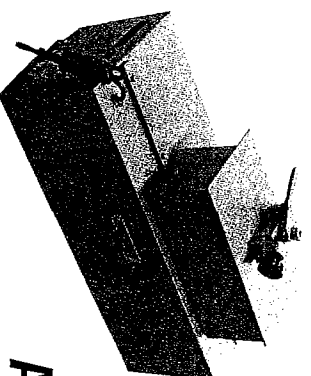
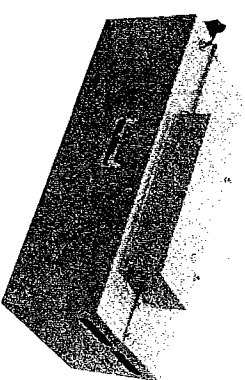


LOCKFORMER

Model 24
Instructions
and
Parts Diagram



AUTO-GUIDE
Flanging Attachment
for
LOCKFORMER Model 24

LOCKFORMER

Where the Machines of Tomorrow are Made TodaySM

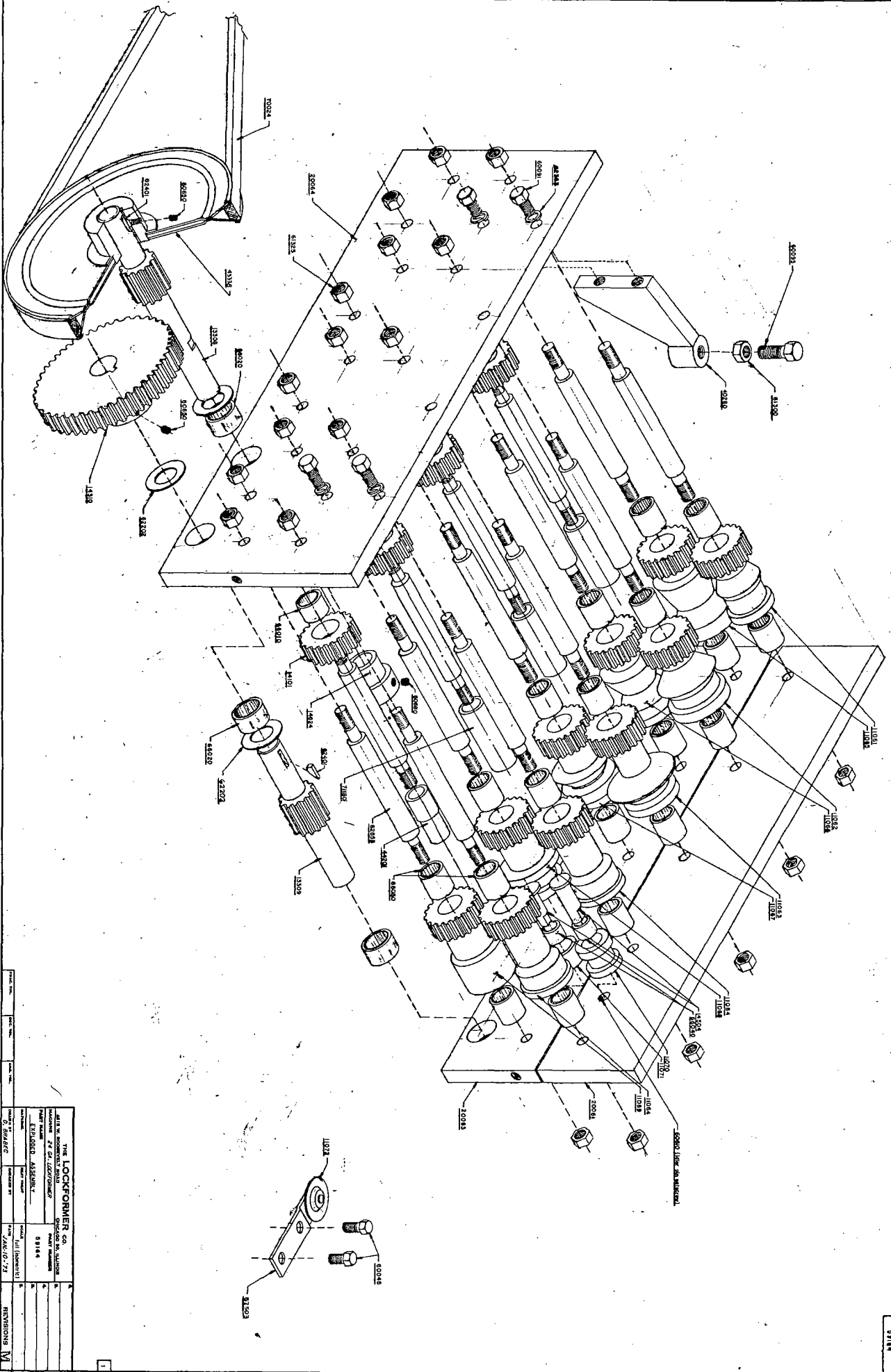
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LOCKFORMER

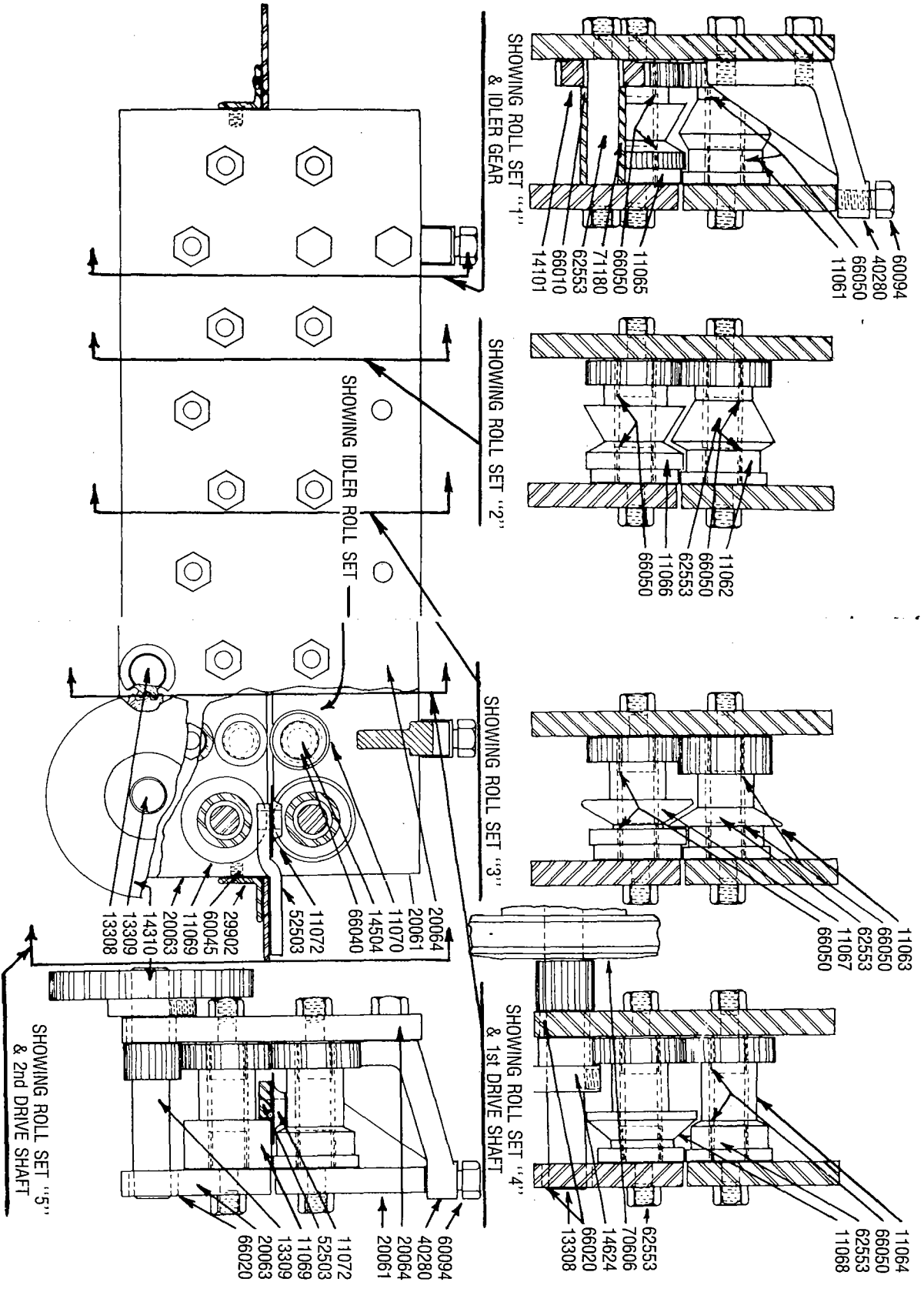
Where the Machines of Tomorrow are Made TodaySM

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THE LOCKFORMER CO.	
1000 W. 10th St., St. Paul, Minn.	
Manufacturers of Lockformers	
PART NAME: EXPLODED ASSEMBLY	
PART NUMBER: 9114	
DATE: JAN. 10, '72	
DRAWN BY: M	
CHECKED BY: M	
APPROVED BY: M	
REVISIONS: M	

24-Gauge Lockformer Assembly



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.

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.

If the material slips, tighten the studs equally until the condition is overcome.

It is very important that long sheets be fed into the machine flat and against the 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.

SPECIFICATIONS

GENERAL: Recess for Pittsburgh Lock Flange is $\frac{3}{16}$ " deep . . . Hammer-over edge adjustable for width . . . Uses about $\frac{1}{8}$ " of material . . . One piece Pittsburgh lock rolls, gears and shafts . . . **FORMING UNIT:** Hardened and ground steel shafts, precision made case hardened steel forming rolls, machine cut gears . . . **CAPACITY:** 24 gauge and lighter . . . **MOTOR:** Standard equipment $\frac{1}{8}$ H.P., 110-220 V., 60 cycle, single phase, A.C., plugs into regular light socket (other types available) . . . **DRIVE:** single V belt . . . **STAND:** arc-welded steel construction finished in blue machinery enamel, heavy top plate . . . **DIMENSIONS:** 30" long, 14" wide, $16\frac{1}{2}$ " high overall including Power Flanger, 12" high without flanger, cabinet height 8" . . . **WEIGHT:** 150 lbs. . . . **ROLLER BEARINGS THROUGHOUT:** Power Flanger makes $\frac{1}{4}$ " Right Angle Flange on either straight or curved pieces to a radius as small as $1\frac{1}{4}$ ". It is fitted with an adjustable guide which can be set to hold metal to the gauge and automatically turn a flange to a given radius or a straight line.

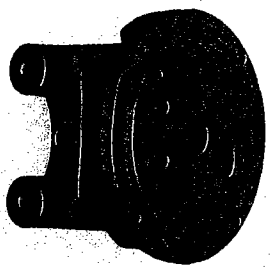
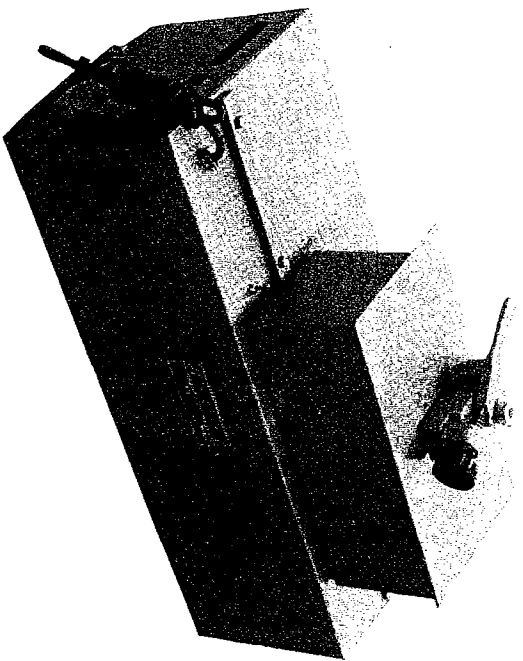
PARTS LIST AND DESCRIPTION

Part Number	Description	Pieces Per Unit	Part Number	Description	Pieces Per Unit
20064	Back Housing Plate	1	62401	#9 Woodruff Key	2
20063	Lower Front Housing Plate	1	11070	Upper Idler Roll (need 1 66040)	1
20061	Upper Front Housing Plate	1	11071	Lower Idler Roll (need 1 66040)	1
21101	Feed Gauge Bar	1	14504	Idler Roll Pin	2
11069	Bottom Forming Roll B5	1	60094	3/8-16 x 1-1/4 HHCS FT	2
11068	Bottom Forming Roll B4	1	60047	5/16-18 x 3/4 HHCS	6
11067	Bottom Forming Roll B3	1	62553	Spacer Stud	14
11066	Bottom Forming Roll B2	1	50013	Stand Assembly	1
11065	Bottom Forming Roll B1	1	80206	Toggle Switch 82070	1
11064	Top Forming Roll T4 & T5	2	39508	Cover Assembly	1
11063	Top Forming Roll T3	1	70608	2 A5 23 5/8 Sheave	1
11062	Top Forming Roll T2	1	60650	5/16-18 x 5/16 SSS	1
11061	Top Forming Roll T1	1	61101	5/16-18 HN Heavy SF	8
13308	1st Drive Shaft w/In-tegral Gear	1	60680	3/8-16 x 3/8 SSS	1
13309	2nd Drive Shaft w/In-tegral Gear	1	60610	1/4-20 x 1/4 SSS	2
14310	Gear Driven with Hub	1	61300	3/8-16 Jam Nut SF	2
70606	Sheave Machine 9-1/8"	1	61325	3/8-24 Lk. Nut	28
52503	Opening Roll Hldr As-sbly/EXIT GUIDE BAR	1	80525	Cord 14.3 x 10 Ft.	1
29902	Machine Support	2	70024	4 L 500 Belt	1
40280	Bracket Cast	2	80010	1/3 HP 1 60 18 56	1
66050	Bearing B1012 Torr	20	80481	BX Connector 1/2	2
66020	Bearing B128 Torr	4	60525	5/16-18 x 3/4 FHMS	4
11072	Opening Roll	1	62362	5/16 Lck. Washer	12
66040	Bearing B812 Torr	2	60795	4-3/16 Drive Screw U Cad	4
66010	Bearing B108 Torr	4	85156	Lf. Cap Name Plate	1
60045	5/16-18 x 1/2 HHCS	6	62202	3/4 x .031 Brs. Washer	4
71180	Spacer	3	60091	3/8-16 x 1 HHCS	4
44201	Spacer Step	1	62009	5/16 x 1/16 St. Washer	8
14624	Thrust Collar	1	62363	3/8 Lock Washer	4
14101	Idler Gear (need 1 66020)	4	80493	Sta.KonConnectorB14250	2
			80607	Insulating Cap	2
			80608	Wire Joint	2
			80703	Toggle Switch Plate	1
			85178	Lockformer Logo	1

Lubrication 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.

AUTO-GUIDE FLANGING ATTACHMENT for LOCKFORMER Model 24



40120

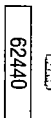
40580



60610



60983



62440

MM

71013



36302



14409



14410



89102



11602



11603



22626



62661



60098



9956563



13006



66050



61161



11601



60094



14102



66010



62363



60501



71014



60652



60610



14921



89103



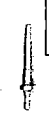
71151



62201



85166



19004



62029



60652



42411



62631



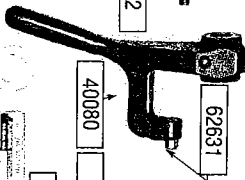
60303



62641



60650



40080

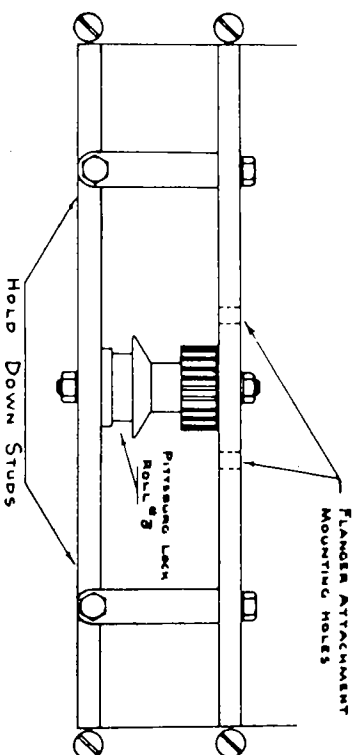
40090

14721

60795

TO INSTALL AUTO-GUIDE POWER FLANGING ATTACHMENT

1. Remove top cover from Lockformer by removing the two hold-down studs and lifting the cover from the machine.
2. Replace the two hold-down studs and adjust.
3. Set the flanging attachment over the forming head so that the combination bevel and spur gear meshes with the Pittsburgh Lock roll No. 3.
4. Place the two 3/8" x 1 1/2" Hex-Head cap screws and lock washers into flanging attachment mounting holes and tighten.



TO OPERATE AUTO-GUIDE POWER FLANGING ATTACHMENT

ADJUST UNIT FOR GAUGE To adjust clearance between flanging **MATERIAL TO BE USED** rolls, tighten the adjusting screw on the front of the block of the machine all the way, then loosen the screw approximately one eighth of a turn. (This setting is usually correct for 26 gauge material.) Do not set front gauge adjusting screw too tight. It should be set just tight enough to draw the metal through the rolls. Too tight a setting will stretch and wrinkle the material.

To adjust the spring tension on the compensator arm, tighten the adjusting dial on the back side of the flanger to the stop and then turn back to the proper gauge setting shown on the adjusting dial.

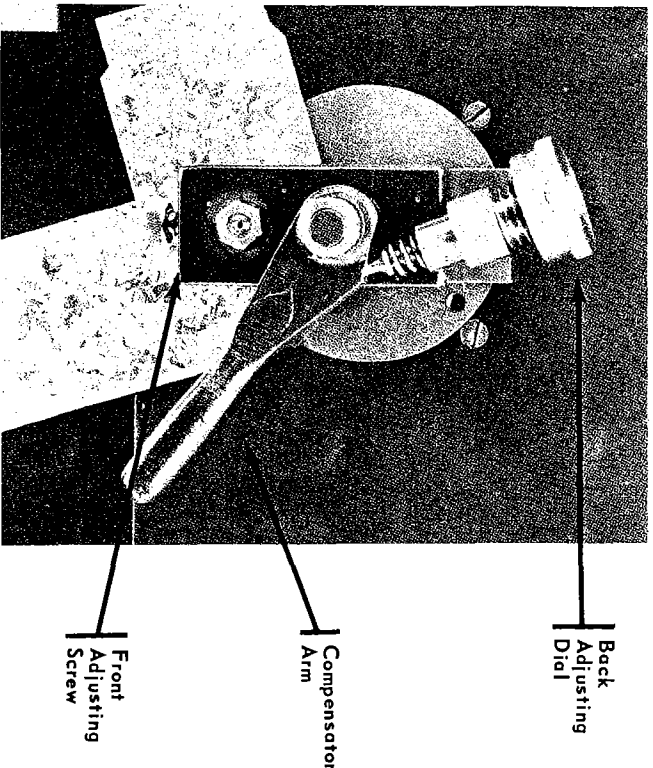
PARTS LIST AND DESCRIPTION

Part Number	Description	Pieces Per Unit	Part Number	Description	Pieces Per Unit
40120	Cast Iron Base	1	62631	Dowel Pin 3/8 x 3/4	1
40580	Steel Forming Head	1	60610	1/4-20 x 1/4 Set Screw	3
62440	Special Machine Key - Concave	1	42411	61 Woodruff Key Modified 62404	1
71013	Compression Spring 3/8 ID	1	40080	Compensator Arm 88080	1
36302	Cover	1	40090	Tension Screw Nut	1
14409	Gear Bevel	1	14721	Gauge Dial	1
14410	Gear Comb. Spur & Bevel	1	14921	Tension Screw	1
89102	Litter Plug	1	19004	Tension Spring Push Rod	1
11602	Knurled Forming Roll	1	62641	7/16 x 1-1/2 Dowel Pin	1
11603	Plain Forming Roll	1	71014	Spring - Compression	1
22626	Spacer Plate	1	89103	Sensory Casting	1
62861	5/8 x 2-1/4 Dowell Pin	1	71151	5/8 Collar	1
60098	3/8-16 x 2 HHCS	2	62201	Washer 5/8 x 1/16	2
9956563	Inner Race Assembly	1	60303	1/4-20 x 3/4 SHCS	1
13006	Roll Shaft	1	85166	Name Plate	1
66050	Bearing B1012	2	60795	4 x 3/16 Drive Screw	2
61161	1/2-20 NF Hex. Nut	1	58526	Forming Table	1
11601	Adjustable Guide Roll	1	60983	3/8-16 x 1 STS	1
60094	3/8-16 x 1-1/4 HHCS	2	62029	3/8 x 1/16 Washer	2
14102	Gear	2	35090	Removable Cover	1
66010	Gearing B108 Torr	4	66164	Bearing	1
62363	3/8 Lock Washer	2			
60501	1/4-20 x 1/2 FHMS	4			
62423	3/16 Sq. x 1-1/2 Key	1			
60652	5/16-18 x 1/2 SSS	3			

TO OPERATE (CONTINUED)

TURN UP A "STARTING FLANGE" on the material before inserting it into the rolls. This is done by inserting the leading edge of the work to be flanged in the slot cut into the table and bending the piece away from the operator approximately 45°. Start the leading edge of the material into the rolls. As the material passes through the rolls, the compensator arm will make contact with the material and guide it through the rolls. If the material pulls out of the rolls, it is an indication that either the front adjusting screw is too loose or the back adjusting dial is not tight enough.

IMPORTANT. When starting a partially formed section that contains an inside curve, push the compensator arm back until it locks out of position. Feed partially formed section into the rolls and the machine will pull the material through. As the rolls approach the section that is not formed, bring the compensator arm to the material holding the spring tension off the piece until the unformed section comes to the rolls; then bear pressure to the piece until the flange picks up, then release compensator arm so that "automatic" guiding is resumed.



NOTES

