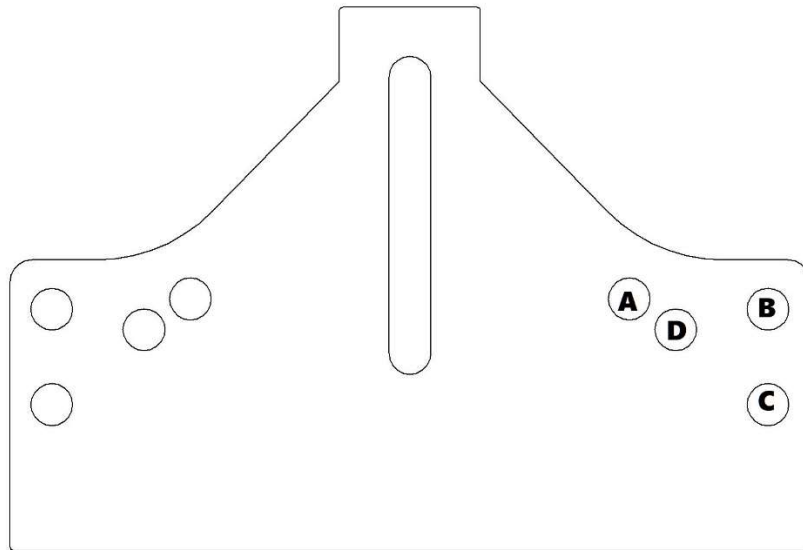


Adjustable Position Guide  
for 4" diameter rollers



A – Materials 1/8" thick or thinner, rolling to diameters of 8-14 inches

B – 12 gauge (.105") – 1/4" thick materials, for large arcs and diameters greater than 36 inches

C – for thick materials such as wood, plastics, or metal tubing. Not recommended for materials thicker than:

1-1/2" square aluminum tube x 1/8" wall thickness

1" square steeltube x 1/8" wall thickness

2" square steel tube x 1/16" wall thickness

D – for materials up to 1/2" thick. Use extreme caution not to overload the roller. You can not roll 1/2" thick steel plate. You can bend 1/2" x 2" hot rolled steel bar stock (or smaller pieces) if you are very careful.

Notes: Side rollers must both be in the same position, so that the unit is symmetrical. Never use an impact wrench. Tighten side rollers to 30-40 ft-lbs. excessive tightening will make repositioning more difficult.