

# **LOCKFORMER**

# **SUPER-SPEED**



**THE LOCKFORMER COMPANY**

• 711 W. OGDEN AVENUE • LISLE, ILLINOIS 60532

CINCINNATI PRECISION

# Operating Instructions

Holding the material against the angle gauge slide it into the forming head. Be sure that the material remains against the gauge until work is finished.

Note: This machine will handle sheets 7" and longer. If shorter, leave on long piece — notch and cut later.

Make "Hold-Down Adjustment" to meet any variation in the material of your locality. Do not *adjust* unless material slips, tends to leave gauge, or curls up at finish.

## TO ADJUST:

1. Remove top cover.
2. Tighten hold-down studs until snug and then loosen them a quarter turn. (This setting will usually give proper adjustment for all thicknesses of material.)
3. *If the material slips, tighten the studs equally until the condition is overcome.*  
*If the material curls up after leaving the forming head, or shows extremely heavy pressure marks, loosen studs slightly.*

If a wider or narrower hammer-over edge is desired, the angle gauge on the right hand side can be moved to give the desired width. When moving this gauge, be sure to move both ends the same distance, keeping it parallel to the front edge of the top plate of the machine. **DO NOT MOVE ANGLE GAUGES ON THE LEFT OR FINISHING END OF THE MACHINE. THESE GAUGES ARE NOT INTENDED TO TOUCH THE MATERIAL AS IT COMES THROUGH.**

It is very important that long sheets be fed into the machine flat and against the angle gauge for the start.

**IMPORTANT:** If proper care is taken, the small knife edge roll that holds the pocket of the Pittsburgh Lock open will not break. If burrs and twists from snip cuts are not flattened out, it will sometimes strike against the opening roll causing it to break.

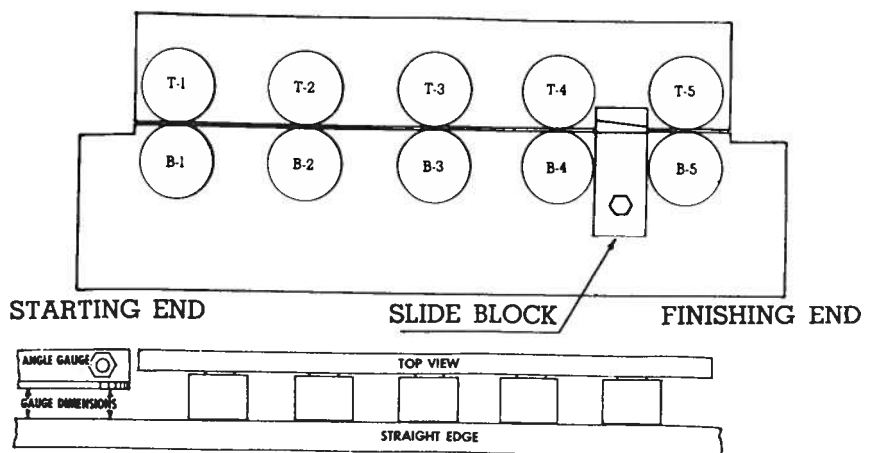
## Lubrication

Six lubrication fittings can be found on the underside of the stand roller case (auxiliary side of machine). Lubricate machine after every four hours of operation. Recommended lubricant, Standard Viscous No. 3, a product of the Standard Oil Company. Grease gears periodically. If machine is to be used out of doors an oil or grease film will prevent rusting of surfaces.

# Instructions for Instc

## DOUBLE SEAM or STRAIGHT RIGHT ANGLE FLANGE ROLLS

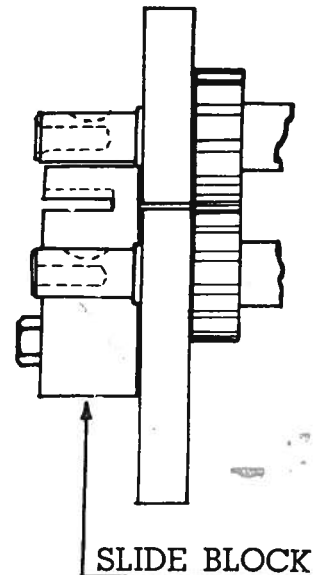
1. Remove top cover.
2. Remove rear section of top plate. This will expose the extended shafts on which the rolls are to be mounted.
3. Select the first pair of rolls, which are marked "T1" and "B1", and slip them on the shafts at the left, or feed side of the machine, placing "T1" on the upper shaft and "B1" on the lower. Repeat this procedure with rolls "T2" and "B2"; "T3" and "B3"; "T4" and "B4"; "T5" and "B5" until all rolls have been mounted. All rolls marked "T" should be on the top shafts and "B" rolls on the bottom shafts, in numerical order, reading from left to right, facing shafts. *THE NUMBERED SIDES MUST FACE OUTWARD, OR TOWARD THE OPERATOR.*
4. Fasten rolls to shafts with capscrews and special washers which are provided.
5. Mount gauge on starting side of machine, using slotted holes provided in top plate. The position of this gauge is shown below (Gauge Dimensions). The angle gauge on the finishing side should be flush against the metal as it emerges from the rolls.
6. Replace back plate and top cover.
7. Hold material against gauge and feed into machine.



# Installing Auxiliary Rolls

## Drive Cleat Rolls

1. Proceed as instructed for Double Seam Rolls, but leave roll "T-2" loose. This roll centers itself and should not be held in place with cap screw. Woodruff keys are used in all cases, however.
2. Remove stud indicated by arrow below (this is located between "B4" and "B5") and place the slide block in position, securing it with the 3" stud furnished. **CAUTION: ALWAYS REMOVE THE SLIDE BLOCK AND REPLACE THE SHORT STUD WHEN TAKING THE DRIVE CLEAT ROLLS OFF THE MACHINE.**
3. Mount the feed gauge on left hand side so that it is exactly centered with the rolls. **THIS IS VERY IMPORTANT!** If it is not centered, the cleat will not be perfect.
4. Tighten small hold-down studs so that "T5" and "B5" do not separate when drive cleats are passing through.



**IMPORTANT:** Be sure to cut your material a full  $2\frac{1}{8}$ " wide to insure a perfect cleat.

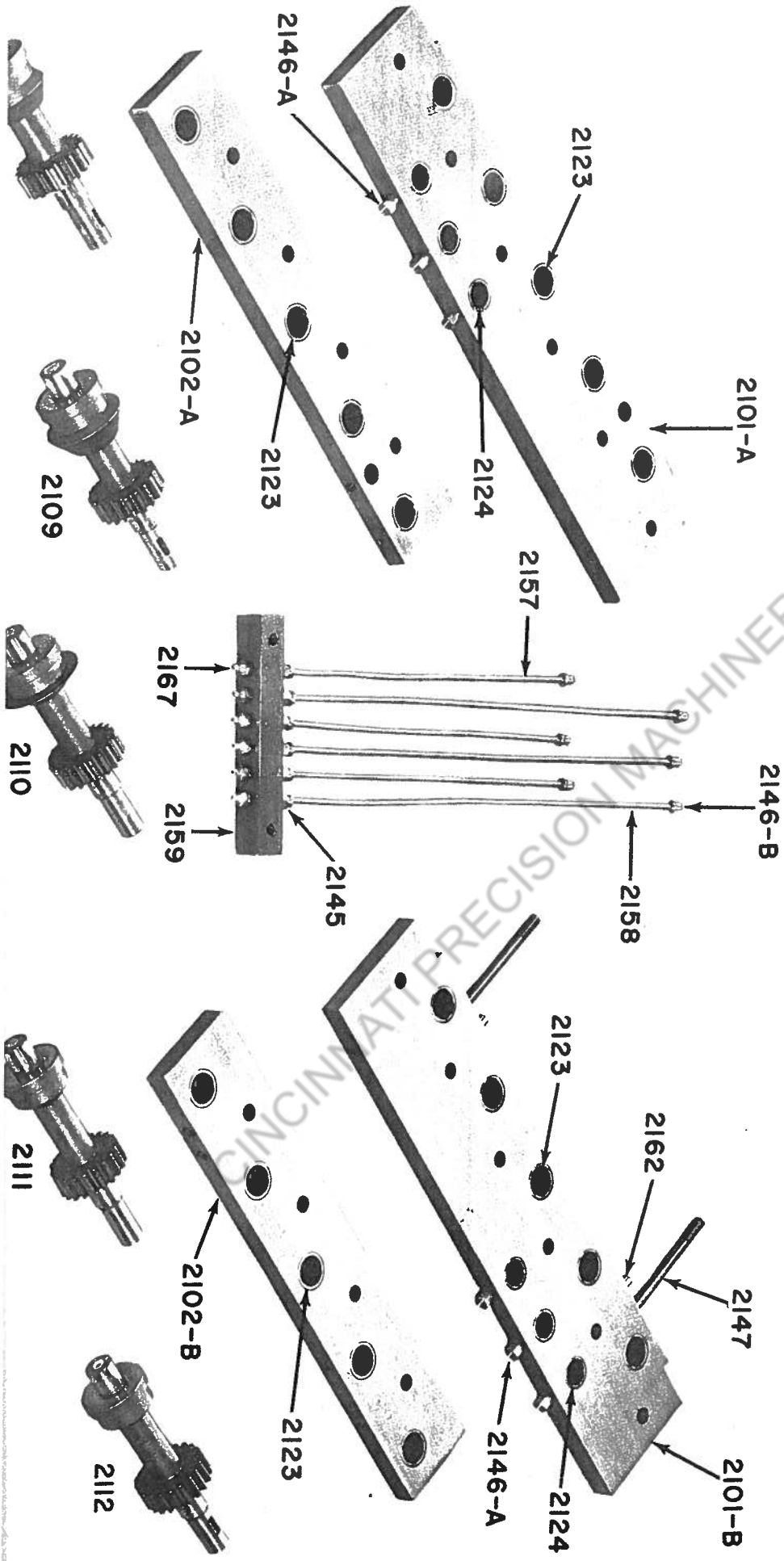
### GAUGE DIMENSIONS ARE:

For Double Seam Rolls.....	$1\frac{1}{8}$ "
For Right Angle Flange Rolls.....	$1-1/16$ "
For Drive Cleat Rolls install guide block with its inner edge in line with outer edge of rolls.	

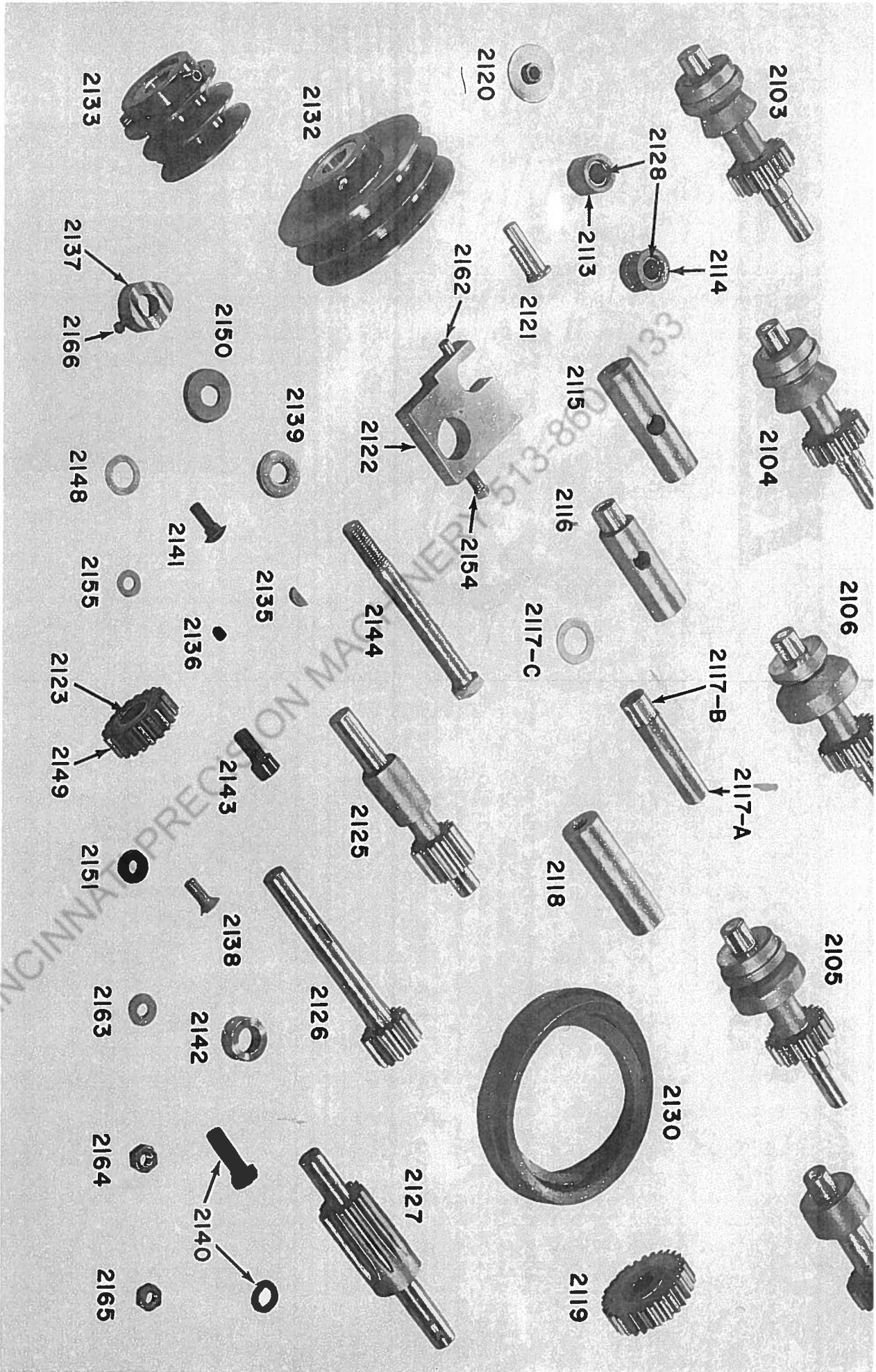
**NOTE:** Standard auxiliary rolls are interchangeable between the standard Lockformer "20" and the Super-Speed models. However, since different Entrance Gauges are required, the model for which auxiliary rolls are intended should be specified.

# LOCKFORMER SUPER-SPEED "20"

## PARTS LIST



CINCINNATI PRECISION MACHINERY 513-860-1733



PART NO.	DESCRIPTION	NUMBER USED
2101-A	Lower Front Plate	1
2101-B	Lower Back Plate	1
2102-A	Upper Front Plate	1
2102-B	Lower Back Plate	1
2103	Bottom 1 Forming Roll	1
2104	Bottom 2 Forming Roll	1
2105	Bottom 3 Forming Roll	1
2106	Bottom 4 Forming Roll	1
2107	Bottom 5 Forming Roll	1
2108	Top 1 Forming Roll	1
2109	Top 2 Forming Roll	1
2110	Top 3 Forming Roll	1
2111	Top 4 Forming Roll	1
2112	Top 5 Forming Roll	1
2113	Lower Idler Roll	1
2114	Upper Idler Roll	1
2115	Plain Spacer Drilled	2
2116	Step Spacer Tapped	2
2117-	A) Step Spacer, B) Retaining Ring, C) Washer	
2118	Plain Spacer	4
2119	3" Gear with Hub - 28 teeth	2
2120	Opening Roll	1
2121	Idler Roll Pins	2
2122	Opening Roll Holder	1
2123	Bearing 7/8" Shaft Dia. x 3/4" Long	24
2124	Bearing 3/4" Shaft Dia. x 3/4" Long	6
2125	Third Drive Shaft	1
2126	Second Drive Shaft	1
2127	First Drive Shaft	1
2128	Bearing 5/8" Shaft Dia. x 3/4" Long	2
2129	Switch Box	1
2130	V-Belt (B size Browning 5L48)	2
2131	Exit Angle Gauge	2
2132	Machine Pulley 2 Groove	1

2133	Motor Sheave 2 Groove	1
2134	B. X. Connectors	2
2135	No. 9 Woodruff Keys	3
2136	Allen Set Screws all 5/16" x 5/16"	5
2137	Locking Collar	2
2138	Flat Head Screw	4
2139	Steel Washer for Part No. 2144	2
2140	Stud & Lock Washer for Spacer	20
2141	Rd. Head Carriage Bolt for Angle Gauges 3/8x1	2
2142	3/4" Collar	2
2143	Macit Set Screw	1
2144	5/8" x 6" Holddown Stud	2
2145	Connector (Lubrication)	6
2146	Half Union (Lubrication)	6
2147	3/8" x 4-1/2" Hold Down Stud	2
2148	Brass Washers	6
2149	Steel Idler Gear	4
2150	1-1/2" O.D. Leather Washer	2
2151	3/4" O.D. Leather Washer	2
2152	Stand Assembly	1
2153	Forming Head Cover	1
2154	3/8" x 1" Set Screw	1
2155	3/8" Spacer Washer	2
2156	Entrance Gauge Bars	2
2157	Plastic Tubes	3
2158	Plastic Tubes	3
2159	Lubrication Connector Holder	1
2160	B. X. Cable	1
2161	2 H.P. Motor	1
2162	3/8 x 1" Dowel Pins	3
2163	3/8" I.D. Steel Washer	4
2164	3/8 Hexagon Nuts	6
2165	3/8 Hexagon Jam Nuts	2
2166	1/4 x 1/2 Sq. Hd. Set Screw	2
2167	Alemite Hydraulic Fitting (Zerk)	6
2168	Rd. Hd. carriage bolts for Entrance Gauges, 3/8x1 1/4	2