

# flagler

Designers and Manufacturers of Sheet Metal Roll Forming Machinery

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## 16 GA. Power Flanger Operating Instructions and Parts List



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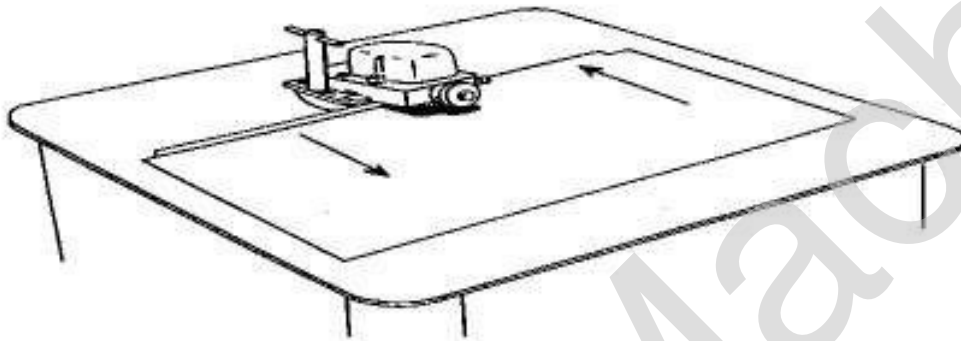
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## Power Flanger Operating Instructions

The adjustment dial on the flanging head must be set to the gauge of material being used. Turn the dial to the right as far as it will go, without forcing. Then, back off until the number of the gauge to be worked with, is opposite the scribed mark.

Turn up a "starting flange" by using the slot cut in the table top( for this purpose). Start the flanger and feed the "starting flange" into the rolls, from the right side. (The metal moves from right to left through the rolls, as you face the machine.)

### Diagram A



Press or push the metal being worked in accordance with the arrows in the diagram above. When the piece of material starts, it is easiest to push the right side of the metal **toward the machine (away from you)**: when the metal is half of the way through, it is easiest to pull the already flanged part, toward you. It will take one or two "practice flanges" before a perfect flange is turned. It is advisable to use waste stock material to test on.

If the flange comes from the rollers in a wrinkled or buckled condition, you are applying too much pressure. If the flange does not come up to full height, or runs off the edge of the material, you need to apply more pressure.

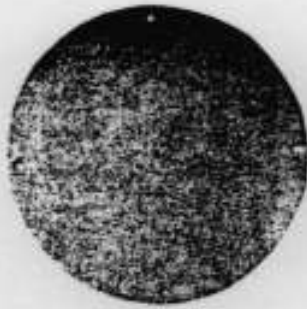
A buckled flange can be corrected by starting the same flange through the rollers a second time, **without applying any pressure**. Simply, start the piece and let it go through.

A low flange can be corrected by running it through the rollers a second time, **applying more pressure**.

## 16 GA Power Flanger Parts List

<u>Part #</u>	<u>Description</u>	<u>Qty.</u>
27-001	Gear Housing	1
27-002	Gasket	1
27-003	Housing Cover - Casting	1
27-004	Forming Head	1
27-005	Dial	1
27-006	Vertical Shaft	1
27-007	Horizontal Shaft	1
27-008	Worm Gear	1
27-009	Worm Gear	1
27-010	15 Tooth Gear	2
10-001	Bearing B - 108	2
11-010	Race IR - 1316	1
27-024	Thrust Bearing # 605 - Nice	1
14-021	Bearing B 1412	2
27-011	Bronze Bushing P 64 - 12	2
27-012	Oil Seal CR - 6229	1
11-012	Guide Roll Holder Assembly	1
11-014	Roll Guide Handle Assembly	1
11-016	Guide Roll Holder Assembly	1
27-025	Gear Cover Assembly	1
27-023	Cabinet Assembly	1
10-031	Label - Manufacturer	1
10-032	Motor	1
10-038	Starter GE 5981 - 8	1
10-040	Label- Osha	1
10-042	Warning Label	1
27-019	Pulley AZ 50	1
27-020	Pulley AZ 30	1
27-021	"V" Belt 4L560	1
27-022	Freezer Plug Dorman P14C	1
14-048	Motor Clamp Assembly	4
27-037	Knurled Roll	1
27-038	Plain Roll	1
27-039	Lifter Button	1

16 GA. POWER FLANGER



27-002



27-003



27-001



27-004



27-019



27-021



27-006



27-008



27-020



27-010



27-007



27-009



14-021



27-005



27-037



11-012



27-038



11-014

27-012



11-010



27-024



11-016



27-011



27-039