/8 Shv.	
62103	7/8 x .025 Wshr.	1	*70027	4L560 Belt	
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. S1.	4
89100	Raw Lift Btttn.	1	*80204	Toggle Swch. 5011	1
11612	PI. 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	2	*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 43412 60680 71012 19131	Adj. Spring Tube Adj. Handle. 70912 3/8-16 x 3/8 SSS Comp. Sprg. Spr Pvt. Rod		*80607 *80608 *80650 *85151 *85162	Insulating Cap Wire Joint Handy Box 4SS1 AG Pf. Name Plate Instruction Plt	A 444 M. 4.
62440 14701 60652 60406 62619	Cncv. Key Adj. Dial 5/16-18 x 1/2 SSS 3/8-16 x 1-3/4" SHCS 1/4 x 1" DW1	1 1 1 1	*85164 14702 80020	Lckform Logo Adj. Dial 1/2 HP-1-60-18-56	1 1
11611 62633 89104 60712 60611	Adj. Guide Roll 3/8 x 1 DWL Sensory Cstg. 7/16-20 x 3/8 SSS Cup 1/4-20 x 3/8 SSS			*Not Illustrated	



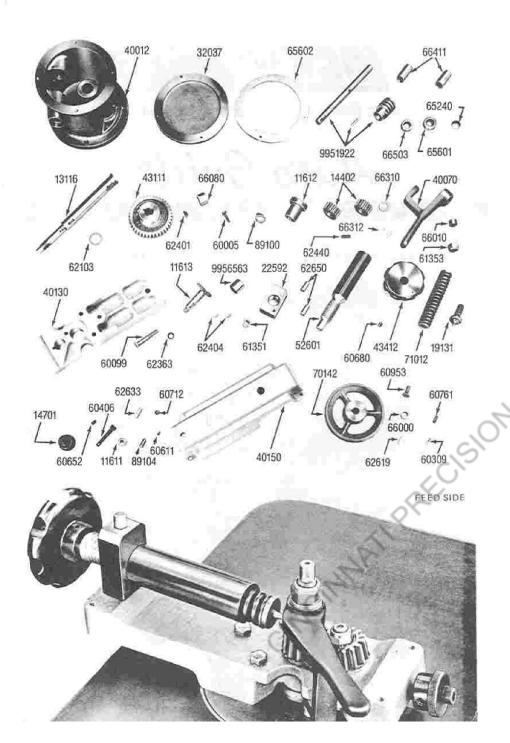
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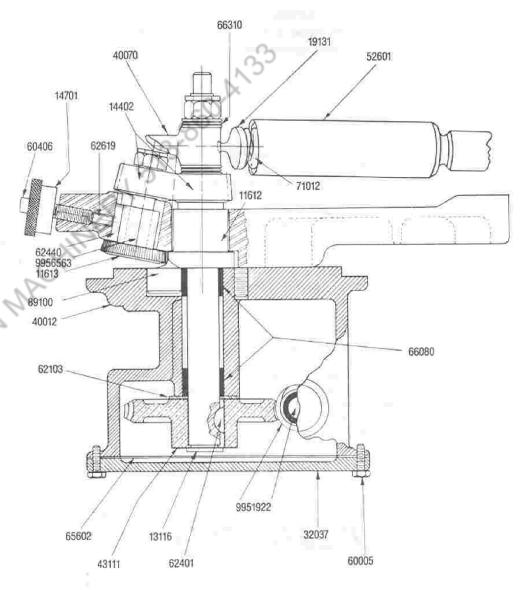
## 16/8 Auto-Guide POWER FLANGER

Instructions and Parts Diagram



#### INDICATE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS





### **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:

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

<sup>\*</sup>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 flamge can be corrected by moving Auto Guide lever arm roller assembly back and out of position. Then start flamge 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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