

# 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

Check and refill the six grease cups on the under side of the forming unit at least once a month. The slow speed shafts

do not require lubrication. Check oil in motor occasionally.

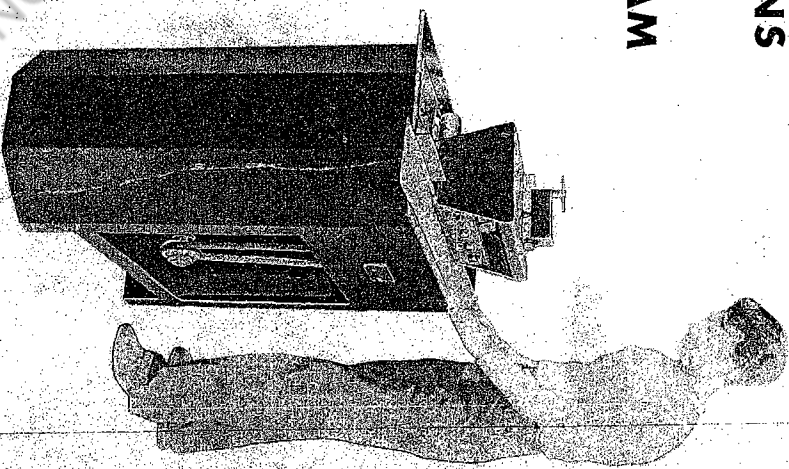
If machine is used out of doors an oil or grease film will

prevent rusting of surfaces

# LOCKFORMER

# 22

INSTRUCTIONS  
*and*  
PARTS DIAGRAM

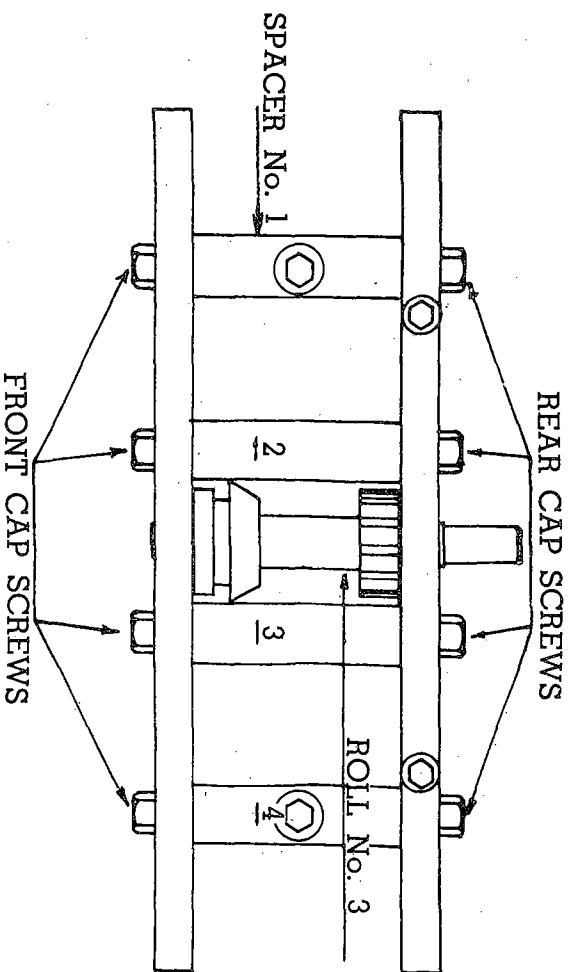


## THE LOCKFORMER COMPANY

## To Install Power Flanging Attachment

1. Remove present cover.
2. Loosen FRONT CAP SCREWS on Spacers No. 1 and 4.
3. Remove Spacers No. 2 and 3 by taking out front and back cap screws.
4. Set flanging attachment over the forming head so the combination bevel and spur gear meshes with the gear on Pittsburgh Lock Roll No. 3.
5. Fasten flanging attachment with the cap screws which held Spacers No. 2 and 3 in place.

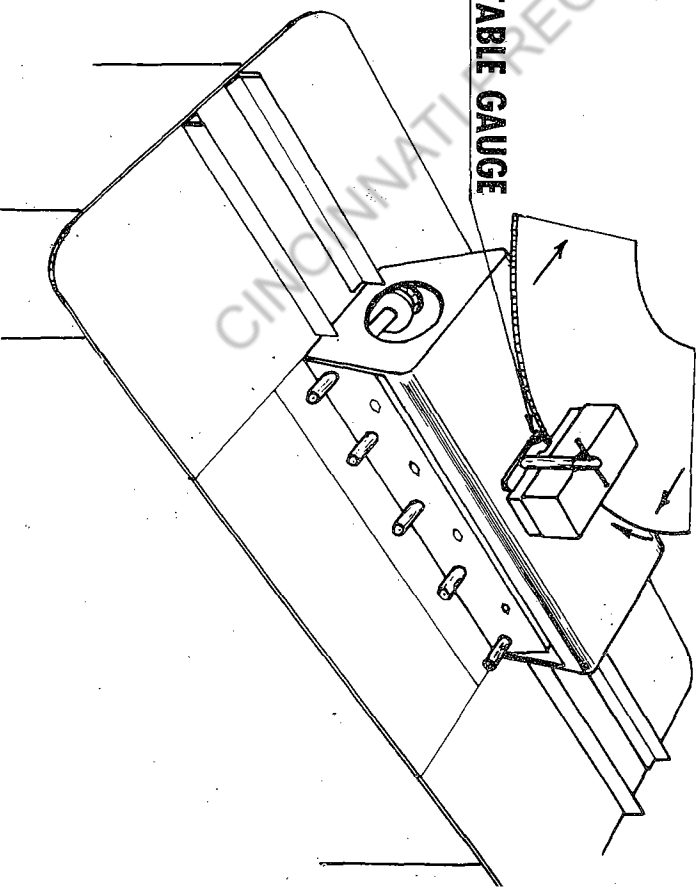
**CAUTION: BE SURE TO TIGHTEN ALL CAP SCREWS!**



## To Operate Power Flanging Attachment

1. Turn gauge adjustment screw all the way in and then 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 it is too loose.
2. Turn up a "starting flange" by using the slot cut in the table top. (On 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. 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, it may be necessary to pass the piece through the rolls a second time to remove wrinkles and straighten the flange.
4. When flanging straight pieces or pieces having a constant radius, the operator may set the adjustable guide. Run a piece partly through the rolls and then set the guide against the flanged edge and then pieces may 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 run off the edge, the piece isn't spoiled. Just run it through the flanger again.
7. After the operator has flanged a few pieces, he will get the "feel" of the machine and find how easily the metal is guided to bring up a perfect flange. For ease in handling of material stand in front of the machine.

## ADJUSTABLE GAUGE

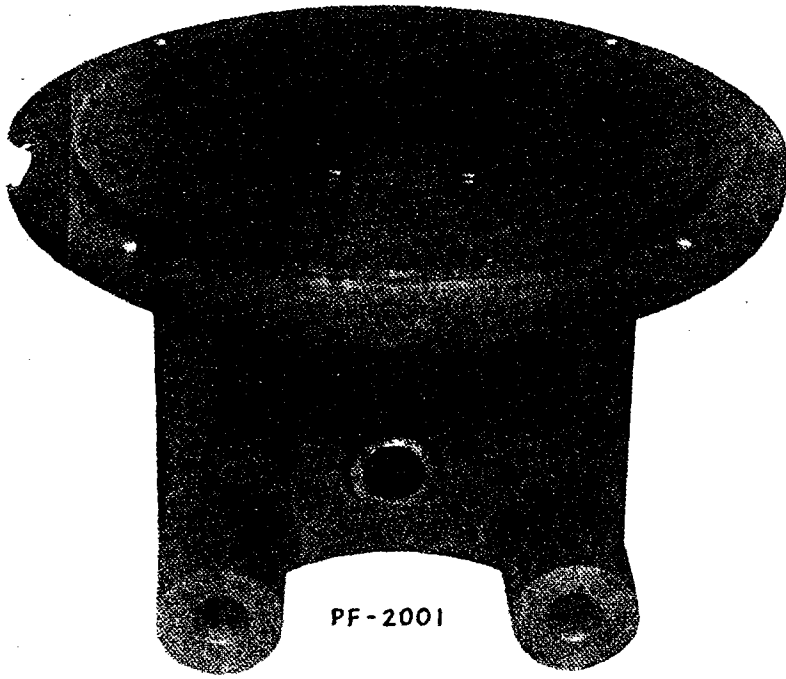


# LOCKFORMER 20 & 22-FLANGER ATTACHMENT-PARTS LIST

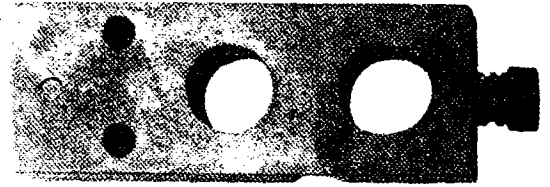
<u>PART NUMBER</u>	<u>DESCRIPTION</u>	<u>No. per Machine</u>
PF-2001	Cast iron base	1
PF-2002	Steel forming head	1
PF-2003	Cover for steel forming head	1
PF-2004	Bevel gear	1
PF-2005	Combination bevel and spur gear	1
PF-2006	Lifter plug	1
PF-2007	Slotted roll holder	1
PF-2008	Knurled forming roll	1
PF-2009	Plain forming roll	1
PF-2010	Spacer plate for steel forming head	1
PF-2011	Handle for adjustable guide	1
PF-2012	Shaft for bevel gear	1
PF-2013	Hexagon head bolt	2
PF-2014	Hardened steel race with two bearings inserted	1
PF-2015	Hardened and ground steel shaft	1
PF-2016	Bearing - 5/8" shaft diam. x 3/4" long	2
PF-2017	Hexagon head nut	1
PF-2018	Adjustable guide roll	1
PF-2019	Hexagon head stud	4
PF-2020	Steel gear - 18 teeth - no hub	1
14103 PF-2021	Steel gear - 18 teeth - with hub	1
PF-2022	Lock washer	4
PF-2023	Plain washer	1
PF-2024	Flat head screw	4
PF-2025	Woodruff key	3
PF-2026	3/8" Allen set screw	1
PF-2027	5/16" Allen set screw	1
PF-2028	1/4" Allen set screw	1
PF-2029	Bearing - 5/8" shaft diam. x 1/2" long	2

**THE LOCKFORMER CO.**

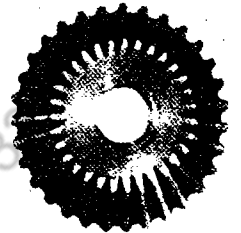
4615 WEST ROOSEVELT ROAD • CHICAGO 50, ILLINOIS



PF-2001



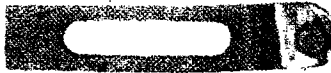
PF-2002



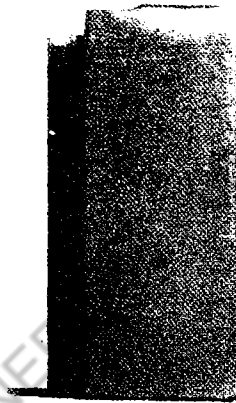
PF-2004



PF-2006



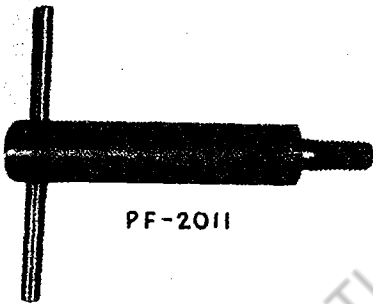
PF-2007



PF-2003



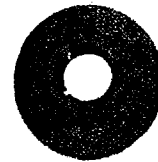
PF-2005



PF-2011



PF-2008



PF-2009



PF-2010



PF-2016



PF-2017



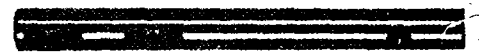
PF-2012



PF-2013



PF-2014



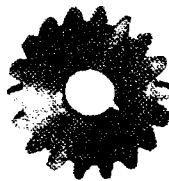
PF-2015



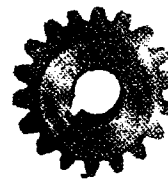
PF-2018



PF-2019



PF-2020



PF-2021



PF-2022



PF-2023



PF-2024



PF-2025



PF-2026



PF-2027



PF-2028



PF-2029