

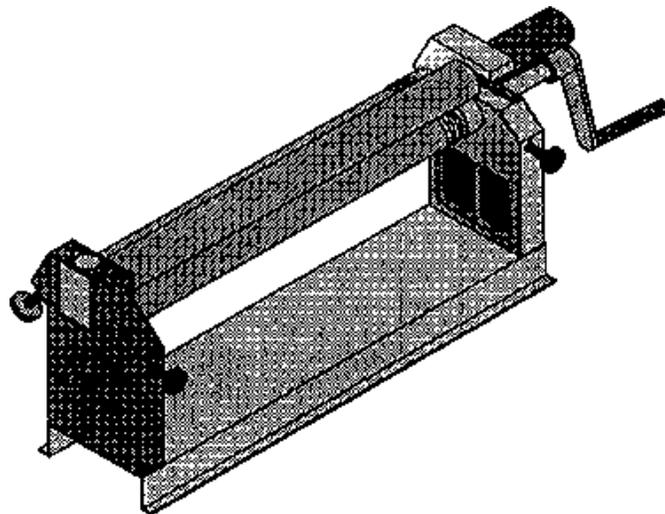
CENTRAL MACHINERY

®

12" SLIP ROLL

Model 36698

Assembly & Operating Instructions



Distributed Exclusively by

®



**HARBOR FREIGHT
TOOLS**



3491 Mission Oaks Blvd. / Camarillo, CA 93011

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For technical questions and replacement parts, please call 1-800-444-3353.

Specifications

ITEM #	36698
Minimum Roll Diameter	1"
Maximum Roll Length	12"
Maximum Thickness (Steel)	20 Gauge
Maximum Thickness (Brass)	18 Gauge
Maximum Thickness (Aluminum)	17 Gauge
Wire Forming Grooves	1/8", 1/4", 3/8"
Weight	37.4 Lbs.
Overall Dimensions	23" x 6.68" x 9.43"

SAVE THIS MANUAL

You will need this manual for the safety instructions, operating instructions, and parts list. Put it in a safe, dry place for future reference. **Keep your invoice with this manual. Write the invoice number on the inside front cover.**

READ ALL INSTRUCTIONS BEFORE ASSEMBLING OR OPERATING THE SLIP ROLL.
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SAFETY WARNINGS & CAUTIONS

WARNING: When using electric tools, machines or equipment, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury.

READ ALL INSTRUCTIONS BEFORE USING THIS TOOL

1. KEEP WORK AREA CLEAN. Cluttered areas invite injuries.
2. CONSIDER WORK AREA CONDITIONS. Do not use in damp, wet or poorly lit locations. Do not expose to rain. Keep work area well lit.
3. KEEP CHILDREN AWAY. All children should be kept away from the work area. Do not let them handle machine.
4. STORE IDLE EQUIPMENT. When not in use, tools should be locked up in a dry location to inhibit rust. If possible, store in an area out of reach of children.
5. DO NOT FORCE THE MACHINE OR TOOL. It will do the job better and more safely at the rate for which it was intended.
6. USE THE RIGHT TOOL. Do not force a small tool or attachment to do the work of a larger industrial tool. Do not use a tool for a purpose for which it was not intended.
7. DRESS PROPERLY. Do not wear loose clothing or jewelry. They can be caught in moving parts. Protective gloves and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair, preventing it from getting caught in machinery.

8. **USE EYE AND EAR PROTECTION.** Use a full face mask if the work you are doing produces metal filings, dust or wood chips. Goggles are acceptable in other situations. Wear a clean dust mask if the work creates a lot of fine or coarse dust. When operating for extended periods of time, use approved ear protection. Safety goggles and ear protectors are available from Harbor Freight Tools.
9. **SECURE WORK.** Use clamps or a vise to hold the work if possible. It is safer than using your hands and it frees both hands to operate the tool.
10. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
11. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Keep handles dry, clean and free from oil and grease.
12. **STAY ALERT.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
13. **CHECK DAMAGED PARTS.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and other conditions that may affect its operation. Any parts that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.
14. **REPLACEMENT PARTS AND ACCESSORIES.** When servicing, use only identical replacement parts. Only use accessories intended for use with this tool. Approved accessories are available from Harbor Freight Tools.
15. **DO NOT OPERATE TOOL IF UNDER THE INFLUENCE OF ALCOHOL OR DRUGS.** Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate machine.

UNPACKING

If any parts are missing or broken, please call Harbor Freight Tools at the number on the cover of this manual.

MOUNTING

Step 1: Bolt the Slip Roll to a secure work surface using the four holes in the BASE (#25).

Step 2: You must purchase your own hardware. Buy four 5/16" bolts, nuts and lock washers, and eight washers. Add 1" to the thickness of your workbench to determine the appropriate length of your bolts.

Step 3: Place the Slip Roll in the desired location, making sure that there is enough room for the handle (positioned on the right when looking from the front) to be moved. Make sure there is enough room behind the Roll to accommodate stock.

Step 4: Mark the bench through the holes in the BASE.

Step 5: Remove Slip Roll.

Step 6: Drill 11/32" holes in the workbench.

Step 7: Place the Slip Roll so the holes in the BASE line up with the drilled holes.

Step 8: Install hardware in the following order:

- A. Bolt
- B. Slip Roll
- C. Workbench
- D. Washer
- E. Lock Washer
- F. Washer
- G. Nut

ADJUSTMENTS

1. To increase the gap between SHAFT I (#17) and SHAFT II (#18) to allow for varying thickness of materials, screw out the ADJUSTMENT KNOB (#24). To decrease the gap, screw it in. Make sure to adjust both KNOBS an equal amount. See Figure 1.

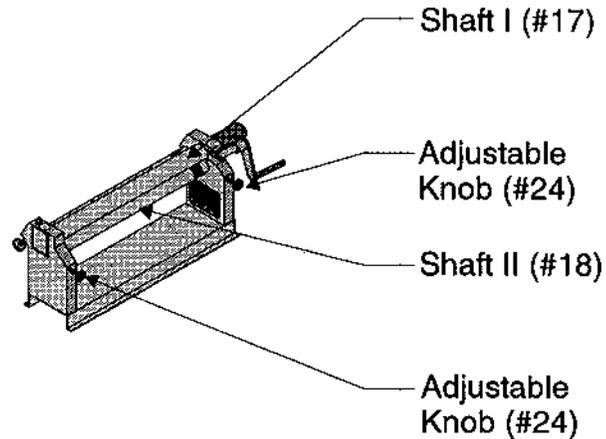


Figure 1 -- Adjusting the Material Gap

2. To increase the gap between SHAFT I and SHAFT III (#8) to increase the diameter of your rolls, screw out the ADJUSTMENT KNOB (#4). For smaller diameter rolls, screw the KNOB in. For even rolls, adjust both KNOBS an equal amount. To create cones, adjust one side more than the other. See Figure 2.

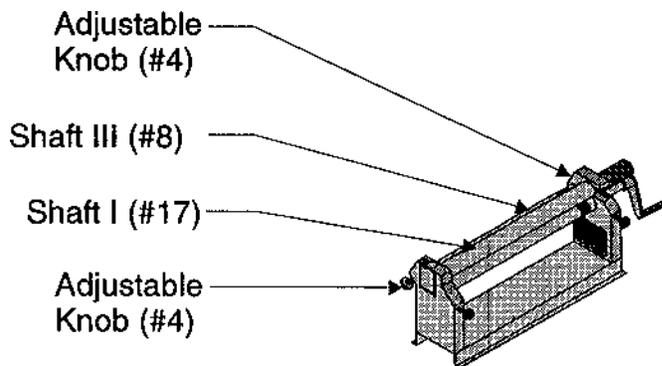


Figure 2 -- Adjusting the Roll Gap

OPERATION

Step 1: Perform all adjustments as required (see ADJUSTMENTS section) depending upon material thickness and whether you are engaging in straight rolls or cones.

Step 2: Insert material's edge between SHAFT I (#17) and SHAFT II (#18). See Figure 3.

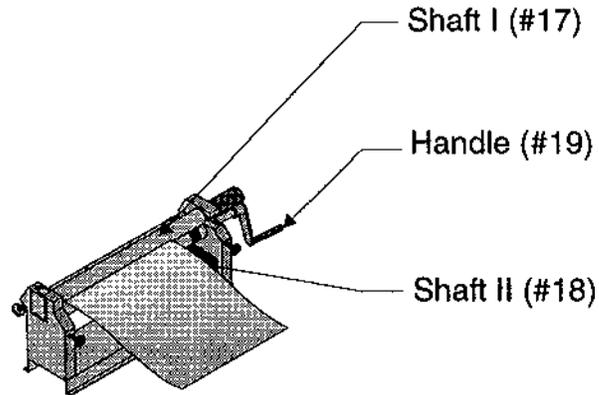


Figure 3 -- Inserting Material

Step 3: Turn HANDLE (#19) to process material.

Step 4: If you are only performing partial rolls and need to remove the material, slide out the SHAFT BUSHING (#11) and pull Shaft I forward. See Figure 4.

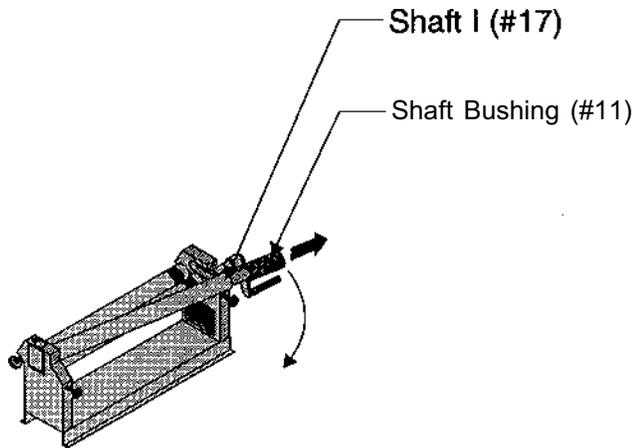


Figure 4 -- Removing Partial Rolls

Step 5: To form wires, select the smallest groove that you can use and put the edge of that wire on the groove of SHAFT II. Other operations are identical to sheet metal forming. See Figure 5.

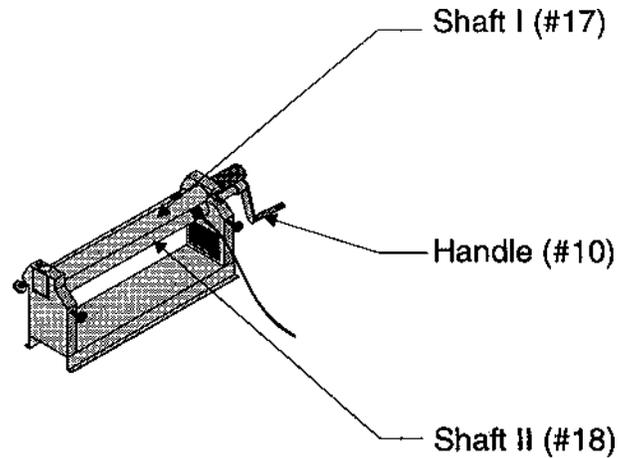


Figure 5 -- Wire Forming

Step 6: To form rings from wire, process the wire until the end meets the length of the stock. Remove SHAFT I as mentioned above. Cut the stock where the end meets it.

MAINTENANCE

Keep rolls free of oil, dirt and grease at all times.

Lubricate the gears as necessary by injecting grease through the hole in the OIL CUP (#2). See Figure 6.

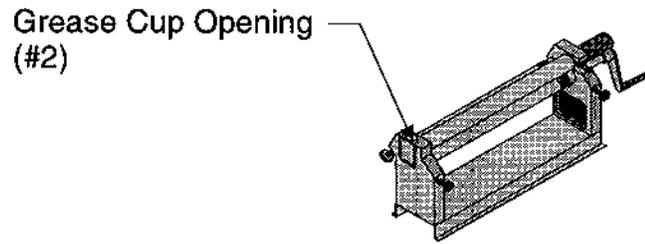


Figure 6 -- Lubricating the Gears

PARTS LIST

ITEM#	DESCRIPTION	QTY
1	Adjustment Screw	1
2	Grease Cap	1
3	Rotating Support	1
4	Adjustment Knob	2
5	Left Stand	1
6	Bushing	1
7	Flat Key 4x8	2
8	Shaft III	1
9	Handle Bushing	1
10	Right Stand	1
11	Shaft Bushing	1
12	Washer 6	1
13	Spring Washer 6	1
14	Screw M6x16	1

ITEM#	DESCRIPTION	QTY
15	Bushing	1
16	Gear	2
17	Shaft I	1
18	Shaft II	1
19	Handle	1
20	Nut M10	1
21	Handle Grip	1
22	Bolt M10x110	1
23	Pin	2
24	Adjustment Knob	2
25	Base	1
26	Washer 10	4
27	Spring Washer 10	4
28	Bolt M10x20	4
29	Bolt M6x6	1

PARTS DIAGRAM

