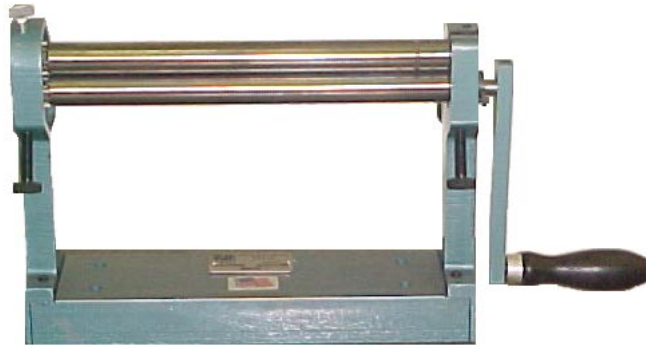


SR-12

PRECISION ROLLER



WARNING: Before operating, machine must be bolted to work bench. If floor stand has been provided, machine must be bolted to floor stand with bolts provided. Stand must be securely lagged to floor.

The SR-12 Precision Roller is intended for rolling sheet metal or forming cylinders of various diameters.

The two pinch rolls feed the sheet against the rear roll, curving the sheet and forming the cylinder. The rear or forming roll can be adjusted by screws on the rear of left and right end housings, varying the diameter of the required cylinder. Pinch rolls can be adjusted for stock thickness by screws on front of end housings.

The capacity ratings of forming machines are based on forming mild steel, fully annealed, the full length of the rolls and are considered as standard by the sheet metal trade for forming rolls of a specified diameter and length. Definite capacities, however, depend upon the diameter and length of cylinder to be formed and the number of passes through the rolls to obtain a given diameter. Stiffness of material and uniformity desired are also factors. When a forming machine is overloaded, the immediate result will be deflection in the center of the rolls, resulting in cylinders bulged in the center.

In order to reduce the number of rear roll adjustments when sheets are of light gauge, proceed as follows:

1. Insert the sheet between two pinch rolls.
2. Bend the sheet upwards and slightly around the top roll.
3. Continue to pass the sheet through the machine.

This will also reduce the flat spot on the leading edge of the sheet.

The right-hand housing is provided with a hinged journal cap and lifting latch. After the cylinder is formed, the latch is lifted and the lever is pressed down. This raises the top roll and the cylinder can be slipped off the roll without distortion.

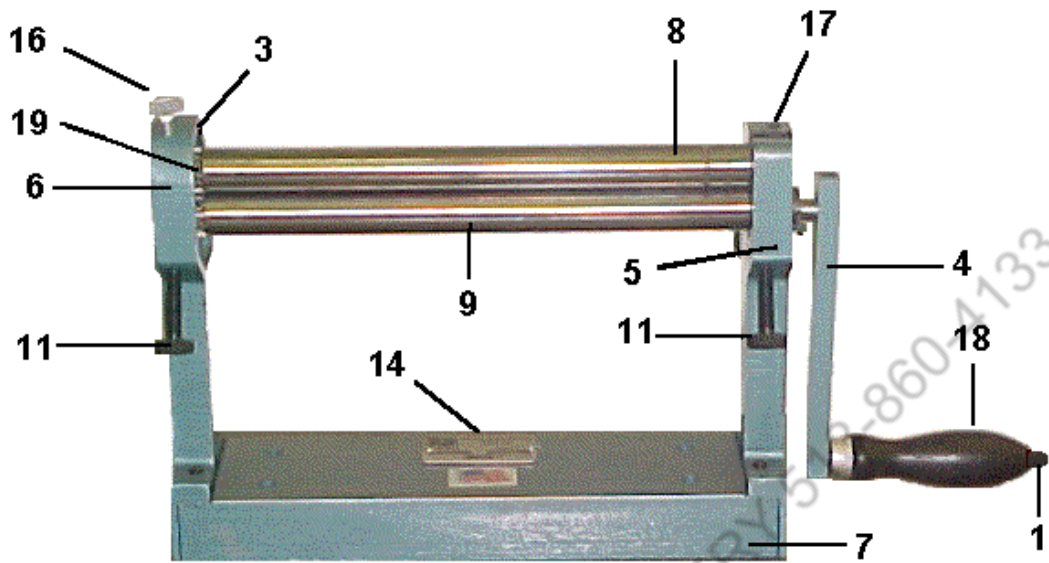


ROPER WHITNEY OF ROCKFORD, INC.

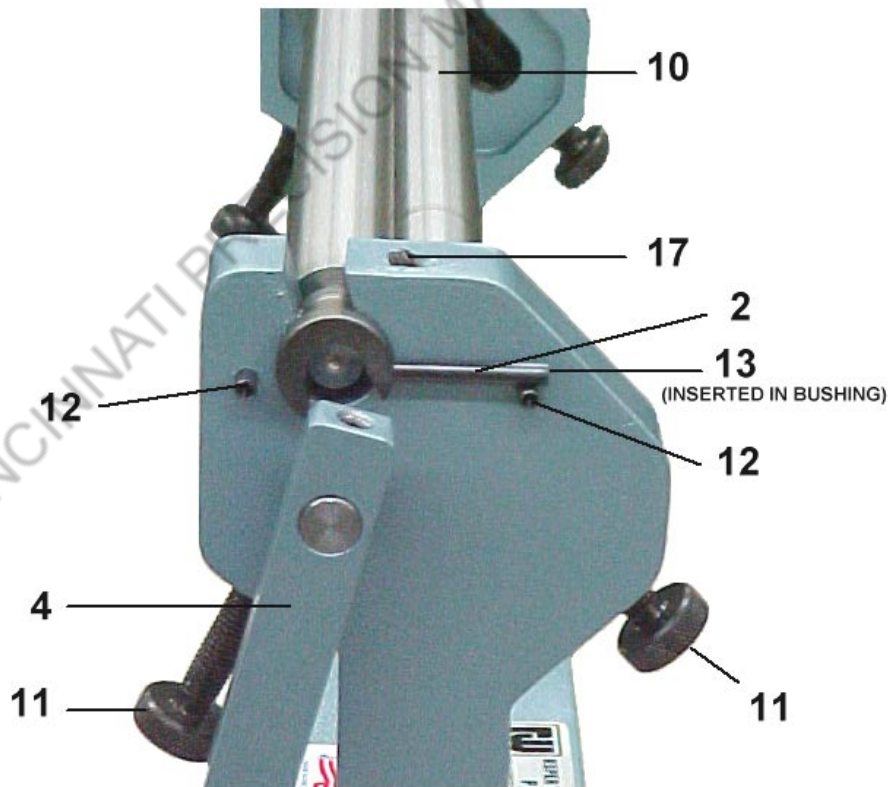
2833 HUFFMAN BLVD., ROCKFORD, ILLINOIS 61103-3990 * 815/962-3011 * FAX 815/962-2227

Website: www.roperwhitney.com * Email: info@roperwhitney.com

SR-12 PARTS IDENTIFICATION CHART



FRONT VIEW



SIDE VIEW

SR-12
PARTS IDENTIFICATION LIST

| ITEM NO. | PART NO. | PART NAME | QTY. |
|-----------------|-----------------|------------------------------------|-------------|
| 1 | 767210201 | Crank Stale | 1 |
| 2 | 767280192 | Release Bushing | 1 |
| 3 | 767380193 | Drive Gear | 2 |
| 4 | 767460200 | Handle Bar | 1 |
| 5 | 767140194 | End Frame, Right | 1 |
| 6 | 767140195 | End Frame, Left | 1 |
| 7 | 767060199 | Base | 1 |
| 8 | 767630196 | Top Roll | 1 |
| 9 | 767630197 | Drive Roll | 1 |
| 10 | 767630198 | Back Bend Roll | 1 |
| 11 | 600012684 | Adjusting Screws | 4 |
| 12 | 600063452 | Roll Pin 3/16 x 5/8 | 2 |
| 13 | 600063457 | Roll Pin 3/16 x 1 1/2 | 1 |
| 14 | 600346122 | Roper Whitney Name Tag | 1 |
| 15 | 689980179 | Brass Bushing (not shown on chart) | 5 |
| 16 | 641012133 | Thumb Screw | 2 |
| 17 | 621012130 | Set Screw 5/16-18 x 5/8 | 1 |
| 18 | 640356309 | Crank Handle | 1 |
| 19 | 600063435 | Roll Pin 1/8 x 3/4 | 2 |