

Eastwood

DO THE JOB RIGHT.

Item #14041

12" SLIP ROLL INSTRUCTIONS



This Eastwood 12" Slip Roll was designed for use on sheet metal and wire to create bends, cones, and cylinders. This tool can help you recreate a variety of parts including rocker panels, and any other piece of sheet metal requiring a rolled bend.

WARNINGS

- Read this entire instruction manual before proceeding to use this tool.
- Serious personal injury could result from the use of this tool if basic shop safety is not used while operating it.
- Always wear eye and skin protection when working with sheet metal as it may have sharp edges.
- Make sure that the tool is securely fastened to a work bench as described in this instruction manual.
- Never put fingers or any other body parts in the rotational parts of this tool. Do not force the tool; if it does not seem to be working right, it is most likely being used improperly.
- Keep loose clothing and/or hair away from the rotating parts of this tool.

SPECIFICATIONS

Maximum Roll Length	12"
Minimum Roll Diameter	1"
Maximum Thickness (Steel)	20 Gauge
Maximum Thickness (Aluminum)	17 Gauge
Wire Forming Sizes	5/64", 1/8", 5/32"
Weight	35lbs
Overall Dimensions	23" x 6-3/4" x 9-1/2"

SET UP

ASSEMBLY

To assemble the Slip Roll, simply slide the included handle over the 1/2" square shaft and tighten the set screw using a 3mm hex key.

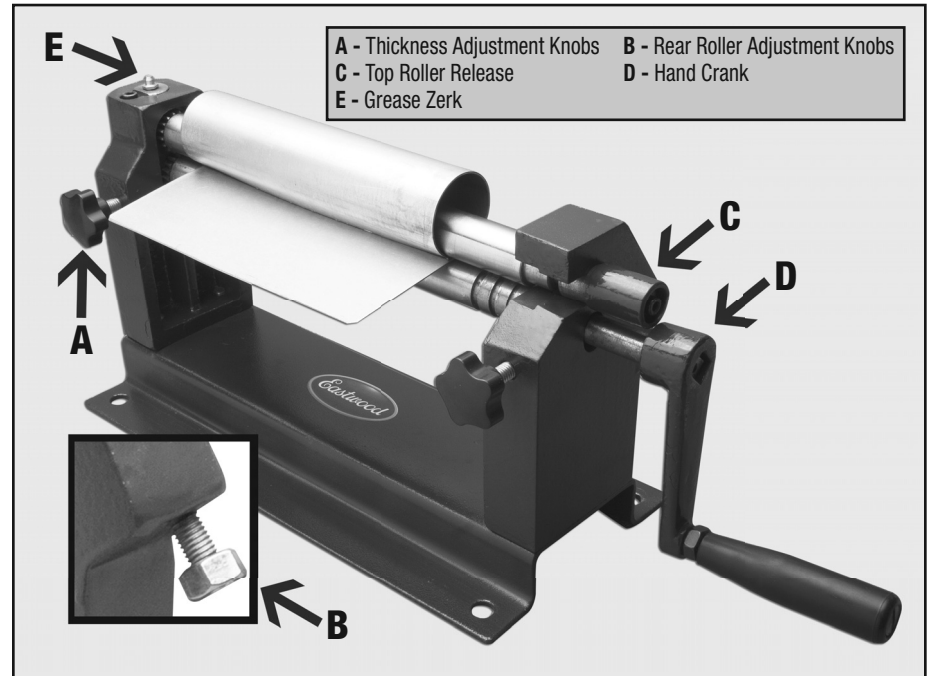
MOUNTING

It is necessary to mount the slip roll to a work bench to secure the tool in place while forming pieces. To mount the slip roll follow the instructions below:

1. Locate a place on your work bench which has enough room for the slip roll tool itself as well as the maximum size work piece you will be forming.
2. Place the slip roll on your work bench with the handle on your right hand side.
3. Mark the four bolt holes onto your table and drill 11/32" holes into the work bench.
4. Fasten the slip roll to the work bench using (4) 5/16" bolts, nuts, and washers. Use a washer on top of the slip roller base as well as on the bottom of the work bench to prevent the bolts from pulling through the bench.
5. Tighten the nuts and bolts until the slip roll is secure on your work bench.

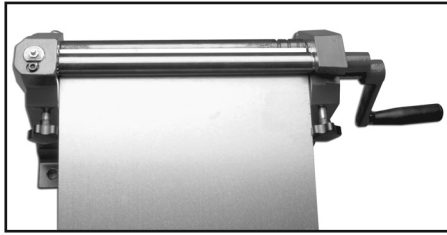
OPERATION

COMPONENTS



CREATING ARC SHAPES IN SHEET METAL

The Eastwood Slip Roll is a great metal working tool that will expand your metal working possibilities. Before making an actual piece for your project, acquire additional pieces of the same size and thickness to practice on and to dial in the desired radius. It is not possible to preset the Slip Roll to a pre determined radius so it will require some trial and error to get the correct radius. The more often you use the Slip Roll, the more familiar you will get with the adjustments to make a specific radius.



1. Turn the Thickness Adjustment Knobs (A) and assure that the top and bottom rollers are parallel.
2. Adjust the Rear Roller Knobs (B) so that the roller is all the way down.
3. Place the piece of sheet metal you will be bending between the top and bottom front rollers and tighten the Thickness

Adjustment Knobs (A) until it is pinching the piece of sheet metal. Make sure when making this adjustment that both sides of the roller are tightened the same amount so that the same amount of pressure is being exerted across the entire length of the piece and the rollers are parallel.

4. Rotate the Hand Crank (D) clockwise (away from you) to begin feeding the piece into the rollers until the piece is directly above the rear roller.
5. Adjust the Rear Roller Knobs (B) to set the radius of the piece. The more this roller is raised, the smaller the radius of the part will be. Be sure to adjust the knobs equally on both sides to avoid making a conical shape.
6. Rotate the Hand Crank (D) clockwise (away from you) to form the piece. Continue rotating the hand crank until the entire pieces exits the rollers.

CREATING CYLINDERS IN SHEET METAL

The Eastwood Slip Roll can not only create bends but can also be used to form cylinders.

1. Determine the diameter of the cylinder you want to form and calculate the circumference by using the formula below:

$$\text{Circumference} = 3.14 \times \text{Diameter}$$

2. The circumference is the length of your piece. With a determined length you can cut your piece to size.
3. Turn the Thickness Adjustment Knobs (A) and assure that the top and bottom rolls are parallel.
4. Adjust the Rear Roller Knobs (B) so that the roll is all the way down.
5. Place the piece of sheet metal you will be bending between the top and bottom front rolls and tighten the Thickness Adjustment Knob (A) until it is pinching the piece of sheet metal. Make sure when making this adjustment that both sides of the roll are tightened the same amount so that the same amount of pressure is being exerted across the entire length of the piece.
6. Rotate the Hand Crank (D) clockwise (away from you) to begin feeding the piece into the rolls until the piece is near half way over the rear roll.
7. Adjust the Rear Roll Knobs (B) to set the diameter of the piece. The more this roll is raised, the smaller the diameter of the part will be. Be sure to adjust the knobs equally on both sides to avoid making a conical shape. It is better to make the initial forming too large of a diameter rather than too small as a diameter that is formed too large can be reformed to a smaller diameter. If the diameter is made too small initially, it cannot be reformed and must be scrapped.
8. Rotate the Hand Crank (D) until the entire piece has passed over the rolls. At this point you will have formed a half of a cylinder.
9. Remove the piece from the slip roll and rotate the piece around to form the opposite end of the piece.
10. Rotate the Hand Crank (D) until the entire piece has passed over the rolls. At the point you will have formed a complete cylinder. If the piece is not a complete cylinder and the ends do not touch, raise the rear roll slightly at both ends equally and rotate the Hand Crank (D) until the entire piece has been rolled again. Continue making tightening adjustments to the rear roll if necessary to get the ends of the cylinder to come together to form a complete cylinder.

Once the cylinder has been formed, you will need to remove it from the top following the below instructions:

1. Loosen both Thickness Adjustment Knobs (A) equally.
2. Slide the Top Roller Release (C) mount away from the slip roll to remove it from the base.
3. Lift the top roll out of the base on an angle but do not try and remove the roll. Simply slide the work piece off the top roll.
4. Replace the top roller back into the base and reinstall the Top Roller Release (C).

CREATING CONES IN SHEET METAL

When fabricating sheet metal bends, sometimes the need for a cone shaped bend will arise. The Eastwood Slip Roll can also achieve this type of bend.

1. Turn the Thickness Adjustment Knobs (A) to lower the front lower roller and measure using calipers to make sure that the top and bottom rollers are parallel.
2. Adjust the Rear Roller Knobs (B) so that the roller is all the way down.
3. Place the piece of sheet metal you will be bending between the top and bottom front rollers and tighten the Thickness Adjustment Knob (A) until it is pinching the piece of sheet metal. Make sure when making this adjustment that both sides of the roller are tightened the same amount so that the same amount of pressure is being exerted across the entire length of the piece.
4. Rotate the Hand Crank (D) clockwise (away from you) to begin feeding the piece into the rollers until the piece is directly above the rear roller.
5. Adjust the Rear Roller Knobs (B) to set the radius of the piece. The more this roller is raised, the smaller the radius of the part will be. This step is where the cone form is determined. Through trial and error with scrap pieces, adjust the Thickness Adjustment Knobs (B) in different amounts to adjust the smaller and larger diameter ends of the piece. The tighter the rear roller is against the piece, the smaller the radius will be. The looser the rear roller is against the piece, the larger the radius will be. Adjust each of the rear roller adjustment knobs so that each end has its set radius.
6. Rotate the Hand Crank (D) clockwise (away from you) to form the piece. Continue rotating the Hand Crank (D) until the entire pieces exits the rollers.

WIRE FORMING

You will notice that your Eastwood Slip Roll has 3 grooves in the rollers. These are for forming solid wire into bends. The three sizes of wire that this tool can be used to form are 5/64", 1/8", and 5/32".

1. Turn the Thickness Adjustment Knobs (A) to lower the front lower roller and measure using calipers to make sure that the top and bottom rollers are parallel.
2. Adjust the Rear Roller Knobs (B) so that the roller is all the way down.
3. Place the piece of wire you will be forming between the top and bottom front rollers and tighten the Thickness Adjustment Knobs (A) until it is pinching the piece of wire. Make sure when making this adjustment that both sides of the roller are tightened the same amount.
4. Rotate the Hand Crank (D) clockwise (away from you) to begin feeding the piece into the rollers until the end of the wire is directly above the rear roller.
5. Adjust the Rear Roller Knobs (B) to set the radius of the piece. The more this roller is raised, the smaller the radius of the part will be. Be sure to adjust the knobs equally on both sides.
6. Rotate the Hand Crank (D) clockwise (away from you) to form the piece. Continue rotating the Hand Crank (D) until the entire pieces exits the rollers.

MAINTENANCE

The maintenance on the Eastwood Slip Roll is minimal but the required maintenance is important to a long life of the tool.

1. Clean the all 3 of the rollers regularly with lacquer thinner or Eastwood's PRE (10041 Z) to remove dirt or other debris.
2. Grease the drive gears via the Grease Zerk (E) located on the top left hand side. Use a wheel bearing or similar grease.

ACCESSORIES

For accessories visit Eastwood.com >> **KEYWORD:14041**

- 28187 - Bead roller with 6 mandrel sets**
- 51088 - DIY Shrinker/Stretch complete set**
- 13475 - Eastwood Electric Metal Shears**
- 11797 - Throatless Shear**
- 14042 - Versa Bend Sheet Metal Brake**

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department:

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