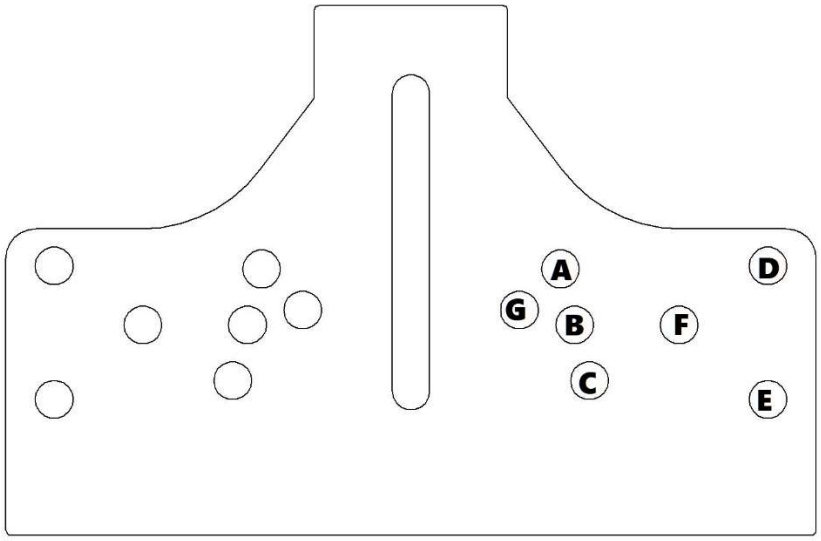
Adjustable Position Guide

for 2” diameter rollers



A – Materials 14 gauge (.075”) thick or thinner, rolling to diameters of 3-8 inches

B – The best starting position for new users doing materials less than 1/8” thick, if the end diameter needs to be 3-15”. This position can be used for 3/16” thick x 1” wide metal bar stock, if you need diameters 3-8”

C – A rarely used position. Can roll 1/4” thick metal into small diameters. Be careful not to overload the roller.

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

E – for making gentle arcs on thick materials such as wood, plastics, or metal tubing. Your maximum sagitta will depend of the strength of your material. 12” on a 6 foot piece is reasonable. Not recommended for materials thicker than:

1” square aluminum tube x 1/8” wall thickness

1” square steel tube x 1/16” wall thickness

F – The best starting position for new users, doing arcs, diameters 24” or larger. Can be used for materials up to 1/4” thick. Use extreme caution not to overload the roller. You cannot roll 1/4” thick steel plate. You can bend 1/4” x 2” hot rolled steel bar stock (or smaller pieces) if you are very careful.

G – Same as A, except it creates less unrolled flat on the end of the sheet.

Notes: Side rollers must both be in the same position, so that the unit is symmetrical. Never use an impact wrench or ratchet extension. Tighten side rollers to 20-30 ft-lbs. excessive tightening will make repositioning more difficult.