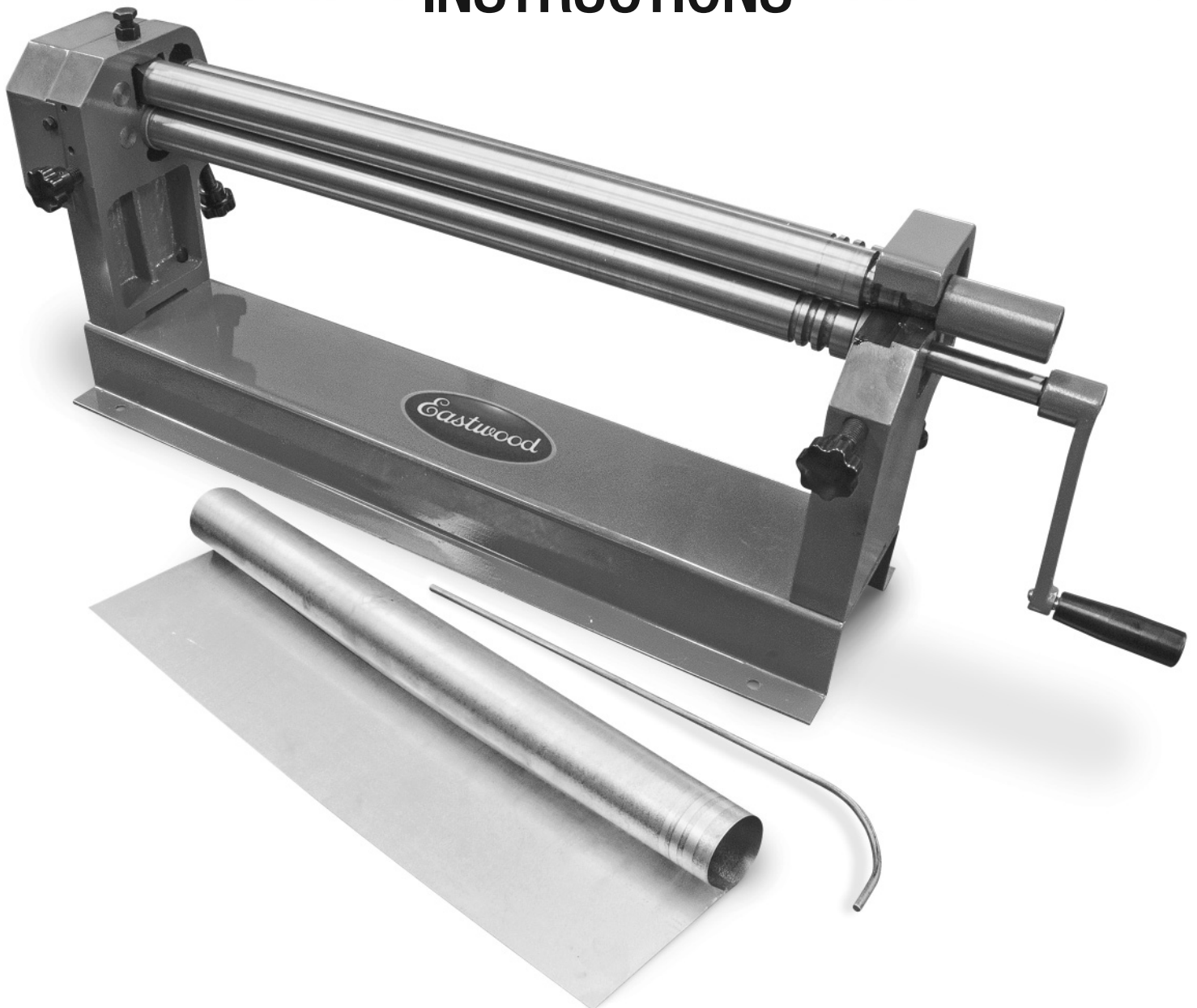


Eastwood

DO THE JOB RIGHT.

Item #20254

24" SLIP ROLL INSTRUCTIONS



The **Eastwood 24" Slip Roll** is a professional metal fabricators tool which is indispensable for producing accurate bends, cylinders and conical shapes for virtually all metal working projects. In addition, the Upper and Rear Rollers feature grooves in 3 popular sizes for forming curves in Wire and Tubing. The gear-driven, design delivers maximum forming power with minimal handle force.

INCLUDES

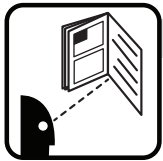
- (1) 24" Slip Roll
- (1) Crank Handle
- (2) Thickness Adjustment Pins



SPECIFICATIONS

Maximum Material Working Thickness	Steel: 18 Gauge
	Aluminum: 16 Gauge
Roller Diameter	1.5" [38mm]
Minimum Forming Radius	(22 Gauge Steel): 1.5" [38mm]
Wire & Tubing Forming Sizes	3/16", 1/4", 5/16" [4.7mm, 6.3mm, 7.9mm]

SAFETY INFORMATION



READ INSTRUCTIONS!

Thoroughly read and understand this instruction manual before using the Slip Roll.



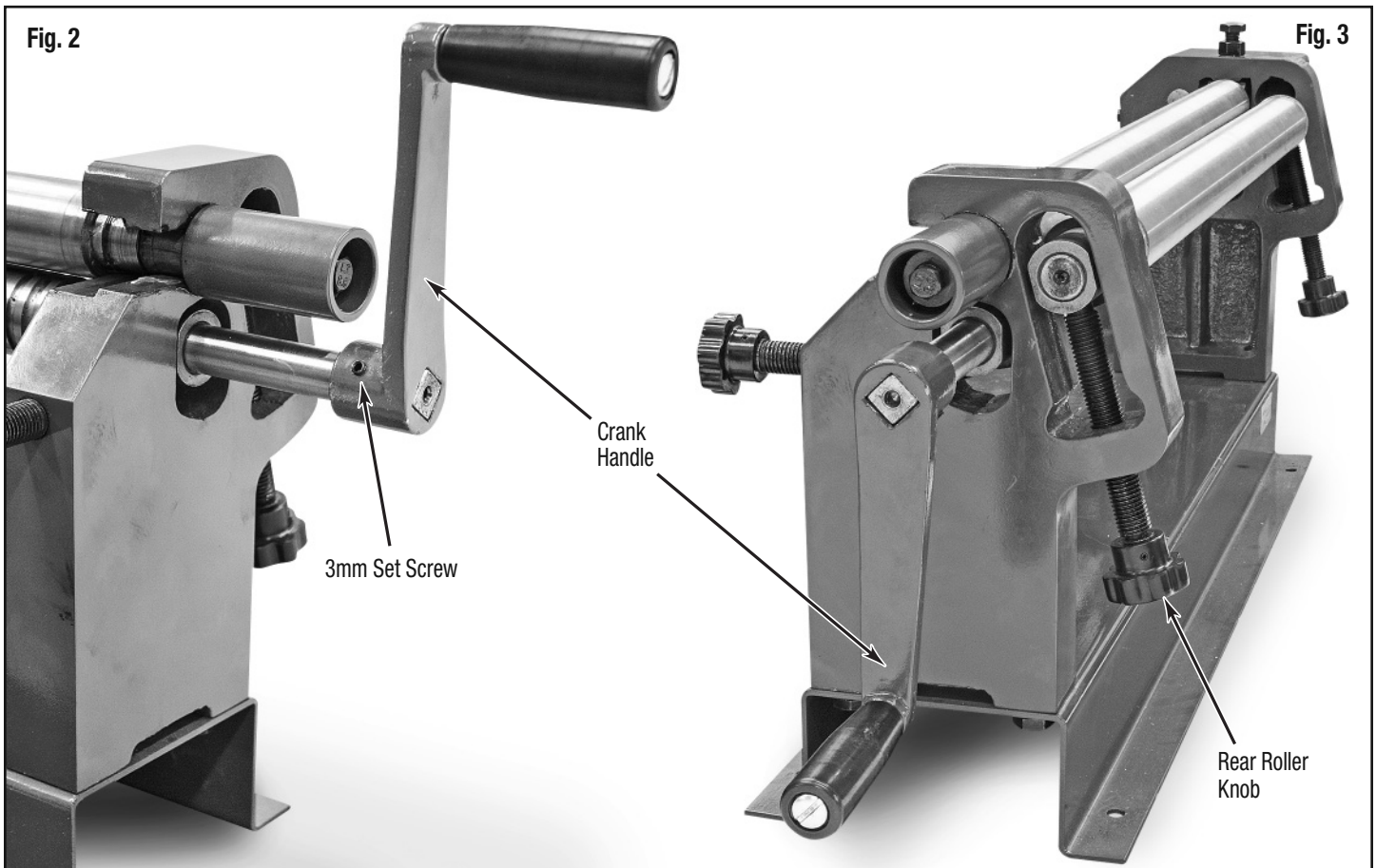
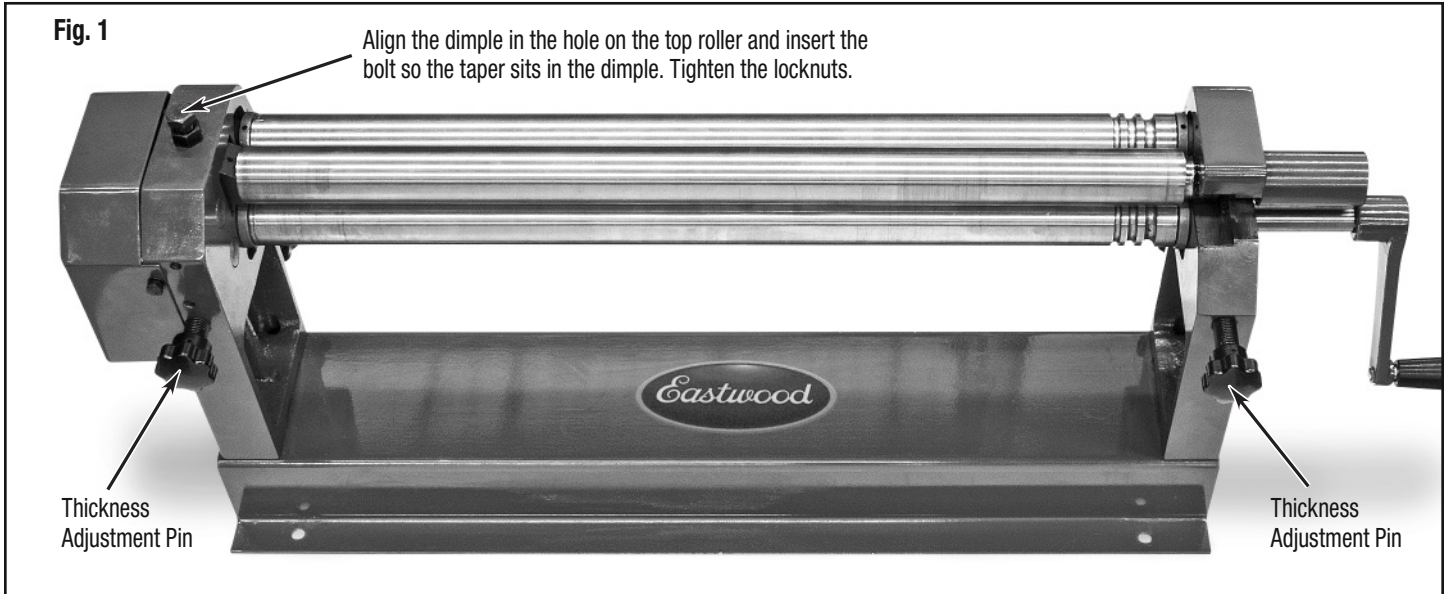
INJURY HAZARD!

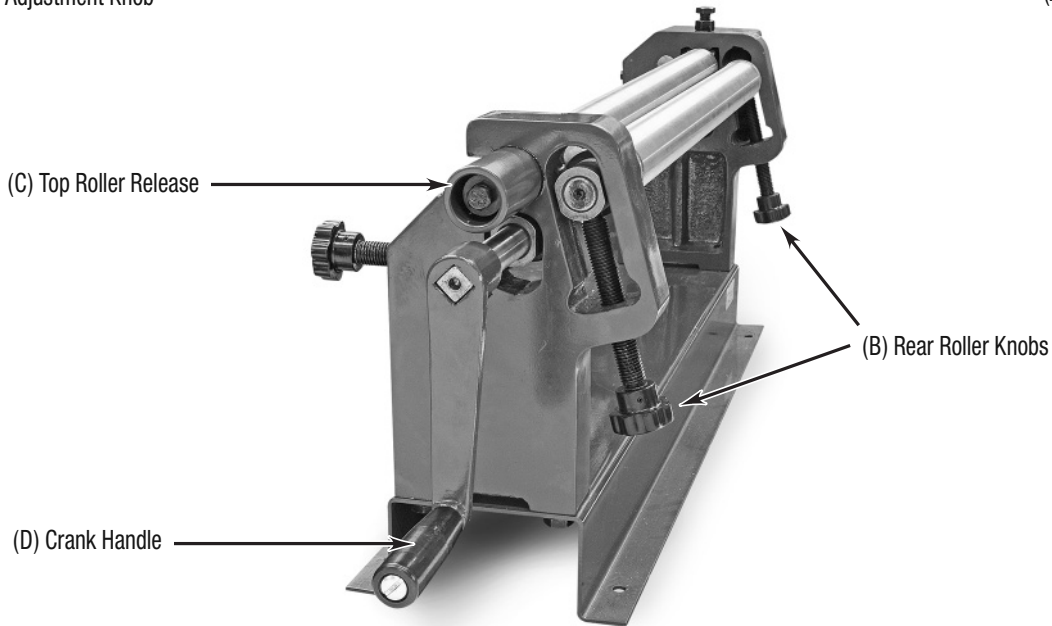
- **WARNING! This tool has rotating rollers and gears with amplified leverage which can quickly cause severe injury!** Keep fingers and hands away from moving parts when operating.
- Wear thick, well-fitting gloves to prevent cuts from handling sharp metal.
- Frequently inspect moving parts and structure of roller. If damage is observed, discontinue use immediately.
- Make sure the roller is securely fastened to a solid work surface before use.
- Always wear eye and skin protection when working with sheet metal as it may have sharp edges.
- Keep loose clothing and/or hair away from the rotating parts of this tool.



SET UP

- Place the Slip Roller on a clean, stable, level surface at a comfortable working height. Mount securely to the work surface using 4 suitable 5/16" [8mm] lag screws or bolts (not included) through the four 21/64" [8.3mm] diameter holes in the base.
- Install the two Thickness Adjustment Pins by threading them into the locations in the upper front faces of the Roller Side Frames (**Fig 1**).
- Slip the square broached hole in the Crank Handle over the square drive end of the Lower Front Roller and tighten set screw with a 3mm hex key (not included) (**Fig 2**).
- Install the two Rear Roller Knobs by threading them onto the locations in the rear of the slip roller (**Fig 3**).





OPERATION

CREATING CURVED SHAPES

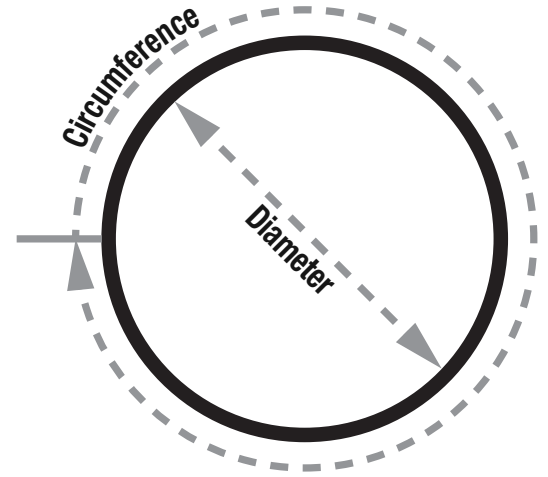
The Eastwood Slip Roll is a great metal working tool that will expand your metal working possibilities. Before making an actual piece for your project, work with some scrap pieces of the same size and thickness to practice on and to dial in the desired radius. It is not possible to preset the Slip Roll 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 required to make a specific radius. To begin:

- Turn the Thickness Adjustment Knobs **(A)** in/out as required to be sure that the Top and Bottom Rollers are parallel. The use of calipers to check the gap side to side between the Rollers is strongly recommended.
- Adjust the Rear Roller Knobs **(B)** (Counter-Clockwise) so that the Rear Roller is all the way down.
- Place the piece of sheet metal you will be bending between the Top and Bottom front rollers and gradually turn in (Clockwise) the Thickness Adjustment Knobs **(A)** until the Lower Roller is exerting pressure on the piece of sheet metal. Important Note: Be sure when making this adjustment that both sides of the Lower Roller are raised equally so that the same amount of pressure is being exerted across the entire length of the piece and the Upper and Lower Rollers are completely parallel.
- Rotate the Hand Crank **(D)** (Clockwise as viewed from the right side) to begin feeding the metal into the rollers until the piece is directly above the Rear Roller.
- 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.
- Rotate the Hand Crank **(D)** (Clockwise as viewed from the right side) to form the piece. Continue rotating the hand crank until the entire piece exits the rollers. Note: If a tighter radius is desired, the piece may be re-run through the rollers with the Rear Roller raised as needed.

CREATING CYLINDERS

The Eastwood Slip Roll can not only create bends but can also be used to form cylinders. Determine the diameter of the cylinder you want to form and calculate the circumference by using the formula below:

Circumference = 3.14 X Diameter



- Turn the Thickness Adjustment Knobs **(A)** in/out as required to be sure that the top and bottom rollers are parallel.
- Adjust the Rear Roller Knobs **(B)** (Counter-Clockwise) so that the Rear Roller is all the way down.
- Place the piece of sheet metal you will be bending between the Top and Bottom front rollers and gradually turn in (Clockwise) the Thickness Adjustment Knobs **(A)** until the Lower Roller is exerting pressure on the piece of sheet metal. **IMPORTANT NOTE:** Be sure when making this adjustment that both sides of the Lower Roller are raised equally so that the same amount of pressure is being exerted across the entire length of the piece and the Upper and Lower Rollers are completely parallel.
- Rotate the Hand Crank **(D)** (Clockwise as viewed from the right side) to begin feeding the metal into the rollers until the piece is directly above the Rear Roller.
- 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.
- Rotate the Hand Crank **(D)** (Clockwise as viewed from the right side) to begin feeding the piece into the rolls until the piece is near half way over the rear roll.
- 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. **IMPORTANT NOTE:** 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 scraped.
- 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.
- Remove the piece from the slip roll and rotate the piece around to form the opposite end of the piece.
- 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.

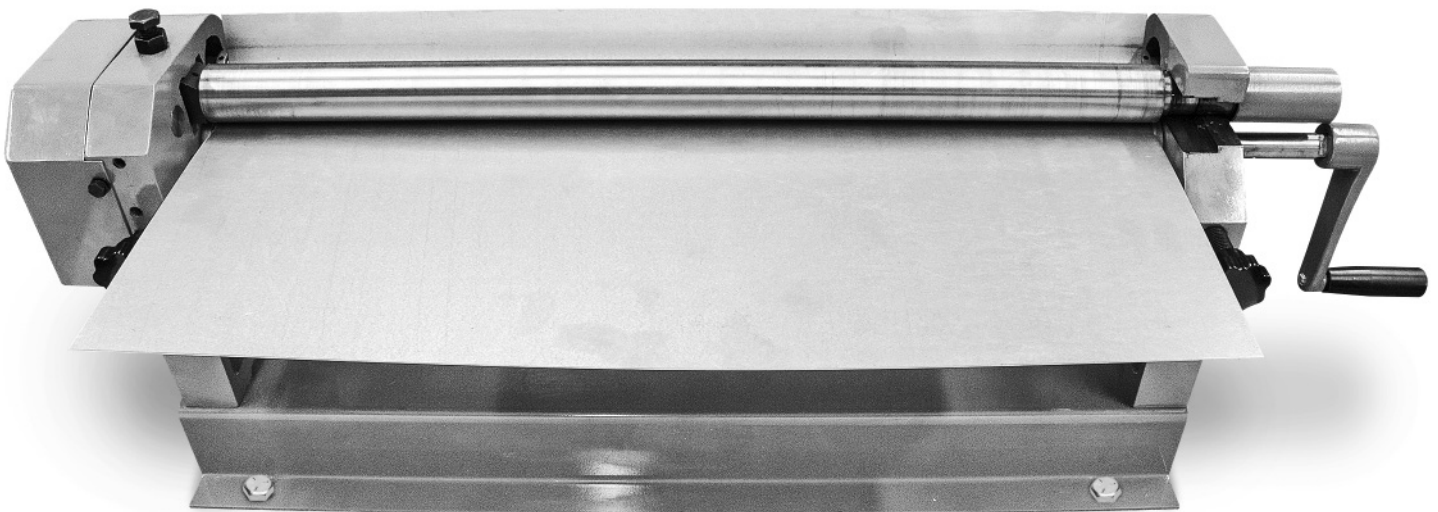
Once the cylinder has been formed, it will need to be removed from the top of the Slip Roller by following the below instructions:

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

CREATING CONICAL SHAPES

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.

- 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.
- Adjust the Rear Roller Knobs **(B)** so that the roller is all the way down.
- 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.
- Rotate the Hand Crank **(D)** (Clockwise as viewed from the right side) to begin feeding the piece into the rollers until the piece is directly above the rear roller.
- 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.
- Rotate the Hand Crank **(D)** (Clockwise as viewed from the right side) to form the piece. Continue rotating the Hand Crank **(D)** until the entire piece exits the rollers.



WIRE & TUBE FORMING

The Eastwood Slip Roll has features 3 grooves in the right end of the rollers. These are for forming bends into solid wire and tubing. The three sizes of wire and tubing that this tool can be used to form are: 3/16", 1/4", 5/16" [4.7mm, 6.3mm, 7.9mm].

- 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.
- Adjust the Rear Roller Knobs **(B)** so that the roller is all the way down.
- 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 exerting pressure on the piece of wire. Make sure when making this adjustment that both sides of the roller are tightened the same amount.
- 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.
- 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.
- Rotate the Hand Crank **(D)** (clockwise as viewed from the right side) to form the piece. Continue rotating the Hand Crank **(D)** until the entire piece exits the rollers.

STORAGE

- Remove Handle.
- Apply a thin film of light oil or rust-preventive to all bare steel areas.
- Store in a clean, dust-free, dry, dampness free area preferably covered with plastic sheeting.

MAINTENANCE

NOTE: Maintenance should be performed before each use.

- Clean dirt and debris from all three Rollers.
- Check tightness of all hardware.
- Check operation for binding. Lubricate pivot points periodically with medium bodied lubricating oil.
- Add grease to the drive gears by removing the metal guard located on the left side frame.

ADDITIONAL METALWORKING ITEMS

#28187 Bead Roller with 6 Mandrel sets
#51088 DIY Shrinker/Stretcher 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: 800.544.5118 >> email: techelp@eastwood.com
PDF version of this manual is available online >> eastwood.com/20254manual

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