

# PEXTO FORMING MACHINES

Forming Machines, or Slip Roll formers, are 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 the front end of the housings.

The capacity ratings of **PEXTO** 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 the 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.

Three inch diameter forming rolls have longitudinal grooves in the rear forming roll to assist in starting the sheet. Forming rolls 3" in diameter and larger have all three rolls driven as standard. Three roll drive for rolls under 3" in diameter at extra cost.

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.

Forming machines are provided with grooves in the right end of the lower and rear rolls to allow for forming cylinders with a wired edge.

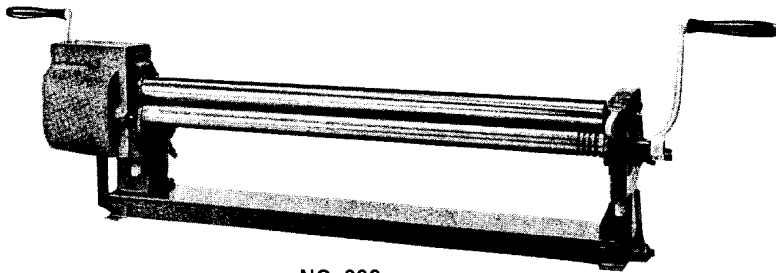
**WARNING:** Before operating, machines **must** be bolted to the work bench. If the floor stand has been provided, machine must be bolted to the floor stand with bolts provided. Stand **must** be securely lagged to the floor.



**ROPER WHITNEY-THE CHOICE OF PROFESSIONALS**

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

# SLIP ROLL FORMERS 390, 391, 392



NO. 392

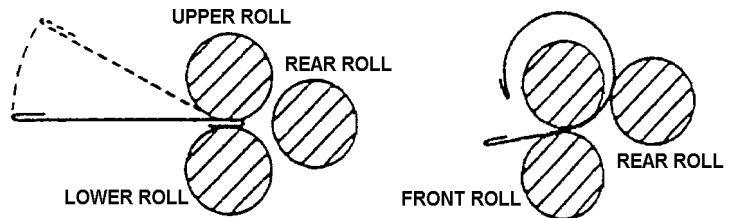
These machines are available in three different sizes. All three models offer the standard front roll drive. These units may be mounted directly to a sturdy work bench or to an optional fabricated pedestal, designed specifically for each unit.

MODEL	390	391	392
Capacity.....ga.	16-18	18-20	20-22
Max Length.....ins.	36	42	48
Roll Diameter.....ins.	2 1/2	2 1/2	2 1/2
Shipping Weight Boxed..lbs.	457	500	540

## INSTRUCTIONS

**CAUTION:** Be sure that the machine is securely bolted onto the pedestal or to the customer supplied bench. Pedestal or work bench should be bolted to the floor.

- Adjust the Lower Roll to grip the metal firmly and evenly but without straining the machine. The Lower Roll is adjusted up or down with the two lower Adjusting Screws (19).
- Adjust the Rear Roll to form the metal up as it travels through the rollers. The Rear Roll is adjusted up or down with the two rear Adjusting Screws (21). Be sure the Rear Roll is parallel with the Lower Roll. If the rolls are not parallel, the formed metal will be conical in shape instead of cylindrical.
- Feed the stock to the rolls only from the front.
- As the front rolls grip the stock, lift the rear end of the metal upward. This will help reduce the flat spot on the leading edge of the sheet and will also cause the leading edge to pass over the rear roll readily.
- The diameter of the formed cylinder is determined by the position of the Rear Roll. To increase the diameter of a cylinder, lower the Rear Roll by turning the two rear Adjusting Screws (21) counter clockwise. To reduce the diameter of a formed cylinder, raise the Rear Roll by turning the two rear Adjusting Screws (21) clockwise. The two rear Adjusting Screws (21) should be turned an equal number of turns in order to keep the Rear Roll parallel with the front gripping rolls.
- To remove a cylindrical piece without distorting it, lift up the Locking Handle (29), raise the Right Hand Housing Cap (28) and turn the Cam Handle (33) down. This raises the outboard end of the Upper Roll and allows the formed cylinder to be slipped off of the Upper Roll.
- The Lower Roll and the Rear Roll have grooves of varying widths in one end. These are for the purpose of accommodating a wired edge when forming a shape or when forming wire into a ring.



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## INTERCHANGEABLE PARTS LIST ---- 390, 391, 392

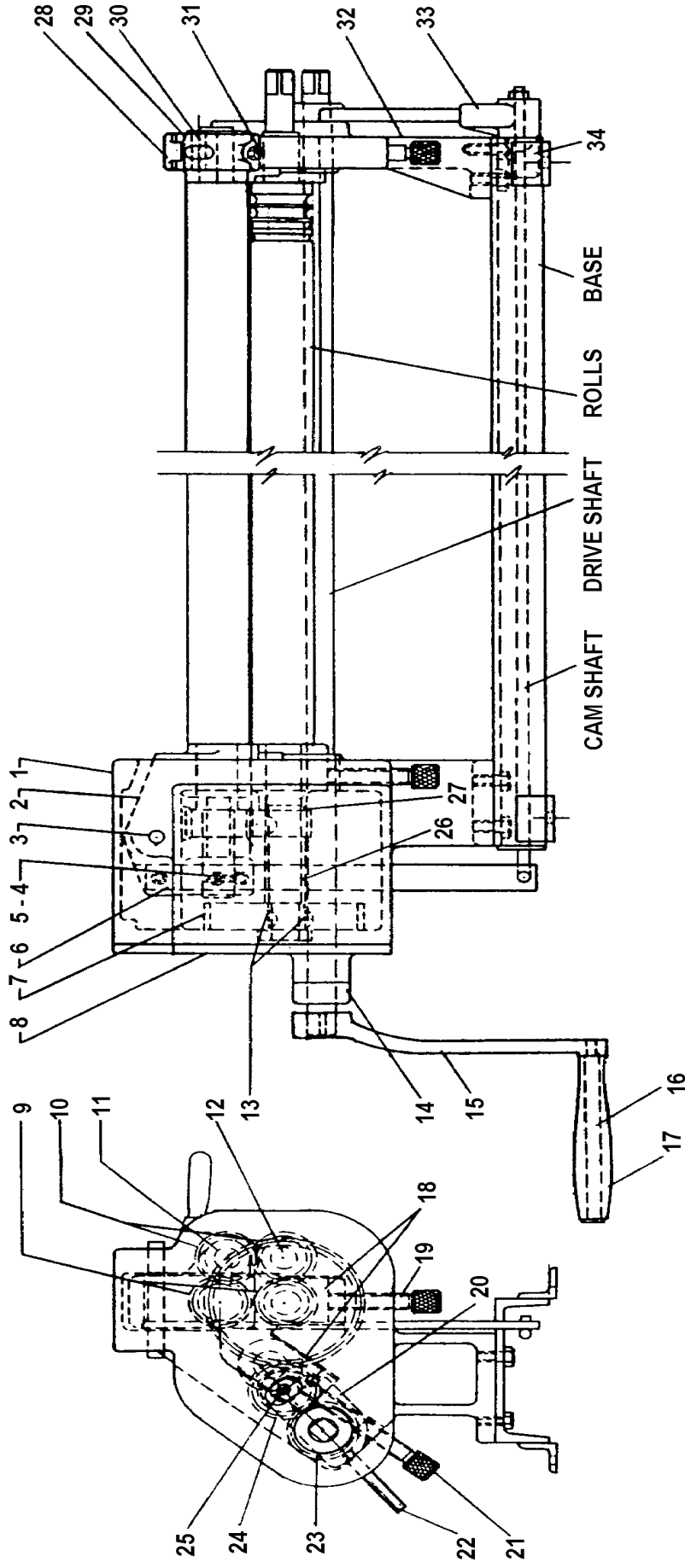
INDEX	CATALOG NO.	NAME	OLD PART NO.
1	267940021	L.H. Housing Assembly	16944
2	767170147	Rocking Box	11492
3	767160166	Pin	16946
4	767650045	Screw	11271
5	767560055	Nut	10155
6	767030162	Lifting Lever	11508
7	767380155	Gear	11500
8	767220146	Cover	16945
9	767380151	Conn. Gears	11496
10	267940022	Compensating Gears	11497
11	767680158	Stud	11503
12	767680159	Stud	11504
13	600123913	#12 Woodruff Keys	
14	767260161	Collars	11506
15	767210150	Hand Crank	11495
16	767210051	Stale	11266
17	767460052	Handle	11267
18	767170148	Roll Boxes	11493
19	767650175	Adj. Screws - Lower	10849
20	767010156	Idler Holder	11501
21	767650149	Adj. Screws - Rear	11494
22	767460160	Handle - Idler Holder	11505
23	767380153	Drive Pinion	11498
24	767380154	Idler Pinion	11499
25	767680157	Idler Pin	11502
26	767630164	Lower Roll Spacer	11513
27	767630165	Lower Roll Spacer	11514
28	267940020	Hinge Cap (Included in R.H. Housing Assy)	11510
29	767460163	Locking Handle	11511
30	767160063	Hinge Pin	11512
31	767650030	Locking Handle Screw	A-5807
32	267940020	R.H. Housing Assembly	11490
33	767210105	Cam and Handle	10848
34	767210104	Cam	10847

### INDIVIDUAL PARTS LIST --- 390, 391, 392

MACH.	ROLLS			DRIVE SHAFT	CAM SHAFT	BASE
	Upper	Lower	Rear			
390	767630139 (11528)	767630135 (11516)	767630137 (11519)	767680129 (11522)	767030094 (10876)	767060131 (11525)
391	(11529)	(11517)	(11520)	(11523)	(10877)	(11526)
392	767630140 (11530)	767630136 (11518)	767630138 (11521)	767680130 (11524)	767030095 (10878)	767060132 (11527)

When ordering Replacement Parts always give Model Number, Letter and Serial Number.

# PARTS IDENTIFICATION CHART - SLIP ROLL FORMERS 390, 391, 392



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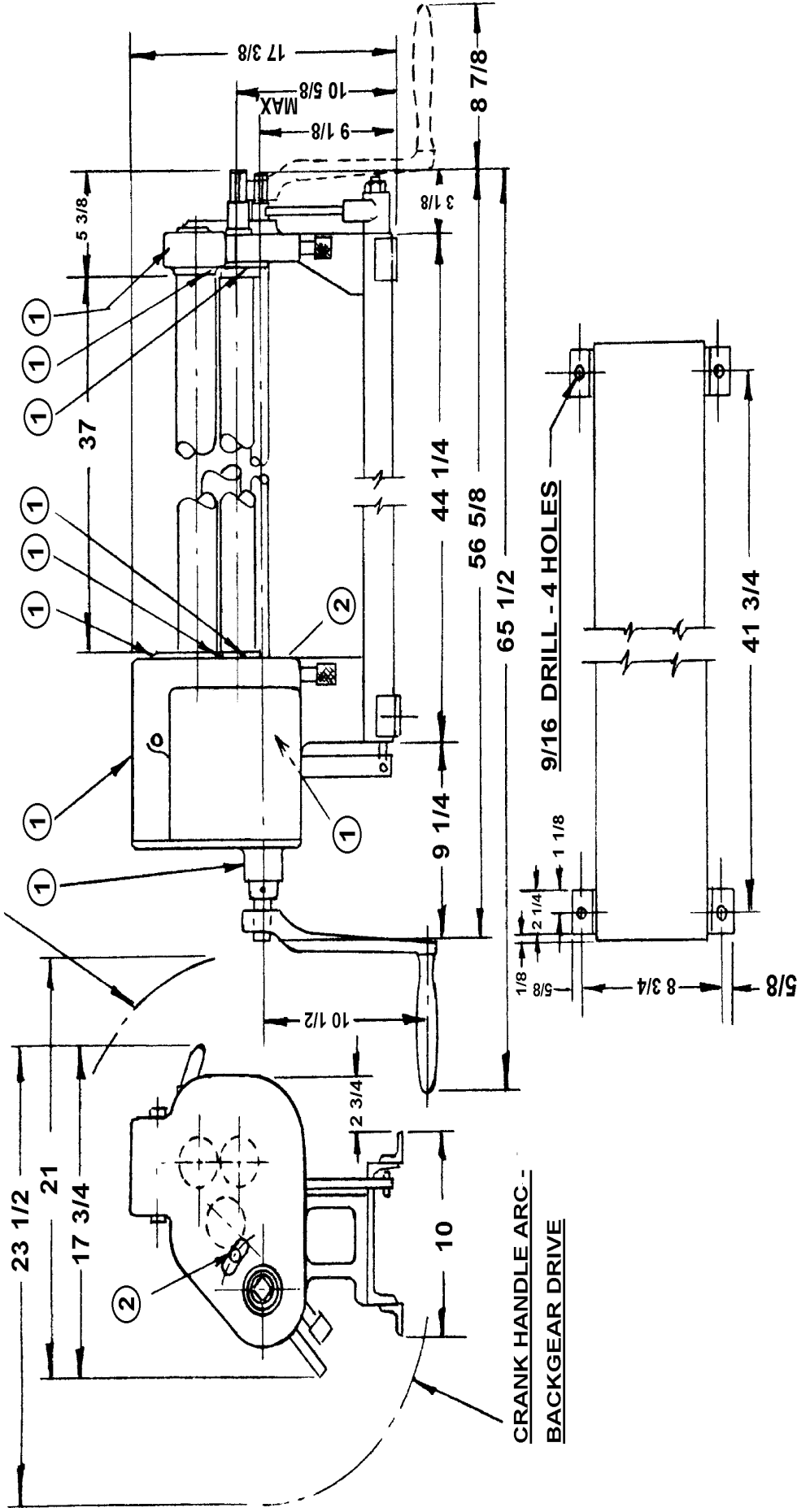


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# FOUNDATION PLAN - 390 FORMER

- NOTE:** ROLL DIA 2 - 1/2"  
CRANK HANDLE ARC - DIRECT DRIVE  
 ① OIL HOLES - USE SAE #30 OIL  
 ② GREASE CUPS - ALEMITE #33 OR EQUAL



WEIGHT - 405 LBS.