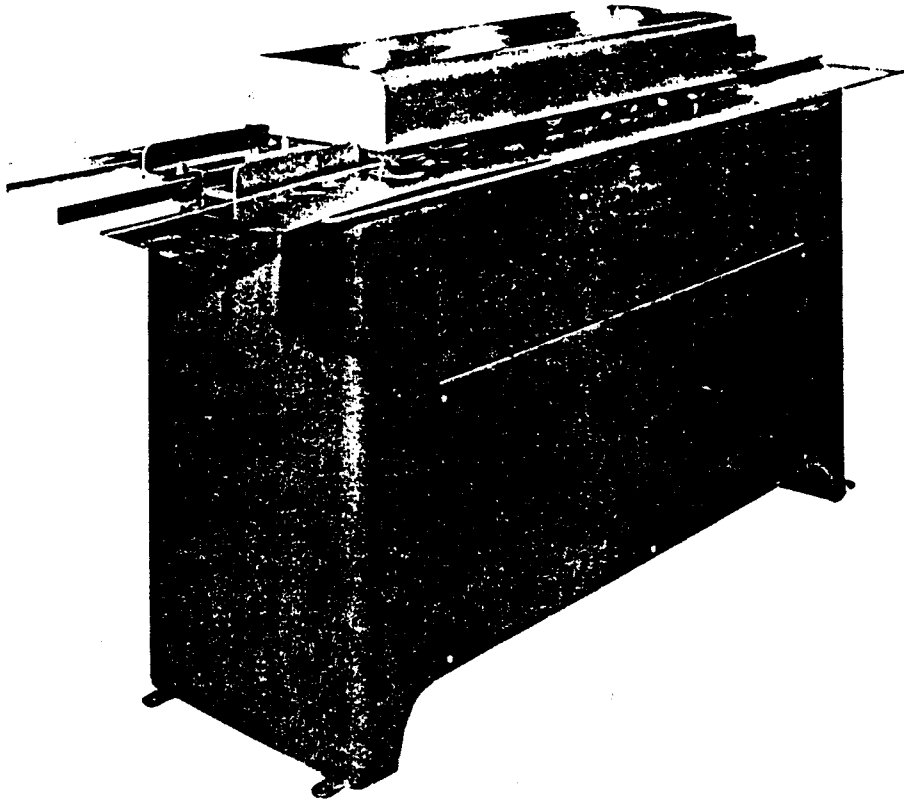


GENERAL OPERATING INSTRUCTIONS AND PARTS LIST



FLAGLER HI-SPEED COMBINATION "S" CLEAT MACHINE

the **flagler** corp.

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OUR NEW
AREA CODE IS
586

GENERAL INSTRUCTIONS

FLAGLER MODEL HI-SPEED COMBINATION MACHINE

Electricals:

5 HP 230/460/3/60 motor and controls. Standard machine wired for 230 volts unless otherwise specified.

Operation:

When machine has been wired to correct power source, check rotation. When rotation has been determined, place properly sheared blank between gauge bars and feed material into the rolls. Check the end result and make changes accordingly.

Adjustments:

Should the machine labor under load, the hold down studs are set too tight. To re-adjust, tighten the eight studs that pass through the machine plates and then loosen approximately one quarter of a turn (90 degrees). Should the machine continue to labor, loosen the four studs on the lead end of the machine to three-eighths (135 degrees) or one-half turn (180 degrees). Downward bow can be compensated for by adjusting the hold down studs located at the exit end of the machine. Side bow is caused by an imbalance in the stud adjustment.

Lubrication:

Lubrication fittings for the high speed shafts are located in the side panel through a central lubrication system. The high speed bearings should be lubricated every eight hours of operation. A coating of good open gear grease should be kept on the gears at all times.

NOTE: If the machine is to be used or stored out-of-doors, an oil or grease film will prevent rusting of all surfaces.

Instructions for mounting auxiliary rolls:

Machine auxiliary shafts are designed to accommodate various auxiliary rolls listed below. To install these rolls, proceed as follows:

1. Remove the section of the table top side plate in the side of the machine which the rolls are to be mounted.
2. If auxiliary rolls are now on the machine, remove the retaining bolts and washers. Remove all parts not pertaining to the set to be used.
3. Place all woodruff keys in proper location.
4. Select the first pair of rolls which are marked "T-1" and "B-1" and place them in the shaft at the entrance end of the machine. Place the "T-1" roll on the upper shaft and the "B-1" roll on the

- lower. Repeat procedure through all roll stations.
5. After the rolls are installed, fasten the rolls with retaining screws and washers.
 6. Mount entrance and exit gauges to the stand, using the slotted holes provided in the table top. Set entrance gauges by placing a straight edge along the outer edge of the auxiliary rolls. Measure to the required amounts in from the straight edge to the extreme ends of the entrance gauge.

SUGGESTED PROCEDURE FOR REMOVING FORMING HEAD FROM CABINET

1. Remove the cover, top side plate and grease lines from the machine.
2. Remove the top head by removing the lock nuts and washers on the 3/8" hold down studs.
3. Move the feed gages as to allow access to the 1/2" flat head screws.
4. Support the weight of the bottom head before removing the 1/2" flat head screws.
5. Remove the 1/2" flat head screws, lower the bottom head, remove the belts from the pulley, tilt the head as to allow it to be raised up and out of the cabinet.
6. Lay the head on it's side with the pulley side up. Remove the pulley, bull gear and the auxiliary rolls (if any) and all the 1/2" screws which will allow the removal of the top plate.
7. You will now be able to inspect for broken parts. See parts list and assembly print for ordering information. Please include serial number of machine when ordering parts.
8. For re-assembly, reverse the above procedure, making sure all of the keys are up and in line.

**FOR SAFETY PURPOSES DISCONNECT POWER BEFORE
REMOVING COVERS TO CLEAN OR TO CHANGE ROLLS**

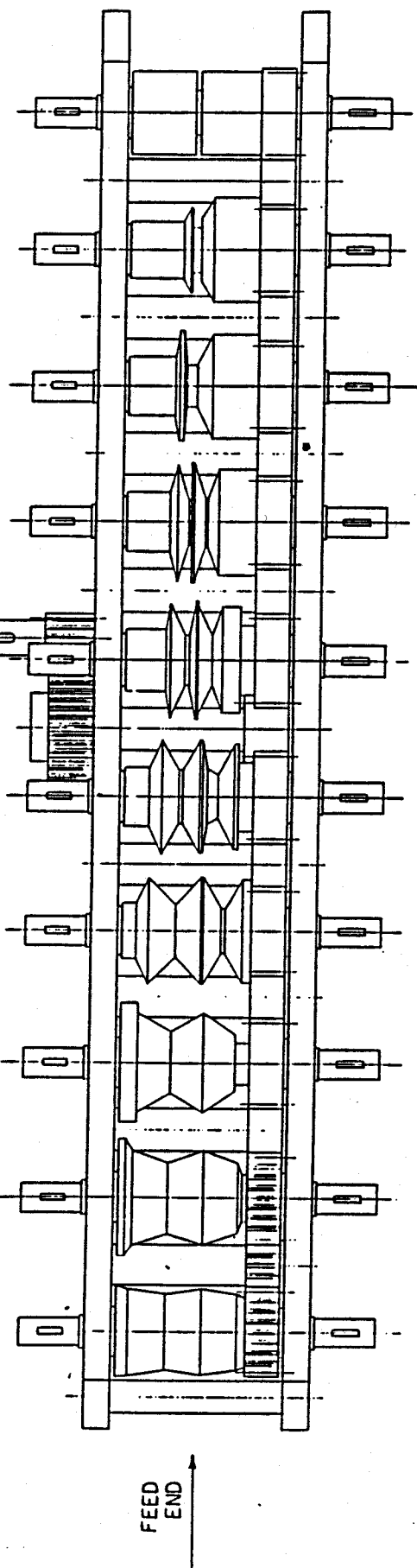
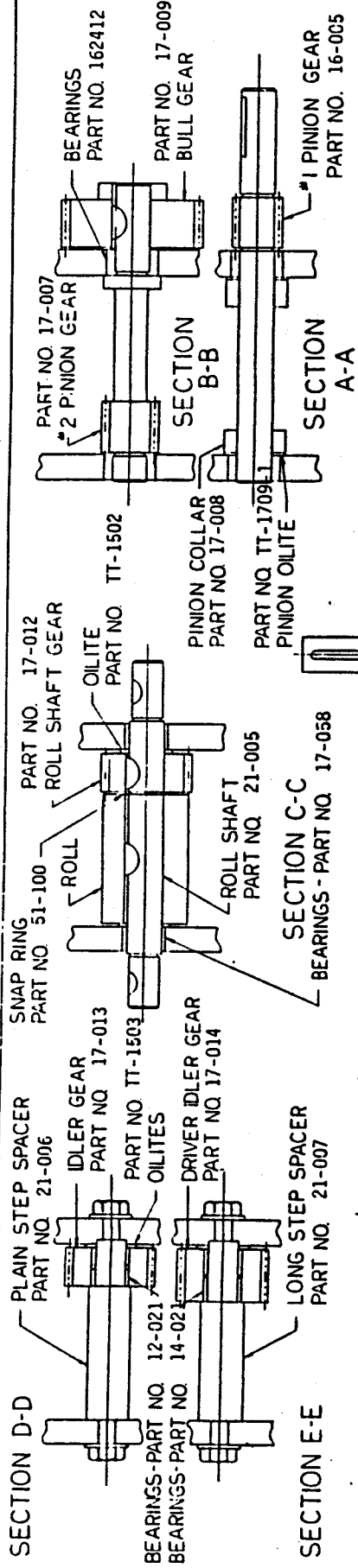
COVERS MUST BE IN PLACE WHEN IN OPERATION

FLAGLER HI-SPEED COMBINATION - "S" CLEAT

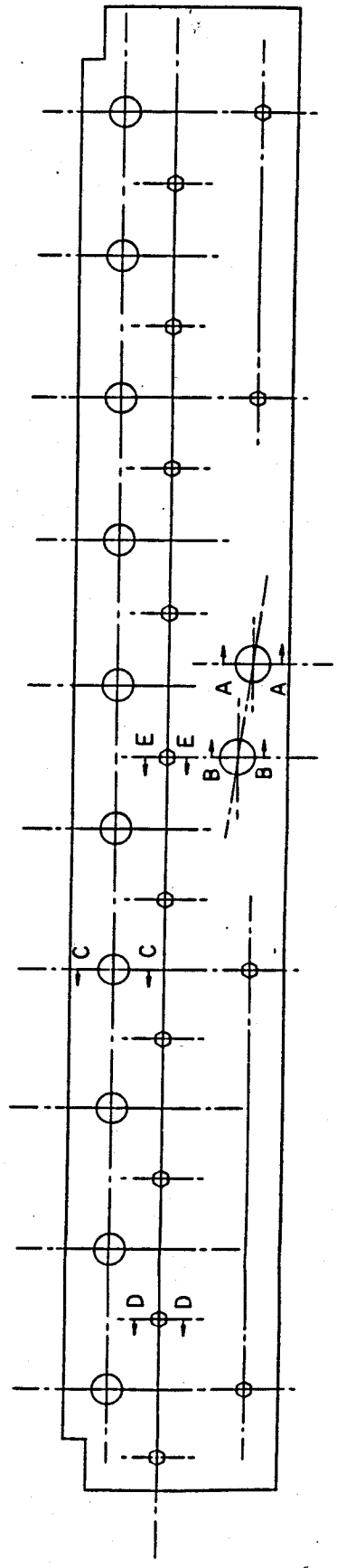
Part no.	Description	Quantity
21-001	Bottom Front Plate	1
21-002	Bottom Back Plate	1
21-003	Top Front Plate	1
21-004	Top Back Plate	1
16-005	#1 Pinion Gear	1
17-007	#3 (or 2) Pinion Gear	1
17-062	Pinion Collar w/Keyway	1
20-040	Collar	2
17-009	Bull Gear	1
20-005	Bearing 162412	4
21-005	Roll Shaft	20
17-012	Roll Shaft Gear	20
17-013	Idler Gear	8
17-014	Driver Idler Gear	1
17-015	Plain Spacer	14
21-006	Plain Step Spacer	8
21-007	Long Step Spacer	1
14-054	Spring Washer # B-0750-040	96
17-058	Bearing 1612	40
12-021	Bearing 148	16
14-021	Bearing 1412	2
16-012	Oilite TT-1709-01	2
17-084	Oilite TT-1502	40
21-032	Oilite TT-1503	9
17-059	Hold Down Stud	8
17-025	Spacer Washers	8
17-031	Grease Bolt	1
21-009	Cover Assembly	1
21-013	--Cabinet Assy.--	1
17-037	Skirt	2
20-021	Upper Side Panel	2
20-022	Louver Panel	2
17-040	Feed Plate	1
21-014	Left Take-Off Plate	1
21-015	Right Take-Off Plate	1
21-016	Center Channel	1
21-017	Side Plate	2
17-063	Feet	2
21-018	Bottom Side Angle	2
14-040	Lag Screw Plate	4
17-050	Motor Support	2
14-048	--Motor Clamp Assembly--	4
14-049	Base	4
14-050	Spacer	4
17-046	Lube Tube; 19" w/14-053	3
14-041	Lube Lines: 12" w/14-053	2

FLAGLER HI-SPEED COMBINATION - "S" CLEAT

Part no.	Description	Quantity
14-053	Lube Line Fittings	10
21-026	Motor (BL-5-184T Ajax)	1
21-030	Starter	1
21-027	Heater	3
20-026	Sheave (Driver)	1
17-053	Sheave (Driven)	1
17-054	Bushing	1
22-036	"V" Belt	2
10-031	Label-Manufacturer	1
10-040	Label-OSHA	1
10-042	Warning Label	1
10-043	Made In USA Label	1
21-019	Riser	2
21-029	Riser	2
21-060	Top 1 "S" Cleat Roll	1
21-061	Top 2 "S" Cleat Roll	1
21-062	Top 3 "S" Cleat Roll	1
21-063	Top 4 "S" Cleat Roll	1
21-064	Top 5 "S" Cleat Roll	1
21-065	Top 6 "S" Cleat Roll	1
21-066	Top 7 "S" Cleat Roll	1
21-067	Top 8 "S" Cleat Roll	1
21-068	Top 9 "S" Cleat Roll	1
21-069	Top 10 "S" Cleat Roll	1
21-070	Bottom 1 "S" Cleat Roll	1
21-071	Bottom 2 "S" Cleat Roll	1
21-072	Bottom 3 "S" Cleat Roll	1
21-073	Bottom 4 "S" Cleat Roll	1
21-074	Bottom 5 "S" Cleat Roll	1
21-075	Bottom 6 "S" Cleat Roll	1
21-076	Bottom 7 "S" Cleat Roll	1
21-077	Bottom 8 "S" Cleat Roll	1
21-078	Bottom 9 "S" Cleat Roll	1
21-079	Bottom 10 "S" Cleat Roll	1
21-020	--Feed Gage Assy.--	1
21-021	Base	1
21-031	Guide Rail	1
21-022	Guide Rail	1
21-023	Hold Down Strap	1
21-024	Angle	1
21-025	Channel Block	1

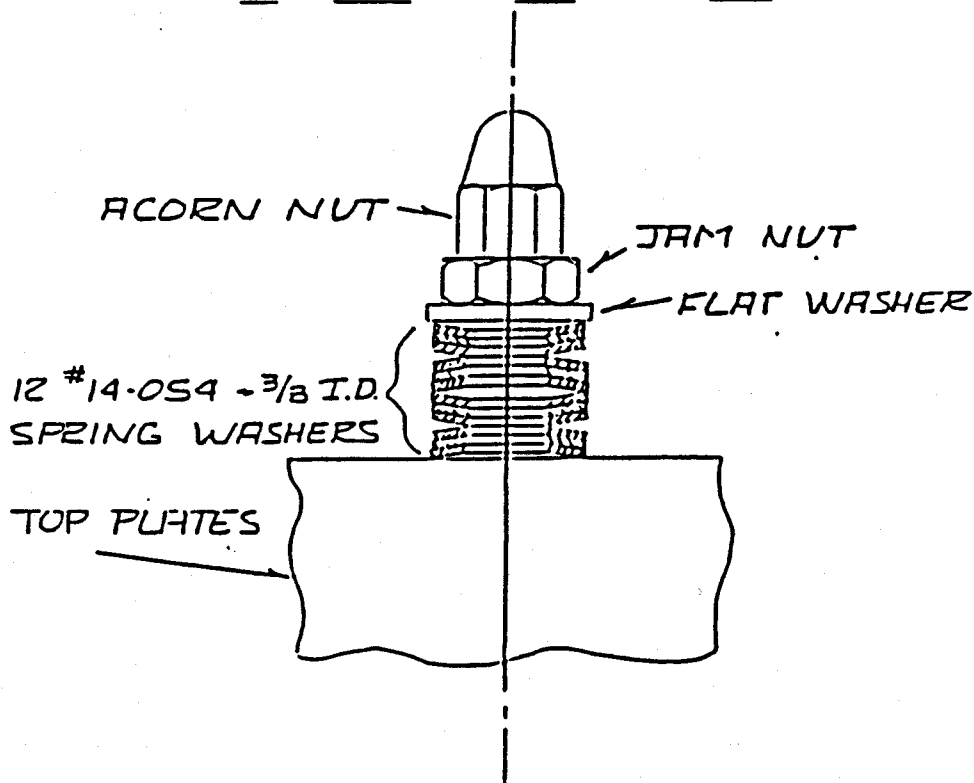


BOTTOM HEAD ASS'Y. FOR REINFORCED "S" CLEAT MACHINE



TEN STATION SPRING WASHER ASSY. INSTRUCTIONS

3/8 HOLD DOWN STUDS



WHEN INSTALLING TIGHTEN JAM NUT
UNTIL SPRING WASHERS ARE FLAT THEN
BACK OFF ONE TURN AND TIGHTEN
ACORN NUT.

TO WORK PROPERLY SPRING WASHERS MUST
BE STACKED AS SHOWN.

Part no.	Description	Size	Qty.
21-200	Top 1 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-201	Top 2 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-202	Top 3 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-203	Top 4 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-204	Top 5 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-205	Top 6 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-206	Top 7 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-207	Top 8 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-208	Top 9 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-209	Top 10 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-210	Bottom 1 Drive Cleat Roll	3.00rd.x2.375 CRS	1
21-211	Bottom 2 Drive Cleat Roll	3.750rd.x2.375 CRS	1
21-212	Bottom 3 Drive Cleat Roll	3.750rd.x2.375 CRS	1
21-213	Bottom 4 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-214	Bottom 5 Drive Cleat Roll	2.500rd.x2.375 CRS	1
21-215	Bottom 6 Drive Cleat Roll	3.750rd.x2.375 CRS	1
21-216	Bottom 7 Drive Cleat Roll	3.750rd.x2.375 CRS	1
21-217	Bottom 8 Drive Cleat Roll	3.00rd.x2.375 CRS	1
21-218	Bottom 9 Drive Cleat Roll	3.00rd.x2.375 CRS	1
21-219	Bottom 10 Drive Cleat Roll	3.00rd.x2.375 CRS	1
21-221	Roll Spacer	1.500rd.x1.000 CRS	20
23-026	Roll Spacer	1.375rd.x.875 CRS	20
14-211	Straightener	16GA.x3.500x9.500	1
21-230	--Feed Gage Assy.--	----	1
21-231	Base	.250x2.875x9.625 HR	1
21-022	Guide Rail	.500x.375x9.500 CRS	2
21-232	Hold Down Strap	.250x.750x2.750 CRS	1