

20 Ga. Stand Alone Power Flanger Operating Instructions

ALL MACHINE COVERS MUST BE ON THE MACHINE DURING OPERATION

Capacity: 20 - 26 Gauge

THE FLAGLER CORPORATION

56513 Precision Dr. Chesterfield, MI 48051 586.749.6300 F.586.749.6363 www.flaglercorp.com

FLANGE FOLLOWER INSTRUCTIONS

The Flange Follower is stamped for different gauges. This setting is for straight pieces and slight curves. When forming the flange an outside radius, more pressure will be need, up to one full revolution inward of the dial. When forming the flange on interior curves, less pressure (then the straight setting) should be used.

For tight interior radiuses (less then 3 1/4" radii) the Flange Follower must be disengaged and the part run through by hand.

The thumb screw also needs to be adjusted for different gauge thickness' of metal. If the metal is not held into the forming rolls this usually means that the Thumb screw is not tight enough. If the flange has a wave to it then the thumb screw is too tight.

If the settings are not correct and the flange does not form properly, simply adjust the machine accordingly and run the piece through again. Depending on the adjustment needed the part will still be good.

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20 GA. POWER FLANGER

MASTER PARTS LIST

30-May-02

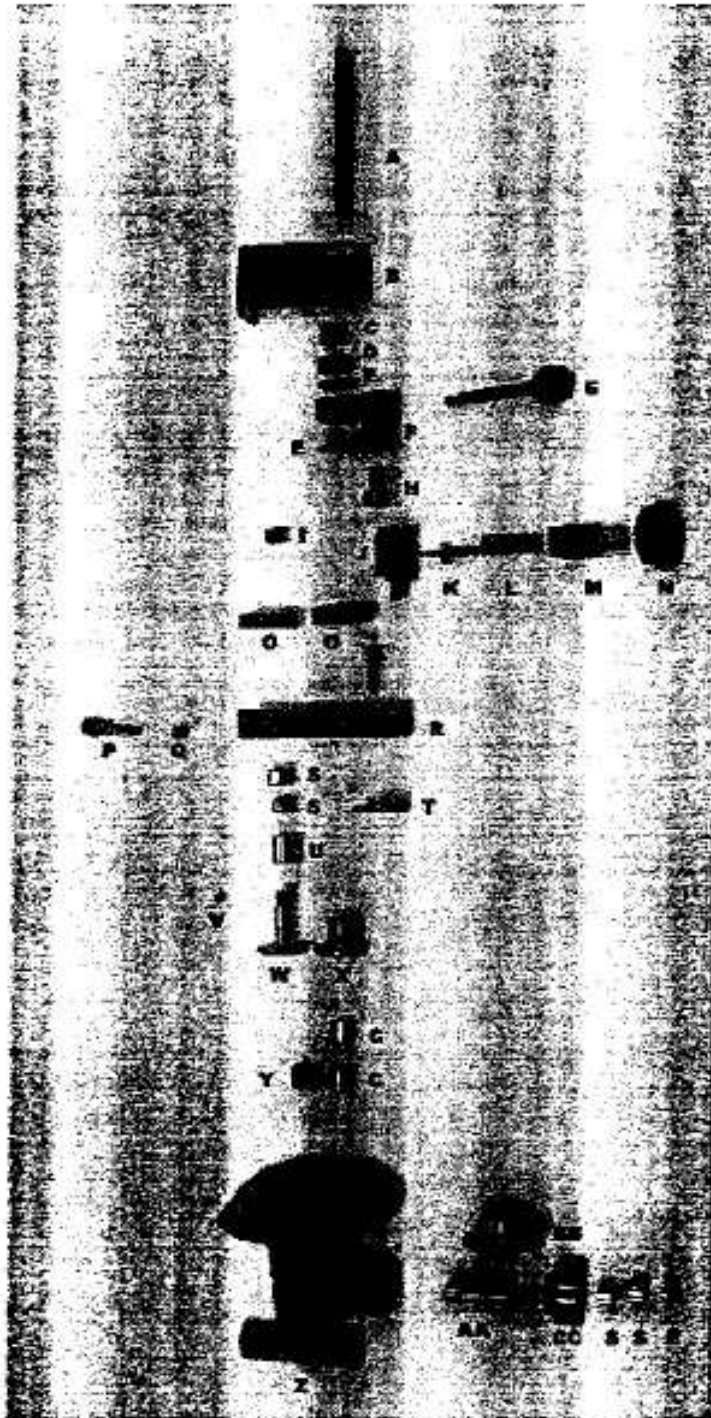
PART NUMBER	DESCRIPTION	SIZE	QTY
15-001	Casting	---	1
11-002	Forming Block	1.00 x 2.00 x 5.500	1
11-003	Spacer Plate	.250 x 2.00 x 1.593	1
11-108	Main Shaft	.625rd. X 6.250	1
11-005	Plain Gear	2.00rd. X .500	2
15-002	Bevel Gear		1
15-003	Combination Gear		1
10-011	Bearing 108	---	6
11-033	Oilite TT-1204-01	.625 x 1.250 x .125	3
11-010	Inner Race #IR-1316	---	1
11-011	Collar	#2X369	1
11-101	Swivel Block	1.00 x 2.00 x 1.750	1
11-102	Adjustment Screw	1 1/4-7 Th'd Rod x 2.5	1
11-104	Adjustment Handle	2.250rd. X .875	1
11-109	Spring	#9588K34	1
11-103	Nose	.750rd. X 1.875	1
11-107	Cam Block Assembly	---	1
22-015	Cam Follower	#CF-7/8-B	1
11-110	Knob/Handle Assy.	---	1
11-025	Plain Roll	2.00rd. X 1.250	1
11-026	Knurled Roll	1.875rd. X 2.156	1
11-027	Lifter Button	1.00rd. X .938	1
11-028	Dowell Pin	---	1
11-029	Thumb Screw	---	1
11-030	Spring	---	1
11-031	#61 Woodruff Key (Mod)	---	1
15-102	Pinion Plate	.750 x 3.00 x 6.00	2

I NUMBER	DESCRIPTION	SIZE	QTY
14-011	Roll Shaft	1.00rd. X 7.125	1
14-012	Roll Shaft Gear	2.250rd. X .750	1
15-103	Collar	#6435K17	1
21-032	Oilite TT-1503	.875 x 1.500 x .125	1
14-021	Bearing 1412	----	2
11-017	Cover Assembly	----	1
15-101	Cabinet Assembly	----	1
15-107	Cabinet Top	12GA. X 24.00 x 24.00	1
27-014	Side Panel	14GA x 14.00 x 14.00	2
27-015	Skirt	14GA x 29.00 x 34.00	2
27-027	Feet	12GA x 3.5 x 22.00	2
27-017	Bottom Angle	2.0 x 1.250 x .188 x 19	2
15-110	Motor Mount	.500 x 3.500 x 8.00	1
17-047	Lag Screw Plate	.250 x 1.250 x 4.00	4
14-048	Motor Clamp Assembly	----	4
15-104	Sprocket (Driver)	#6280K663	1
15-105	Sprocket (Driven)	#6280K702	1
15-108	#40 Roller Chain	4 ft.	1
15-109	#40 Connecting Link	----	1
15-106	Gearmotor	1/3 HP 115/1760/59	1
10-036	Cord	----	1
10-037	Connector	----	1
10-038	Switch	----	1
10-039	Switch Box Cover	----	1
10-041	Switch Box	----	1
10-031	Manufacturer Label	----	1
10-040	OSHA Label	----	1
10-042	Warning Label	----	1
10-047	"Flagler" Label (Small)	----	1

Item	Description	Model 24		Model 22		Model 20	
		Part #	Qty.	Part #	Qty.	Part #	Qty.
Z	Casting	11-001	1	13-001	1	15-001	1
R	Forming Block	11-002	1	11-002	1	11-002	1
T	Spacer Plate	11-003	1	11-003	1	11-003	1
A	Main Shaft	11-108	1	11-108	1	11-108	1
O	Plain Gear	11-005	2	11-005	2	11-005	2
BB	Bevel Gear	11-006	1	11-006	1	15-002	1
CC	Combination Gear	11-007	1	11-007	1	15-003	1
S	Bearing #108	10-011	2	10-011	2	10-011	4
C	Bearing #1012	11-009	4	11-009	4	11-009	3
E	Oilite #TT-1204-01	11-033	3	11-033	3	11-033	3
U	Race #IR-1316	11-010	1	11-010	1	11-010	1
D	Collar	11-011	1	11-011	1	11-011	1
J	Swivel Block	11-101	1	11-101	1	11-101	1
M	Adjustment Screw	11-102	1	11-102	1	11-102	1
G	Adjustment Handle	11-104	1	11-104	1	11-104	1
L	Spring	11-109	1	11-109	1	11-109	1
K	Nose	11-103	1	11-103	1	11-103	1
F	Cam Block Assembly	11-107	1	11-107	1	11-107	1
H	Cam Follower CF 7/8-B	22-015	1	22-015	1	22-015	1
N	Knob/Handle Assembly	11-110	1	11-110	1	11-110	1
B	Gear Cover Assembly	11-111	1	11-111	1	11-111	1
X	Plain Roll	11-025	1	11-025	1	11-025	1
W	Knurled Roll w/key & nut	11-026	1	11-026	1	11-026	1
Y	Lifter Button	11-027	1	11-027	1	11-027	1
AA	Dowell	11-028	1	11-028	1	11-028	1
P	Thumb Screw	11-029	1	11-029	1	11-029	1
Q	Spring	11-030	1	11-030	1	11-030	1
V	#61 Woodruff key (modified)	11-031	1	11-031	1	11-031	1
	Cover	11-018	1	13-002	1	15-004	1

Disconnect power prior to removing any guarding for any reason

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 EMAIL INFO@FLAGLERCORP.COM WWW.FLAGLERCORP.COM

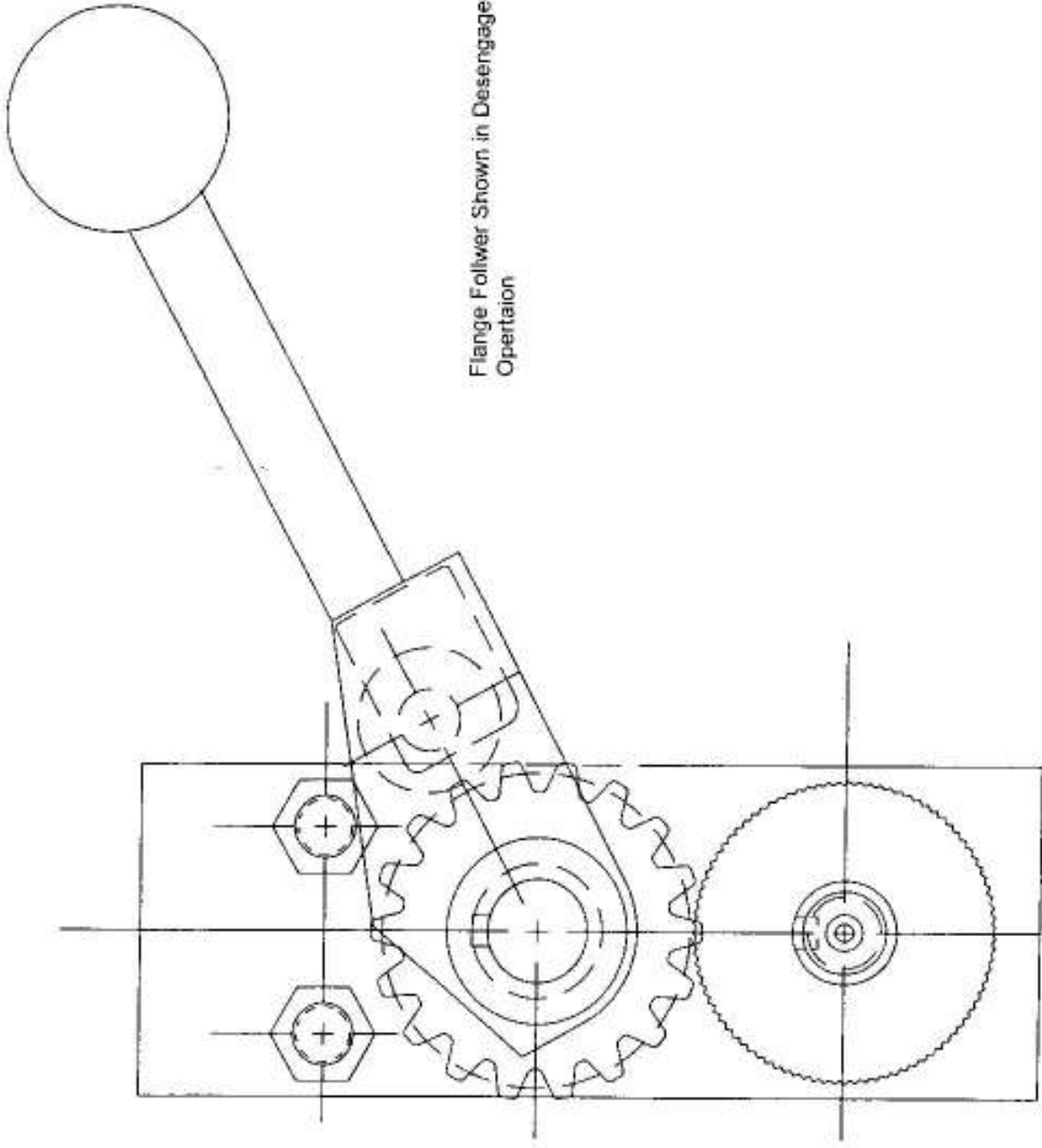


Breakdown shown is of 20 Ga. Flanging Attachment

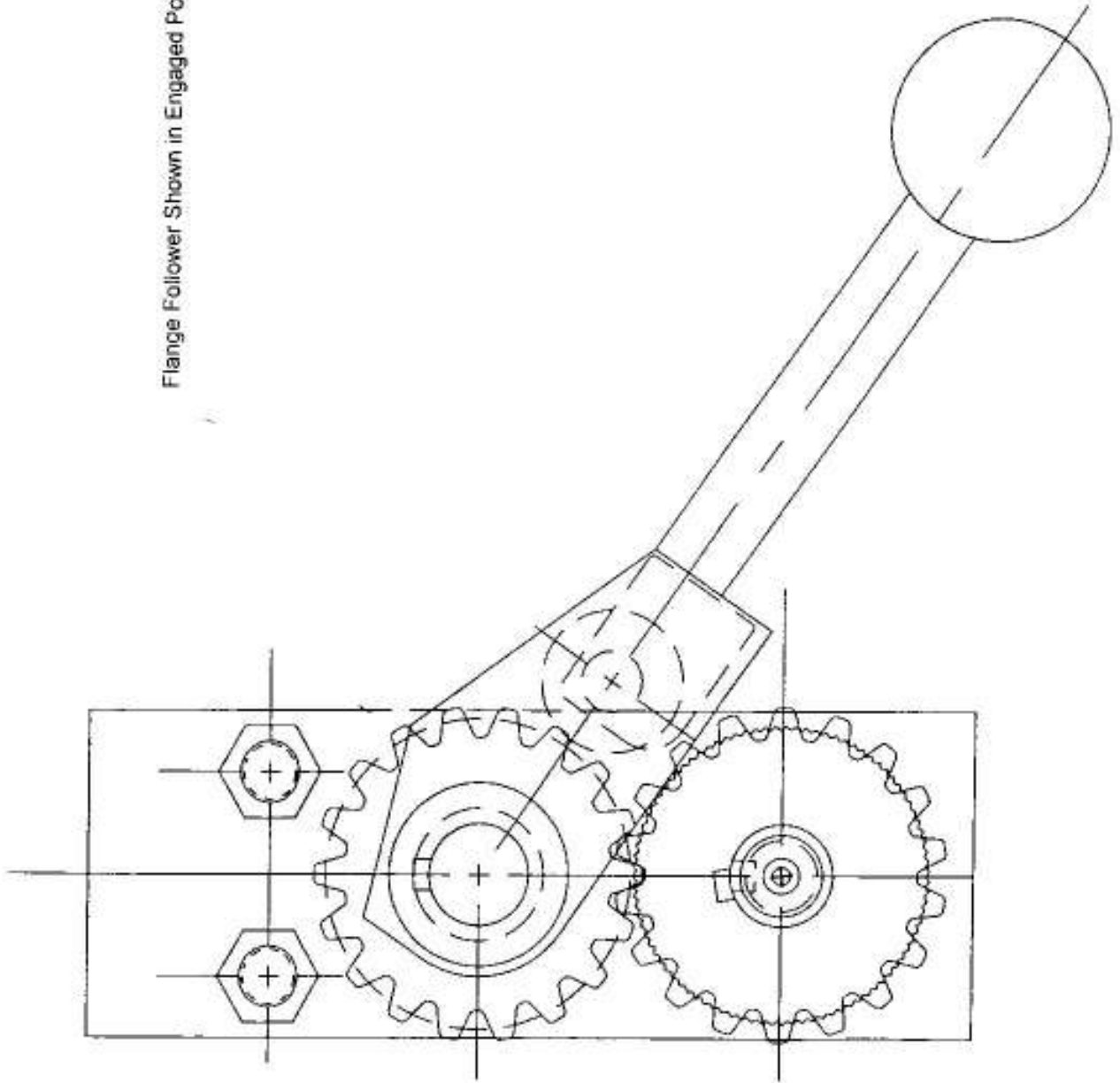
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Flange Follower Shown in Disengaged Position for Manual Operation



Flange Follower Shown in Engaged Position

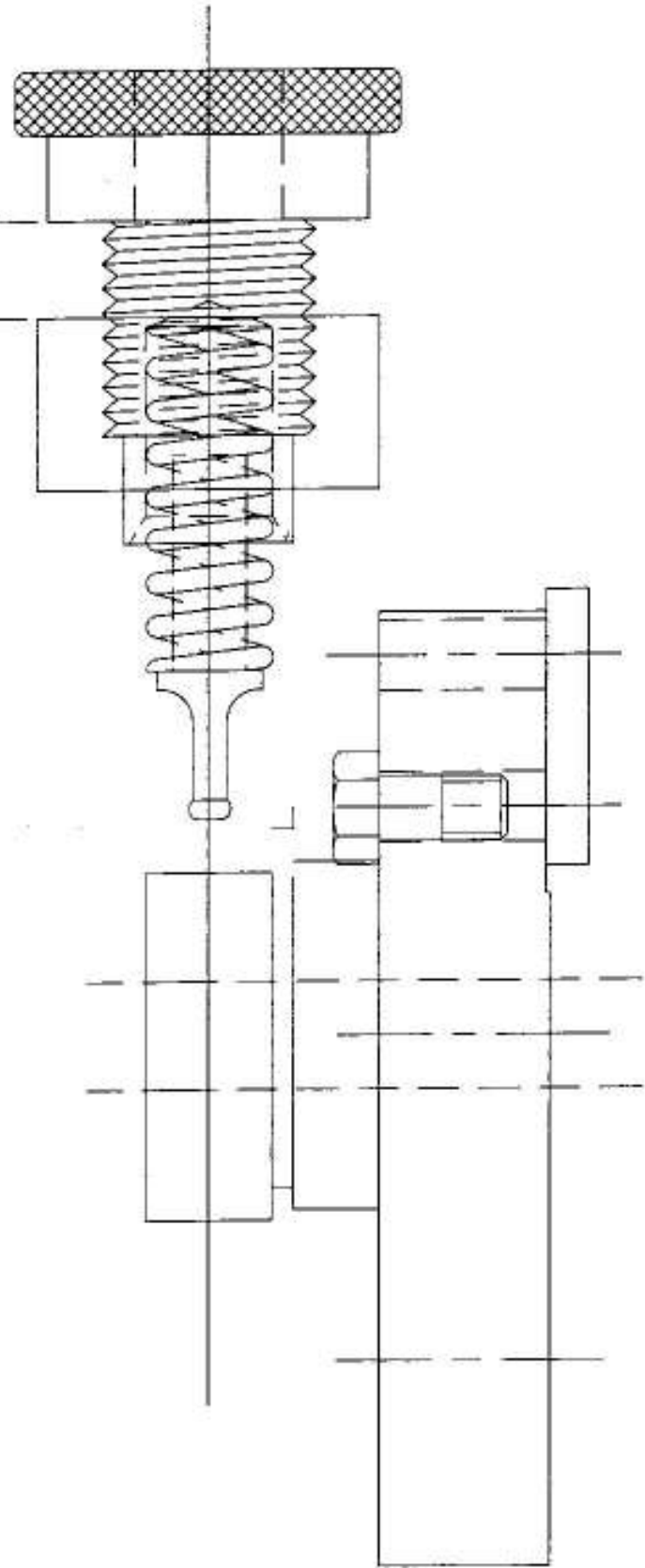


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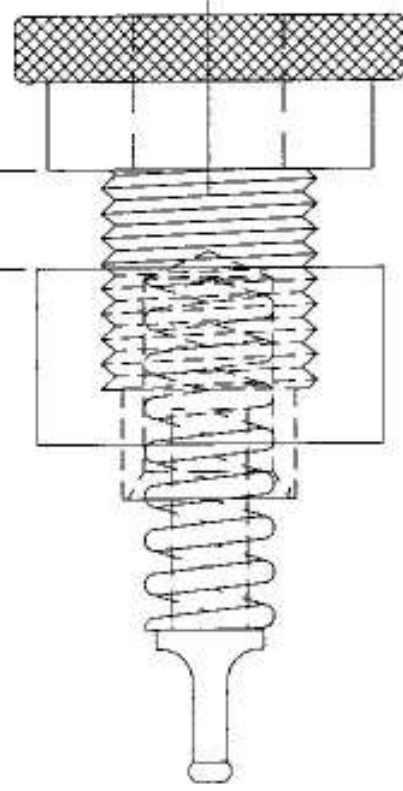
56513 Precision Dr.
Chesterton, WI 48051
1981 749-6300
FAX: 1981 749-5303

$\frac{3}{16}$ " is the setting for 20 ga.
Lock the knurled roll in place with the 20 ga. stamp on top
of the roll.

To Change the gauge to 24, turn the handle out
until the 24 is on the top of the dial



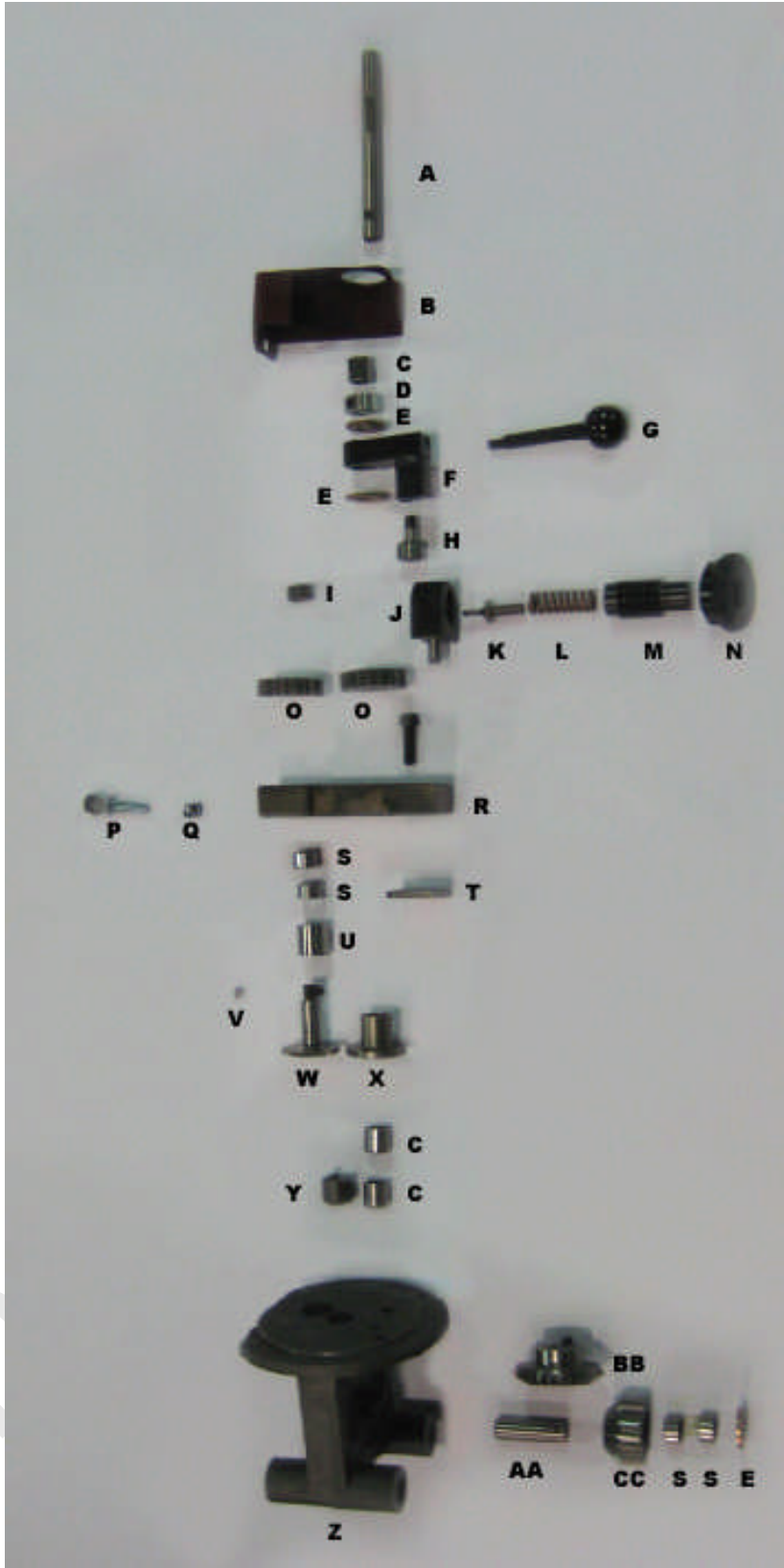
3/16" - 24 Ga.
5/8" - 22 Ga.
9/16" - 20 Ga.



Flange Follower Factory Settings for Straight Pieces

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56513 Precision Dr.
Crawford, MA 01871
(955) 779-8700
Fax: (955) 740-0360



Breakdown shown is of 20 Ga. Flanging Attachment

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