

INSTRUCTIONS

and

PARTS LIST

5 AND 6 INCH ROLL FORMERS

FORM J-7-A

Your Niagara Roll Former is a precision-built, accurate, quality machine tool. Careful attention to the adjustments and maintenance of your machine should result in many years of trouble-free service. Although the machine has been carefully inspected and tested in our plant, some of the adjustments may have been disturbed in transit. Therefore, it is recommended that your millwrights, maintenance men and operators carefully read these instructions before the machine is installed or operated. Additional copies of this manual will be furnished on request. Ask for Form J-7-A.

We can assume no liability for unauthorized alterations or attachments to your machine.

WARNING

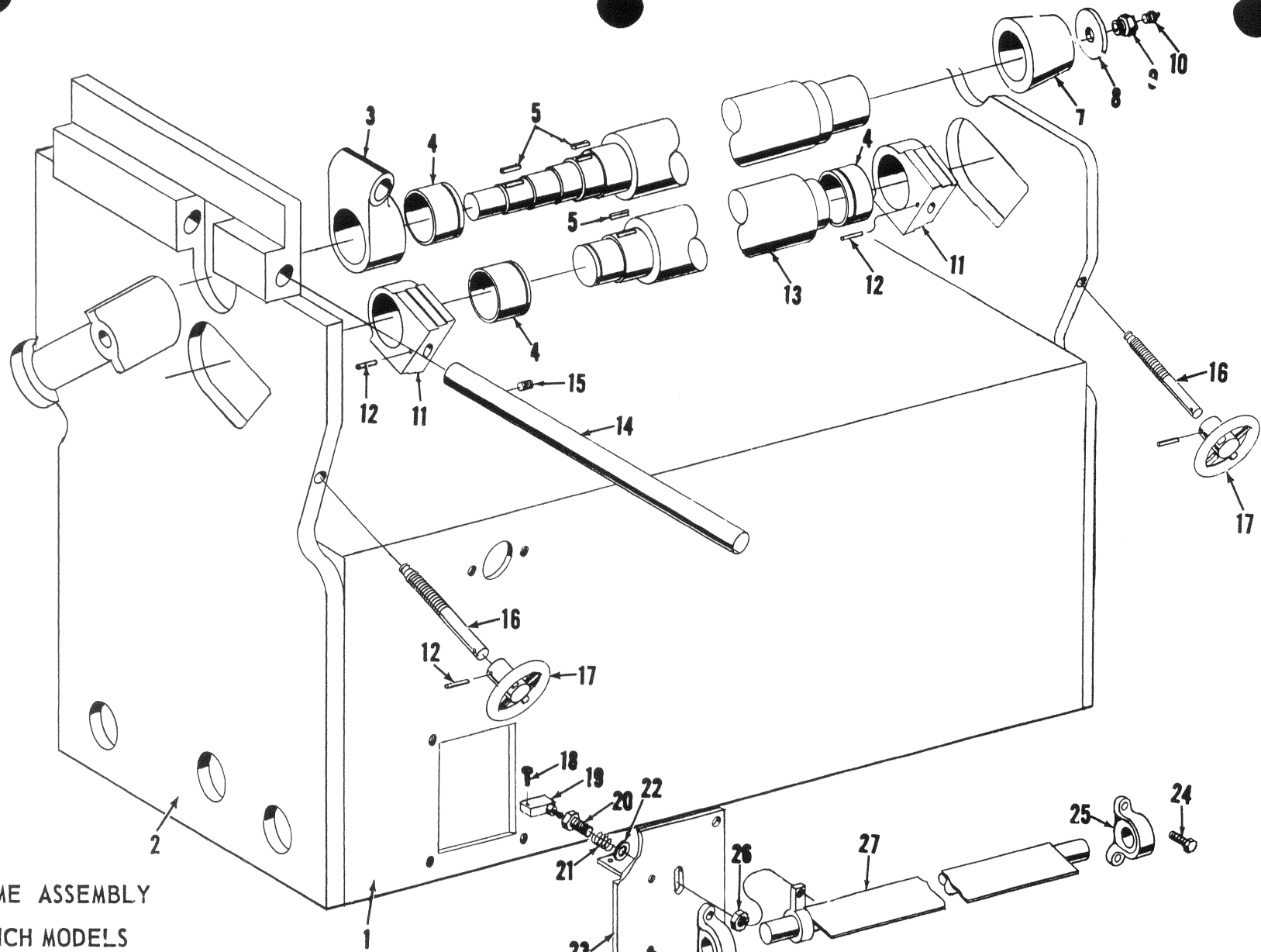
**TO PREVENT SERIOUS BODILY INJURY NEVER PLACE ANY PART OF YOUR BODY NEAR MOVING PARTS OF THIS EQUIPMENT.
NEVER WEAR LOOSE CLOTHING THAT COULD BECOME TANGLED OR CAUGHT IN MOVING PARTS.
NEVER OPERATE OR MAINTAIN THIS EQUIPMENT WITHOUT PROPER INSTRUCTIONS.**

IT IS THE EMPLOYERS RESPONSIBILITY TO IMPLEMENT THE ABOVE AND ALSO TO PROVIDE PROPER GUARDS, DEVICES OR MEANS THAT MAY BE NECESSARY OR REQUIRED FOR ANY PARTICULAR USE, OPERATION, SET-UP OR SERVICE.

DO NOT REMOVE THIS SIGN FROM THIS EQUIPMENT

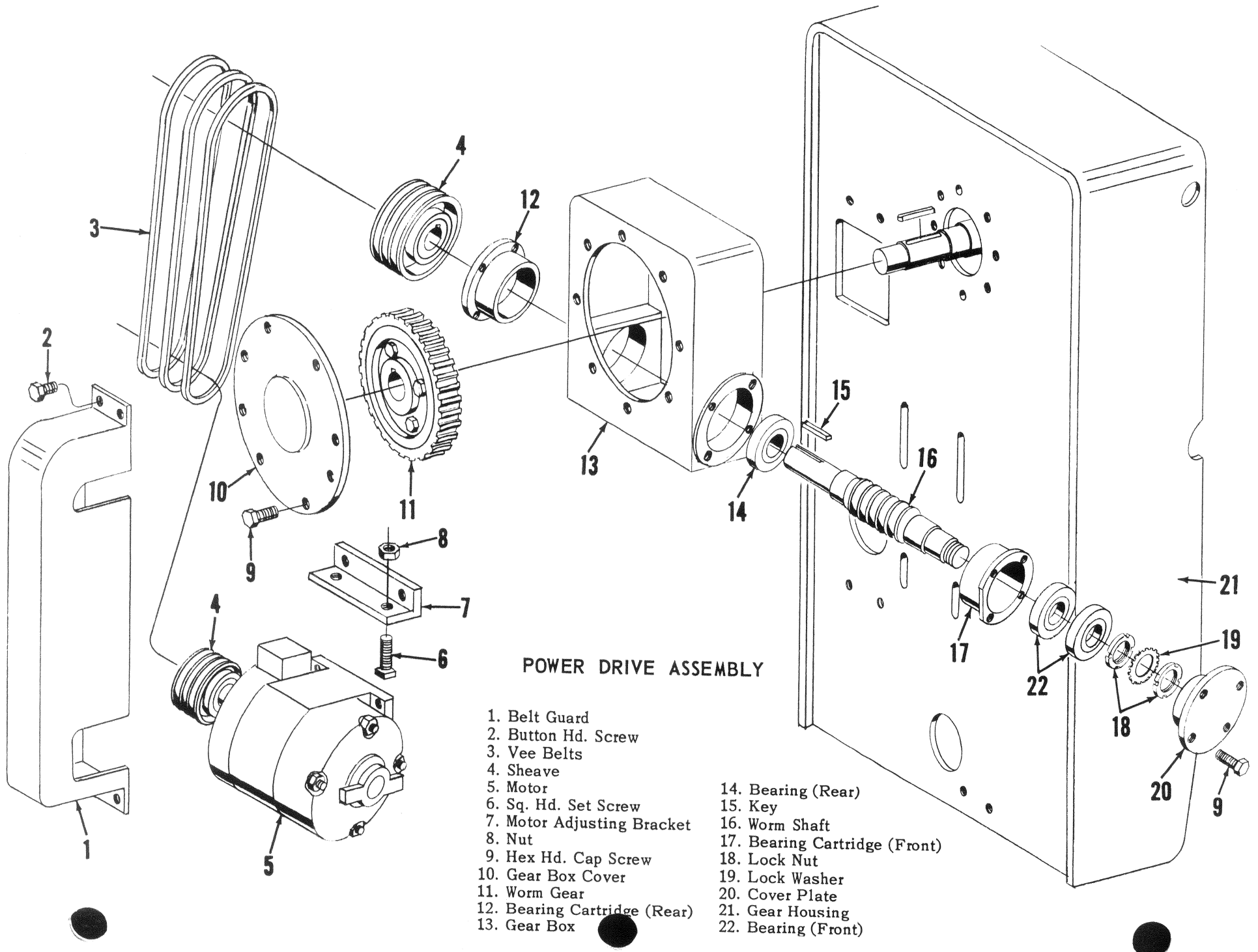
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Form J-7-A



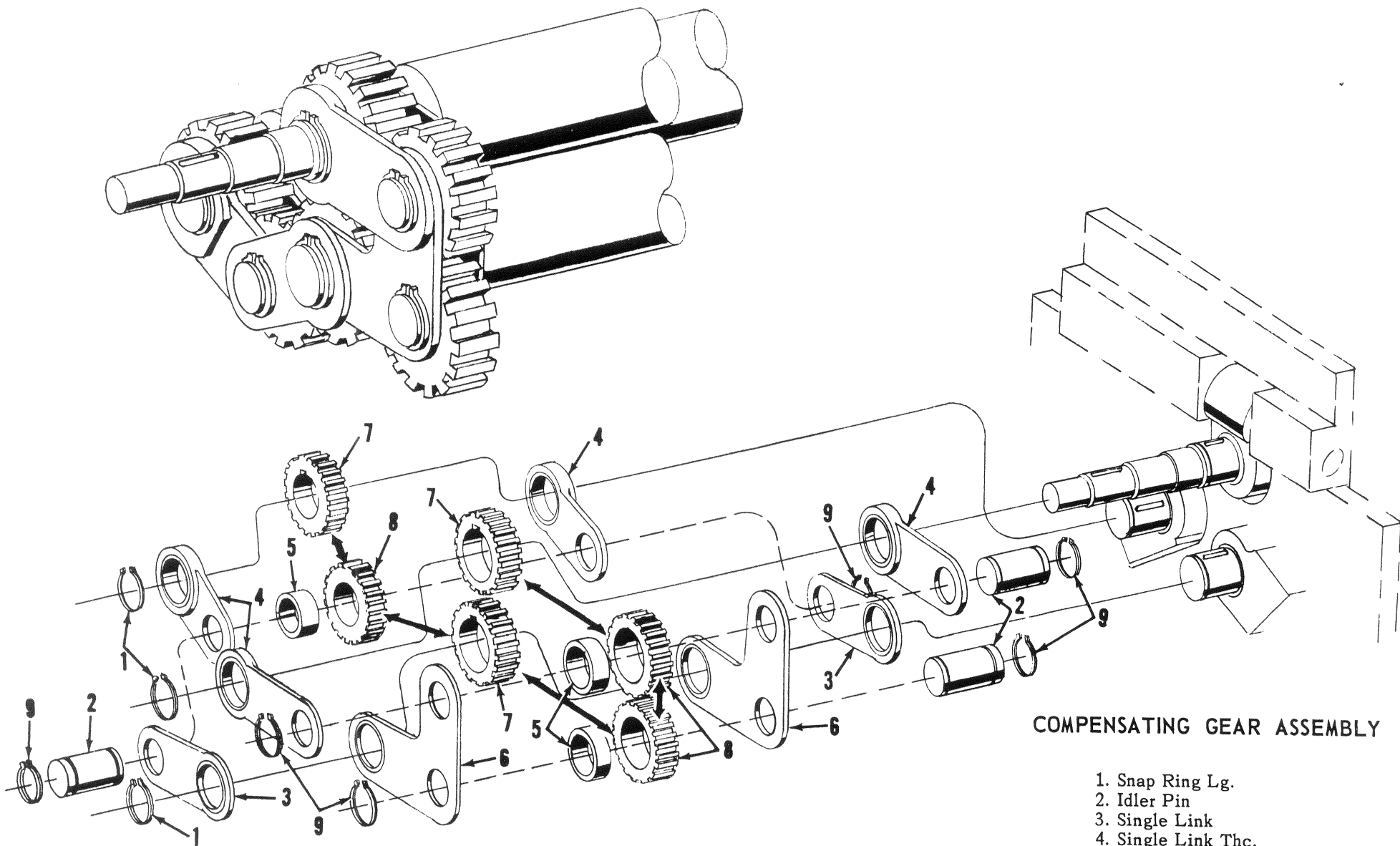
**FRAME ASSEMBLY
6 INCH MODELS**

- | | | | |
|-------------------------|---------------------------|--------------------------------|-----------------------|
| 1. Center Frame Section | 8. Bushing Retainer | 15. Set Screw | 23. Treadle Bracket |
| 2. Hinge Plate | 9. Bushing Retainer Screw | 16. Lower Roll Adjusting Screw | 24. Hex Hd. Cap Screw |
| 3. Rocking Box | 10. Grease Fitting | 17. Hand Knob | 25. Pillow Block |
| 4. Bushing | 11. Lower Roll Bearing | 18. Screw | 26. Nut |
| 5. Key | 12. Roll Pin | 19. Micro Switch | 27. Treadle |
| 6. Upper Roll | 13. Lower Roll | 20. Hex Hd. Cap Screw | |
| 7. Tail Stock Bushing | 14. Hinge Pin | 21. Spring | |
| | | 22. Washer | |



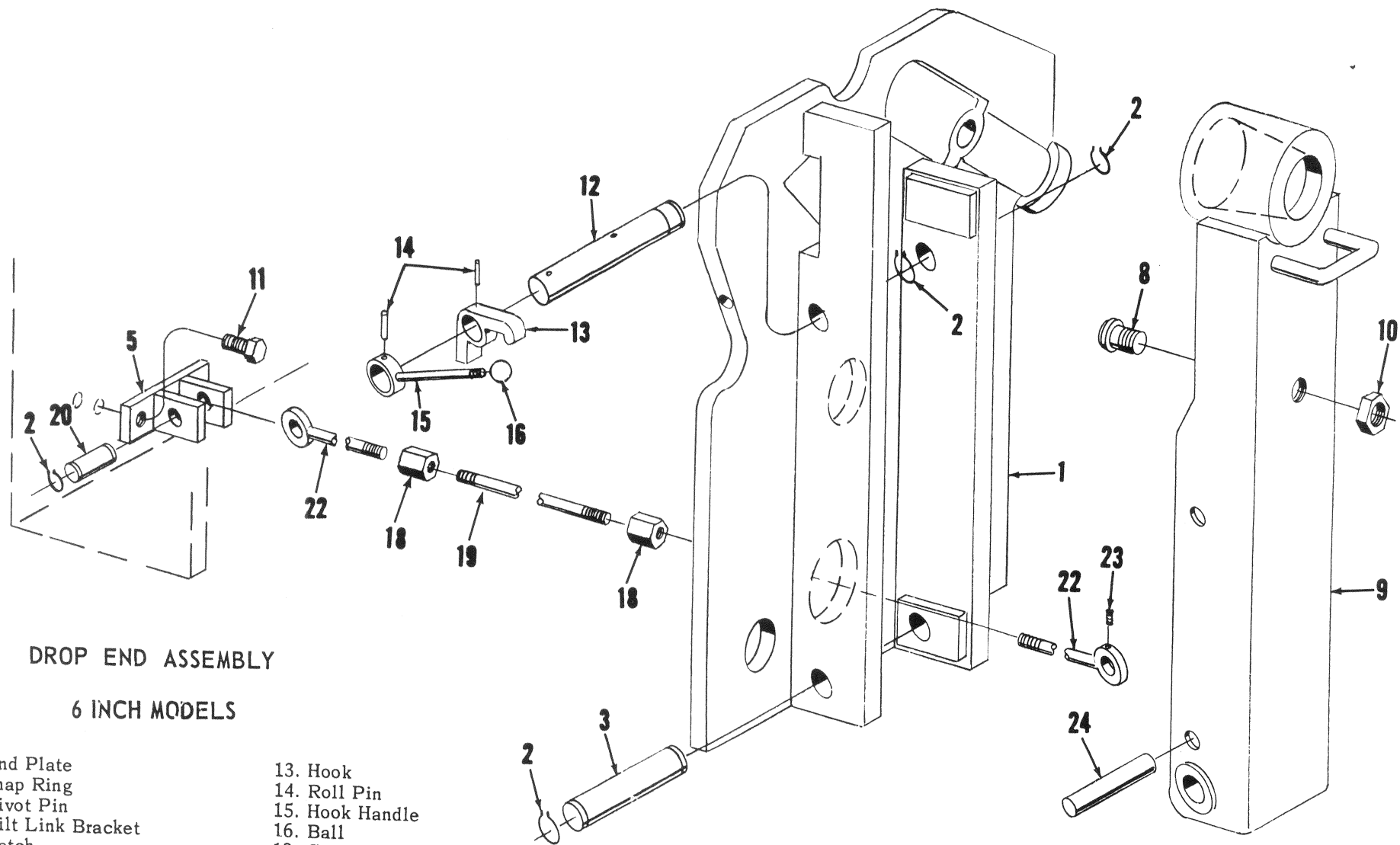
POWER DRIVE ASSEMBLY

- 1. Belt Guard
- 2. Button Hd. Screw
- 3. Vee Belts
- 4. Sheave
- 5. Motor
- 6. Sq. Hd. Set Screw
- 7. Motor Adjusting Bracket
- 8. Nut
- 9. Hex Hd. Cap Screw
- 10. Gear Box Cover
- 11. Worm Gear
- 12. Bearing Cartridge (Rear)
- 13. Gear Box
- 14. Bearing (Rear)
- 15. Key
- 16. Worm Shaft
- 17. Bearing Cartridge (Front)
- 18. Lock Nut
- 19. Lock Washer
- 20. Cover Plate
- 21. Gear Housing
- 22. Bearing (Front)



COMPENSATING GEAR ASSEMBLY

- 1. Snap Ring Lg.
- 2. Idler Pin
- 3. Single Link
- 4. Single Link Thc.
- 5. Bushing
- 6. Double Link
- 7. Roll Gears
- 8. Idler Gears
- 9. Snap Ring Sm.

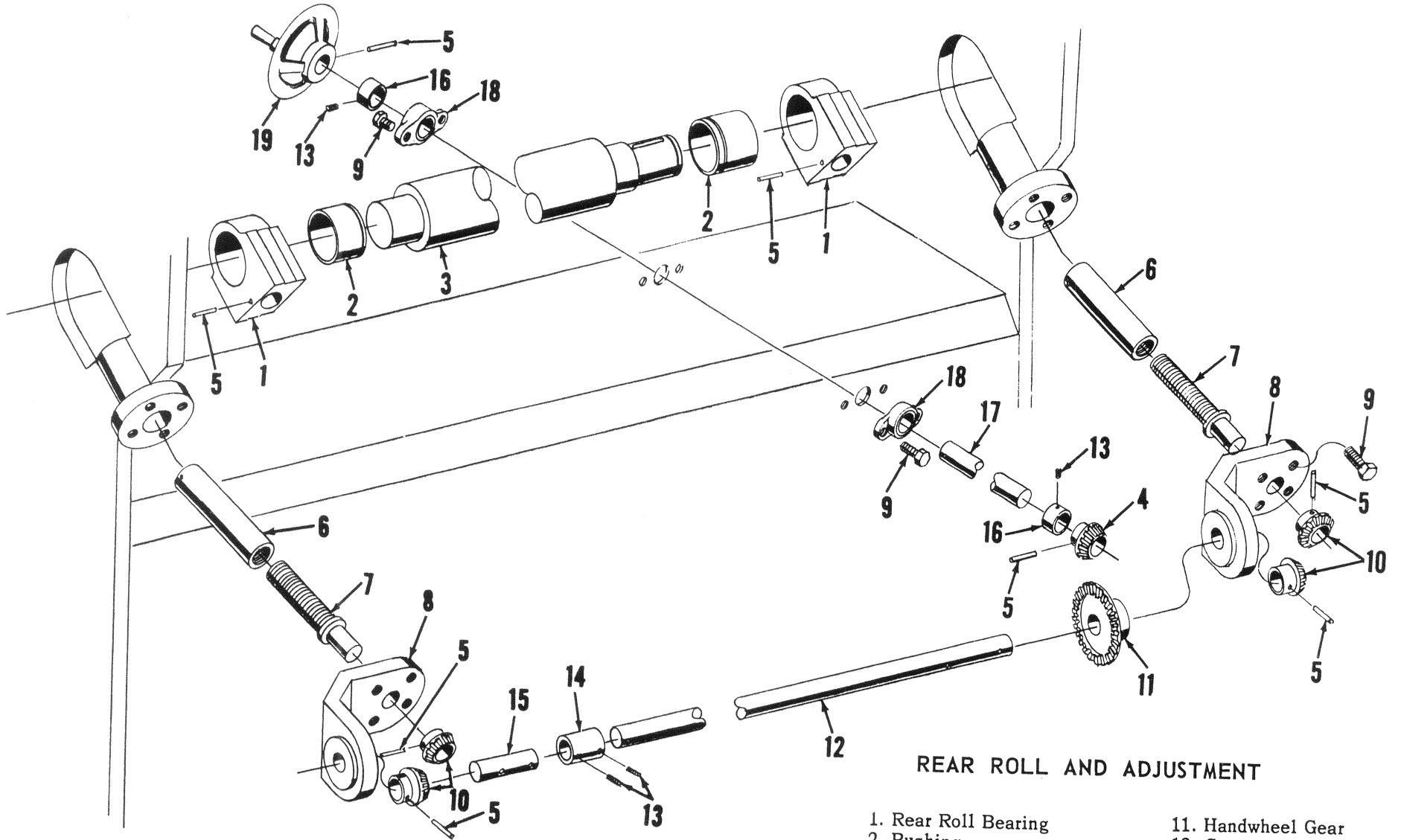


DROP END ASSEMBLY

6 INCH MODELS

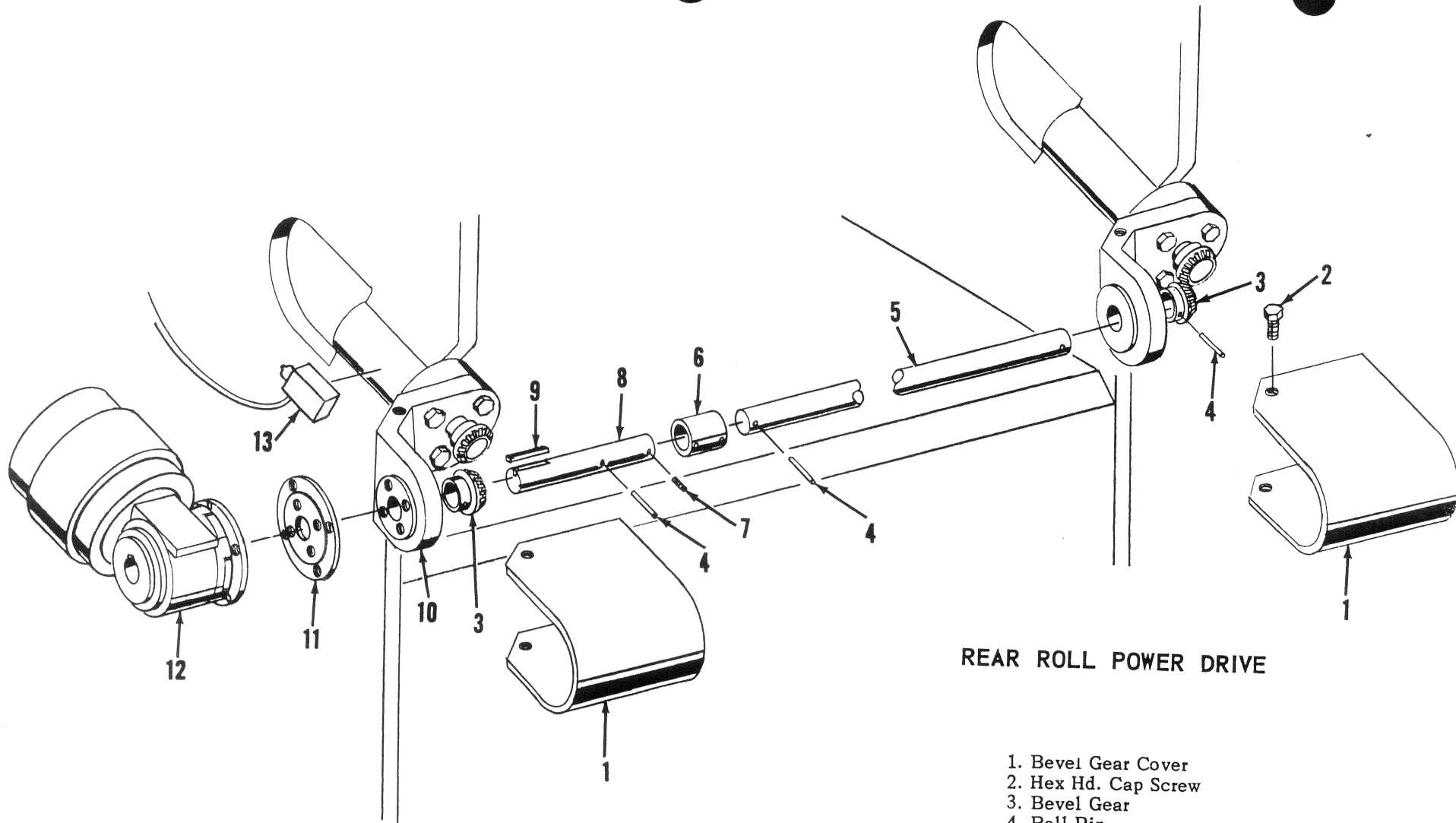
- 1. End Plate
- 2. Snap Ring
- 3. Pivot Pin
- 5. Tilt Link Bracket
- 8. Latch
- 9. Tailstock
- 10. Nut
- 11. Hex Hd. Cap Screw
- 12. Hook Pin

- 13. Hook
- 14. Roll Pin
- 15. Hook Handle
- 16. Ball
- 18. Coupling Nut
- 19. Tilt Link Rod
- 20. Pin
- 22. Eye Bolt
- 23. Set Screw
- 24. Link Pin



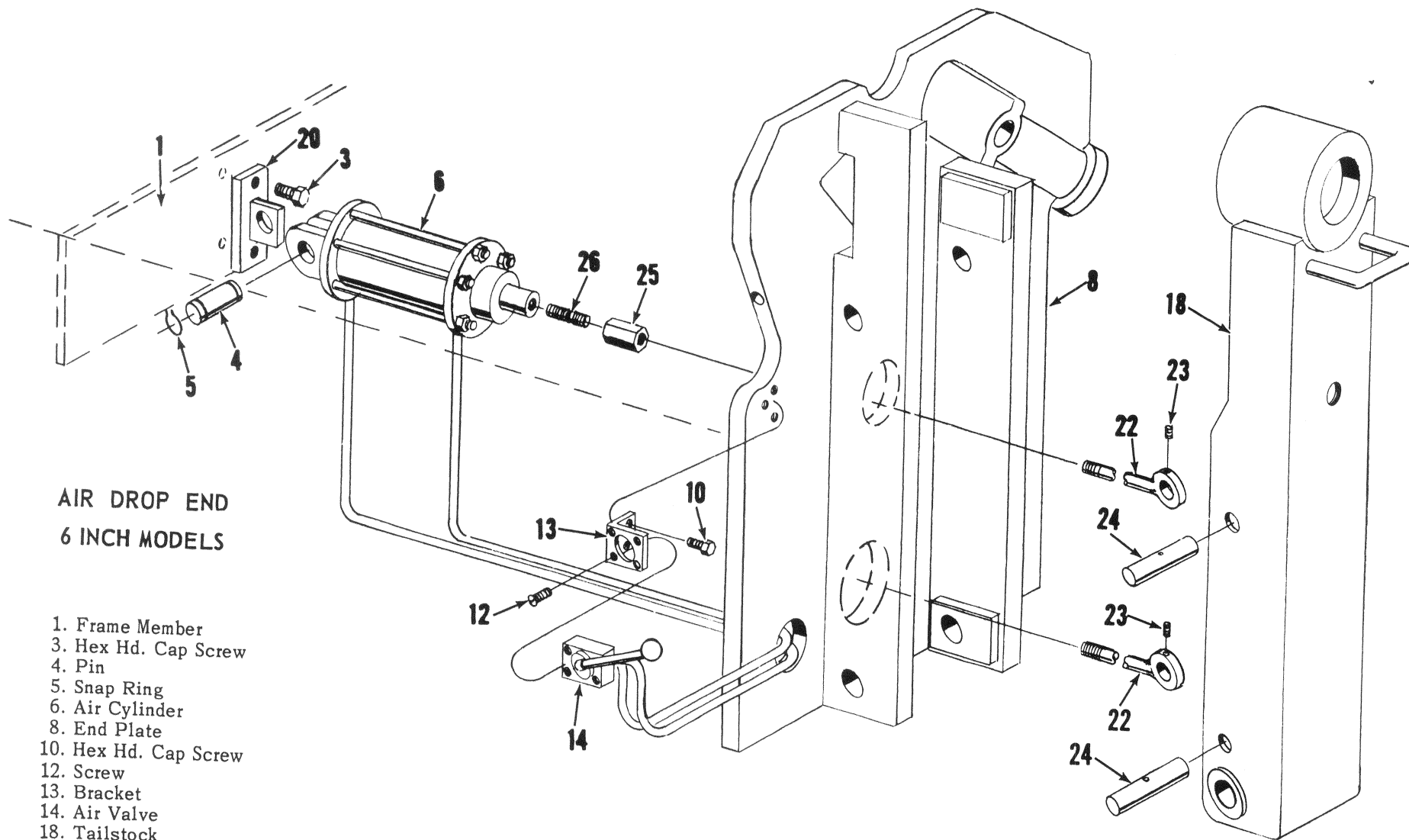
REAR ROLL AND ADJUSTMENT

- | | |
|------------------------------|---------------------|
| 1. Rear Roll Bearing | 11. Handwheel Gear |
| 2. Bushing | 12. Gear Shaft |
| 3. Rear Roll | 13. Set Screw |
| 4. Handwheel Pinion | 14. Sleeve Coupling |
| 5. Roll Pin | 15. Gear Shaft R.H. |
| 6. Adjusting Nut | 16. Collar |
| 7. Rear Roll Adjusting Screw | 17. Handwheel Shaft |
| 8. Bevel Gear Bracket | 18. Pillow Block |
| 9. Hex Hd. Cap Screw | 19. Handwheel |
| 10. Bevel Gears | |



REAR ROLL POWER DRIVE

1. Bevel Gear Cover
2. Hex Hd. Cap Screw
3. Bevel Gear
4. Roll Pin
5. Gear Shaft
6. Sleeve Coupling
7. Set Screw
8. Gear Shaft R. H.
9. Key
10. Bevel Gear Bracket
11. Motor Adapter
12. Motor
13. Micro Switch



**AIR DROP END
6 INCH MODELS**

- 1. Frame Member
- 3. Hex Hd. Cap Screw
- 4. Pin
- 5. Snap Ring
- 6. Air Cylinder
- 8. End Plate
- 10. Hex Hd. Cap Screw
- 12. Screw
- 13. Bracket
- 14. Air Valve
- 18. Tailstock
- 20. Air Cylinder Bracket
- 22. Eye Bolt
- 23. Set Screw
- 24. Link Pin
- 25. Coupling Nut
- 26. Stud

PARTS LIST

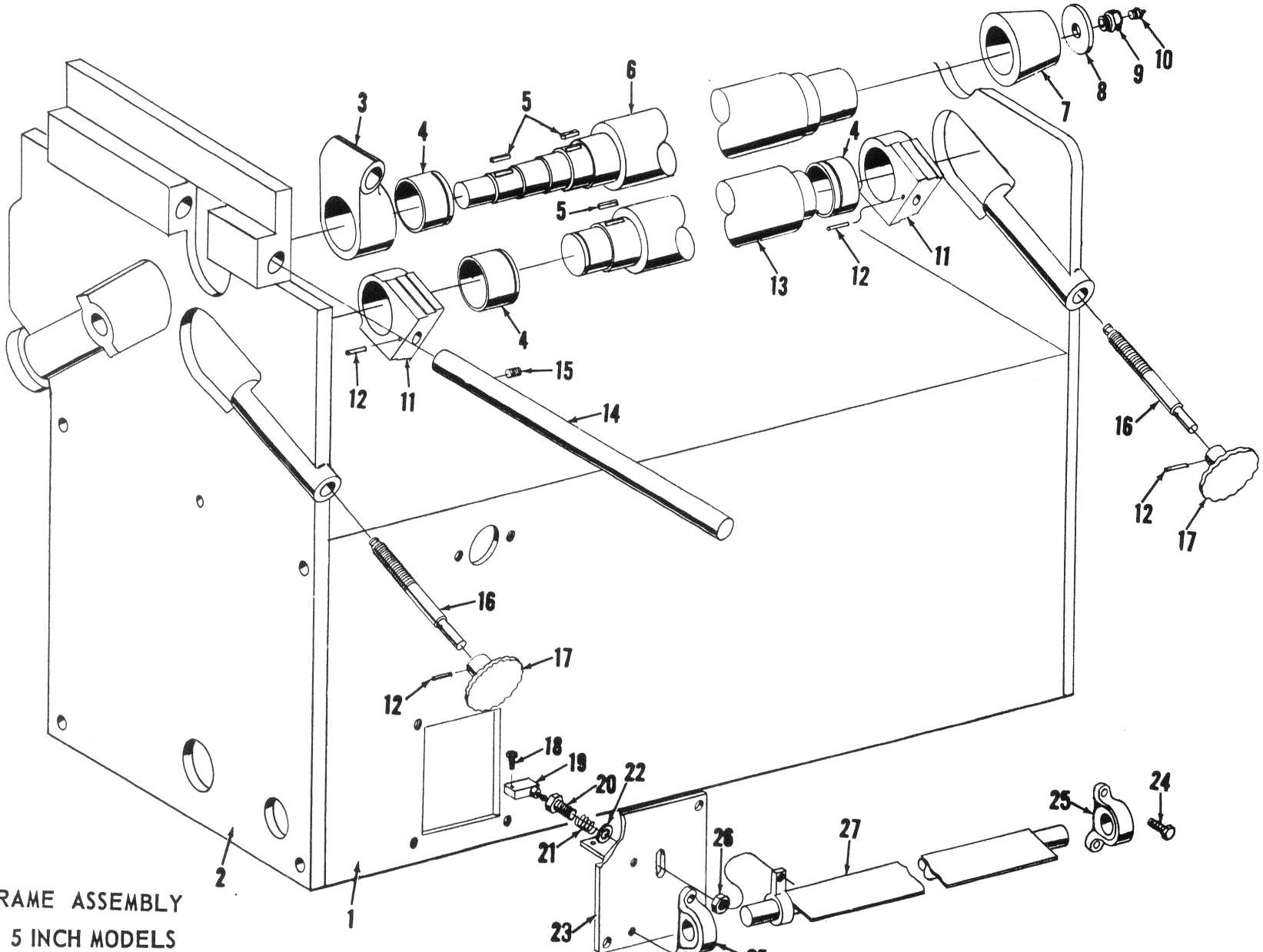
**FRAME ASSEMBLY
5 INCH MODELS**

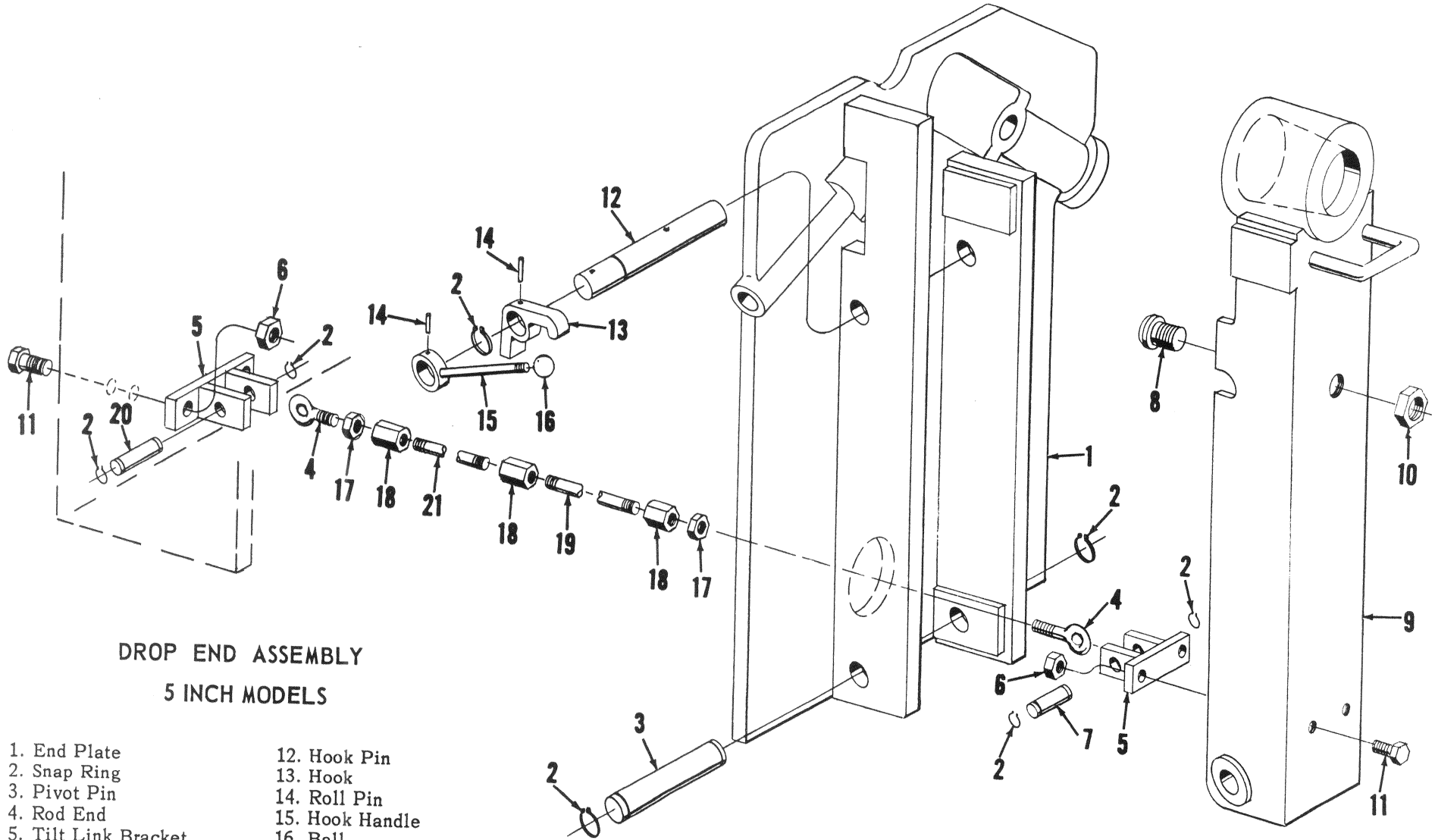
- 1. Center Frame Section
- 2. Hinge Plate
- 3. Rocking Box
- 4. Bushing
- 5. Key
- 6. Upper Roll
- 7. T Stock Bushing

- 8. Bushing Retainer
- 9. Bushing Retainer Screw
- 10. Grease Fitting
- 11. Lower Roll Bearing
- 12. Roll Pin
- 13. Lower Roll
- 14. Hinge Pin

- 15. Set Screw
- 16. Lower Roll Adjusting Screw
- 17. Hand Knob
- 18. Screw
- 19. Micro Switch
- 20. Hex Hd. Cap Screw
- 21. Spring
- 22. Washer

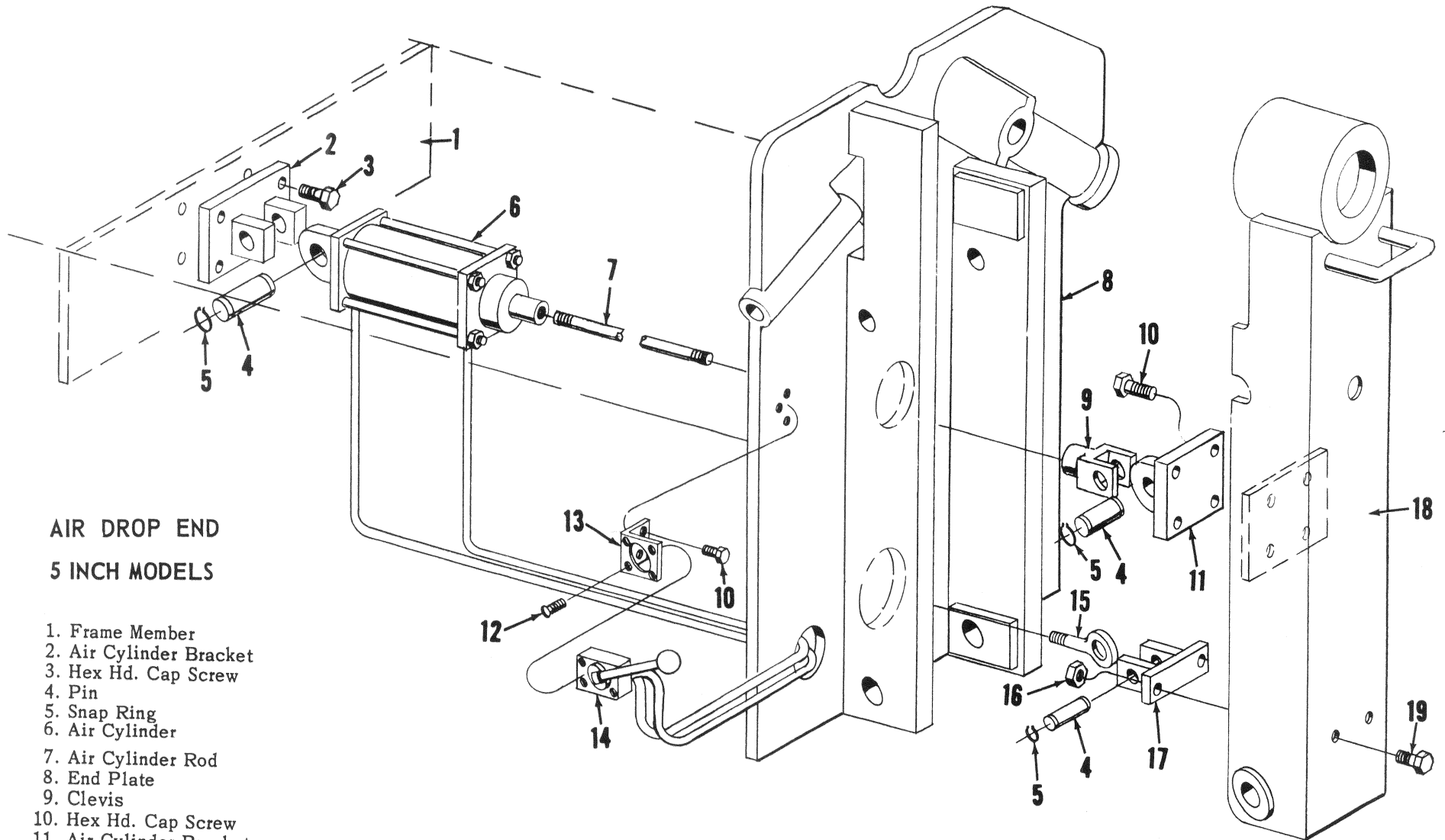
- 23. Treadle Bracket
- 24. Hex Hd. Cap Screw
- 25. Pillow Block
- 26. Nut
- 27. Treadle





**DROP END ASSEMBLY
5 INCH MODELS**

- | | |
|-----------------------|------------------------|
| 1. End Plate | 12. Hook Pin |
| 2. Snap Ring | 13. Hook |
| 3. Pivot Pin | 14. Roll Pin |
| 4. Rod End | 15. Hook Handle |
| 5. Tilt Link Bracket | 16. Ball |
| 6. Nut | 17. Nut |
| 7. Pin | 18. Coupling Nut |
| 8. Latch | 19. Tilt Link Rod R.H. |
| 9. Tailstock | 20. Pin |
| 10. Nut | 21. Tilt Link Rod |
| 11. Hex Hd. Cap Screw | |



**AIR DROP END
5 INCH MODELS**

- 1. Frame Member
- 2. Air Cylinder Bracket
- 3. Hex Hd. Cap Screw
- 4. Pin
- 5. Snap Ring
- 6. Air Cylinder
- 7. Air Cylinder Rod
- 8. End Plate
- 9. Clevis
- 10. Hex Hd. Cap Screw
- 11. Air Cylinder Bracket
- 12. Screw
- 13. Bracket
- 14. Air Valve
- 15. Rod End
- 16. Nut
- 17. Tilt Link Bracket
- 18. Tailstock
- 19. Hex Hd. Cap Screw