

SS INDUSTRIAL SEAMER

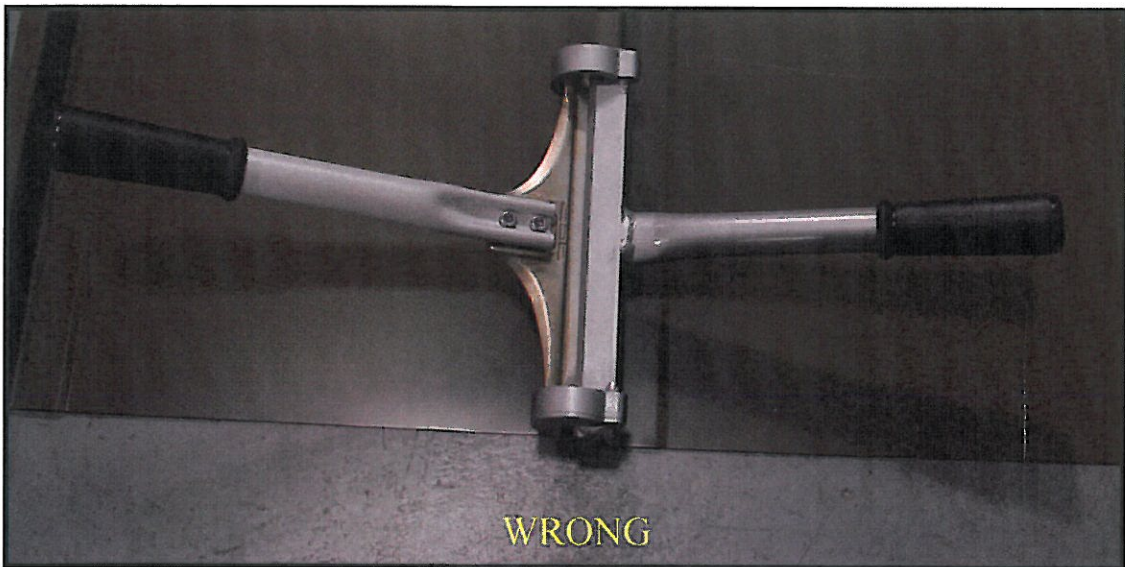
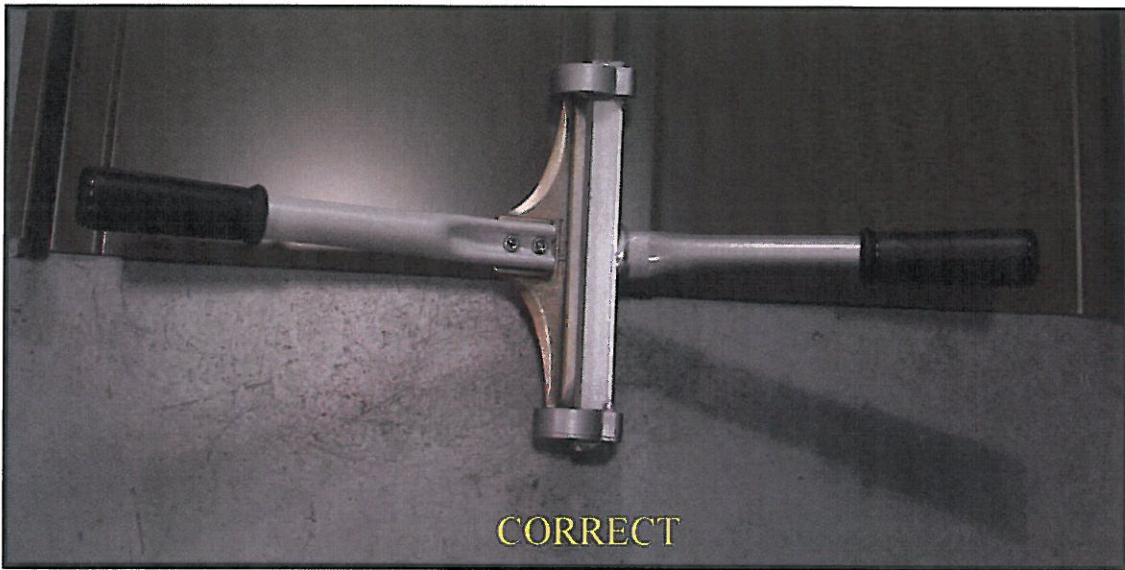
Owner's Manual



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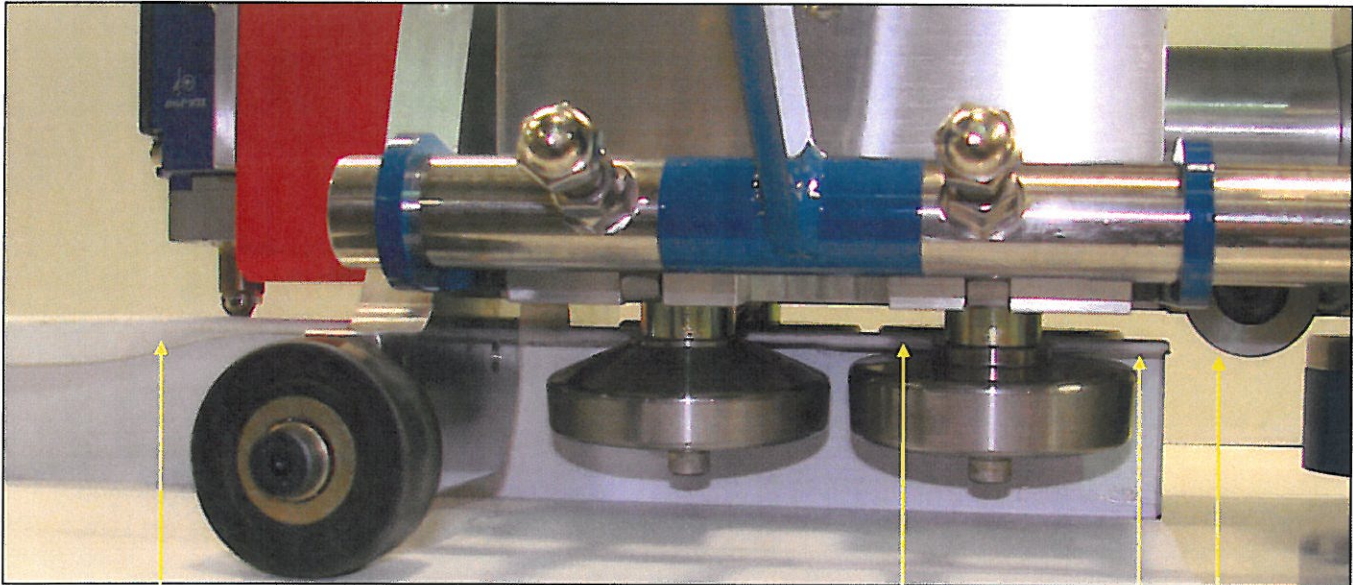
Starting a panel with a hand tool

When making the first crimp, at the edge of the panel with the 90° hand tool, you must start towards the middle of the tool. If you have the panel edge at the end of the tool, the relief in the tool die will not form the metal correctly. Then when you place the electric seamer on the panel, it will not turn the seam properly.



Starting a panel

← Direction of travel



Radius from 90° hand tool

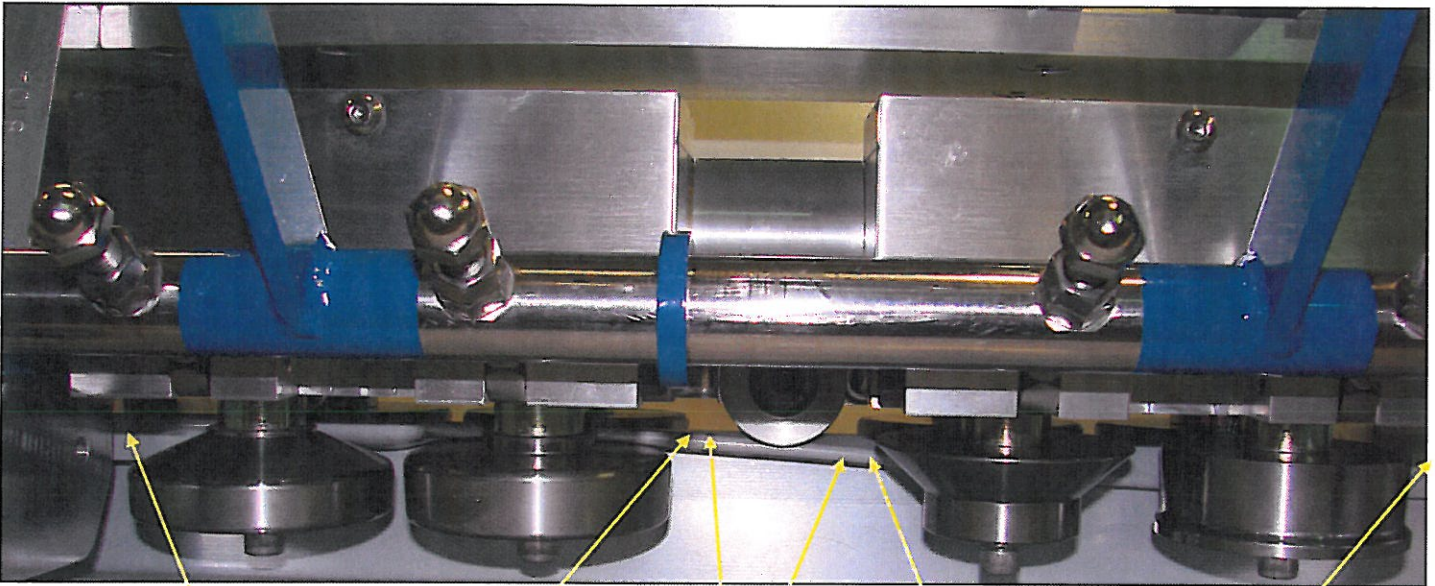
Stage # 2 is under 90° seam made with hand tool

No radius from 90° hand tool on end of panel

End of panel does not contact angle roll

Starting in the middle of a panel

← Direction of travel



Form this area
with 90° hand tool

Transition area
From 90° to 180°

Form this area
with 90° hand tool,
then use 180° hand tool

Wrong adjustment



Correct adjustment





SERIE JOINT A BARRE
QUICK-JOB
BAR CLAMP

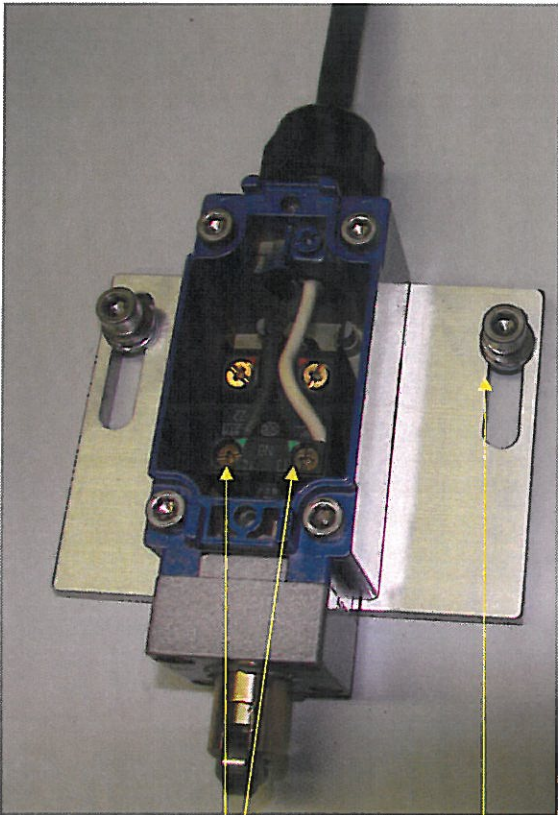
From the makers of VISE-GRIP
Pour les fabricants des outils VISE-GRIP

67150

Optional defeat of rear micro-switch

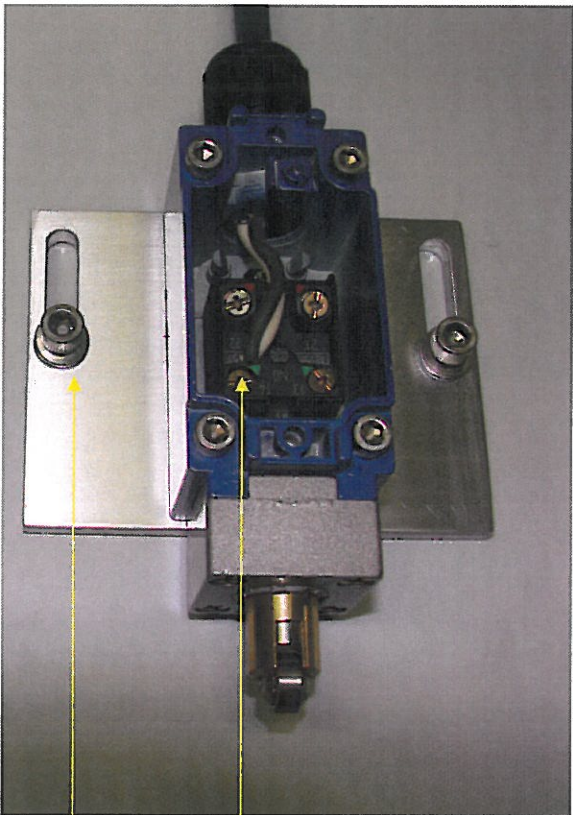
90° seaming
Two way

180° seaming
One way



2 connections

Plate moved down
on bolt



1 connection

Plate moved up
on bolt

To defeat rear microswitch: remove cover and loosen screws holding wires. Twist ends together and place under one connector. Tighten screw and replace cover. Loosen both plate bolts, slide plate up out of the way and tighten bolts.

OPERATION

STARTING A SEAM

1. Place switch on off position.
2. Place seamer with FIRST STAGE ONLY over seam.
3. Push lock handle down. (Tool must be in line with Micro-switch seated on top seam).
4. Now use the JOG-SWITCH to get the entire tool onto the seam.
5. Turn switch to run. (Tool will now run by itself).
6. Before seamer reaches end of seam, turn OFF and finish seam by pressing JOG-SWITCH.

JOG-SWITCH

This switch will turn on the motor without the micro-switches being depressed. It can also be used to operate the seamer for the full length of a seam.

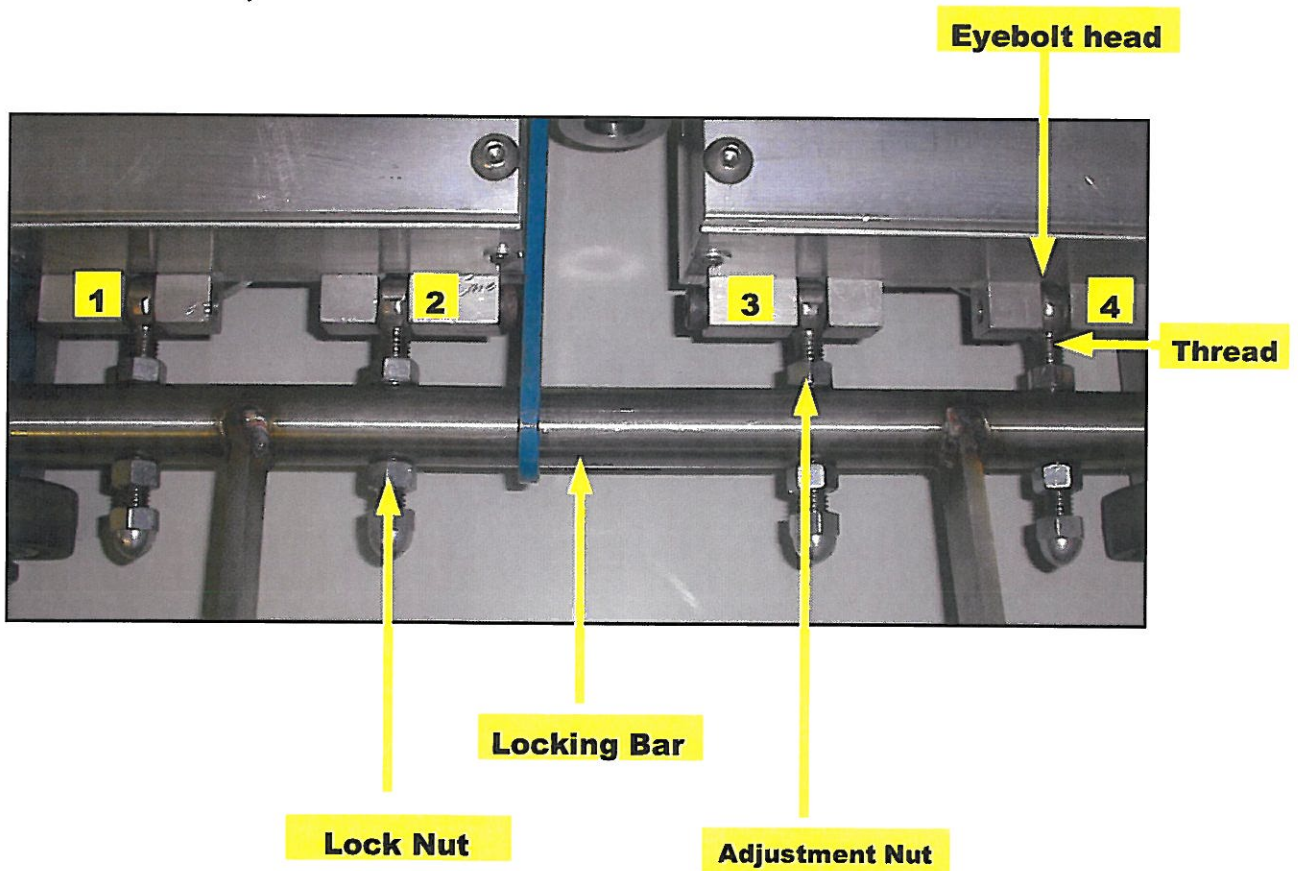
MICRO-SWITCH INFORMATION

1. This is a safety feature to prevent the tool from falling off a roof while operating unattended.
2. The micro-switch will also sense any "ride-up" of the seamer, sometimes caused by improperly formed pans or improperly laid down pans.
3. If a "ride-up" occurs, the micro-switch will cut the power to the tool so no damage will be done to the seam and material.
4. The seamer can be taken off of the seam at any time during seaming by simply turning the switch to OFF and pulling the locking handle up. It can also be put back at the same position where it was taken off and started up again.
5. Both front and rear micro-switches must be depressed on the seam in order to operate in the run position.
6. Microswitch should be adjusted at the beginning of every job and checked to make sure the "sensor wheel" is not being **forced** up into the sensor. It should be brought down on top of panel just until it clicks.

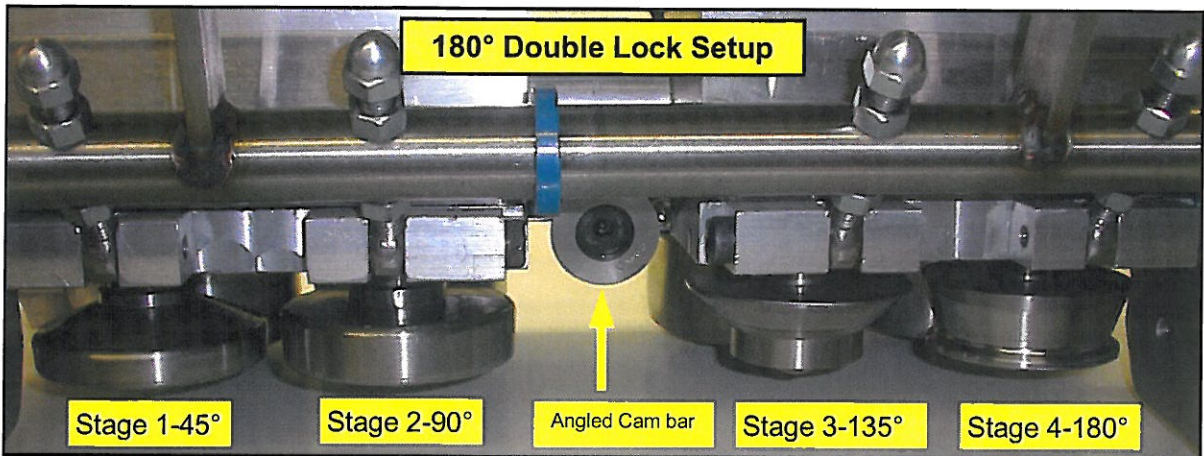
Locking Bar Adjusters

For a tighter seam when forming a 180° double lock:
Loosen lock nut on eyebolt # 4.
Turn adjustment nut to the left moving nut away from machine.
Tighten lock nut.

* It is **VERY** important to not over tighten as this may damage parts of the locking handle assembly.

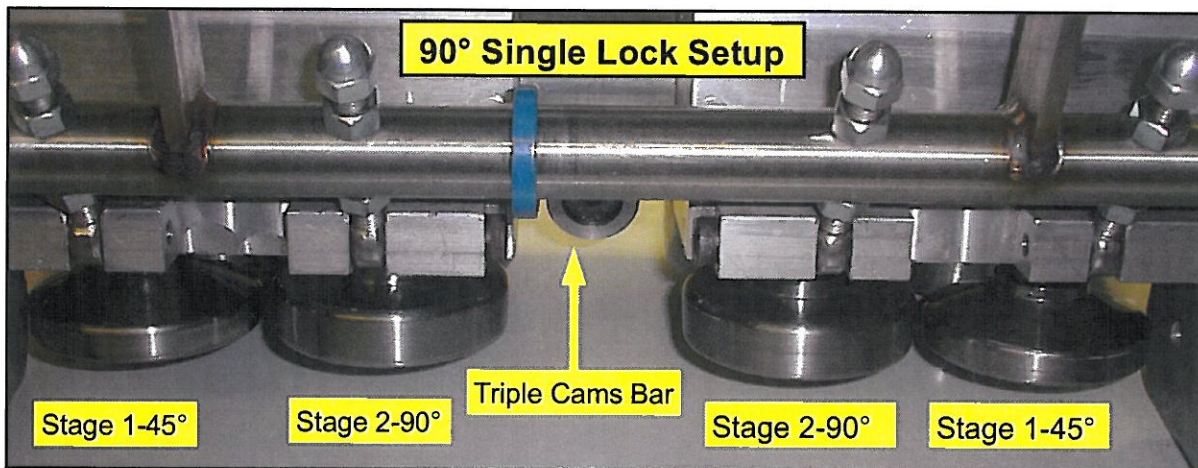


Roll Setup



Change from 180° to 90° seaming

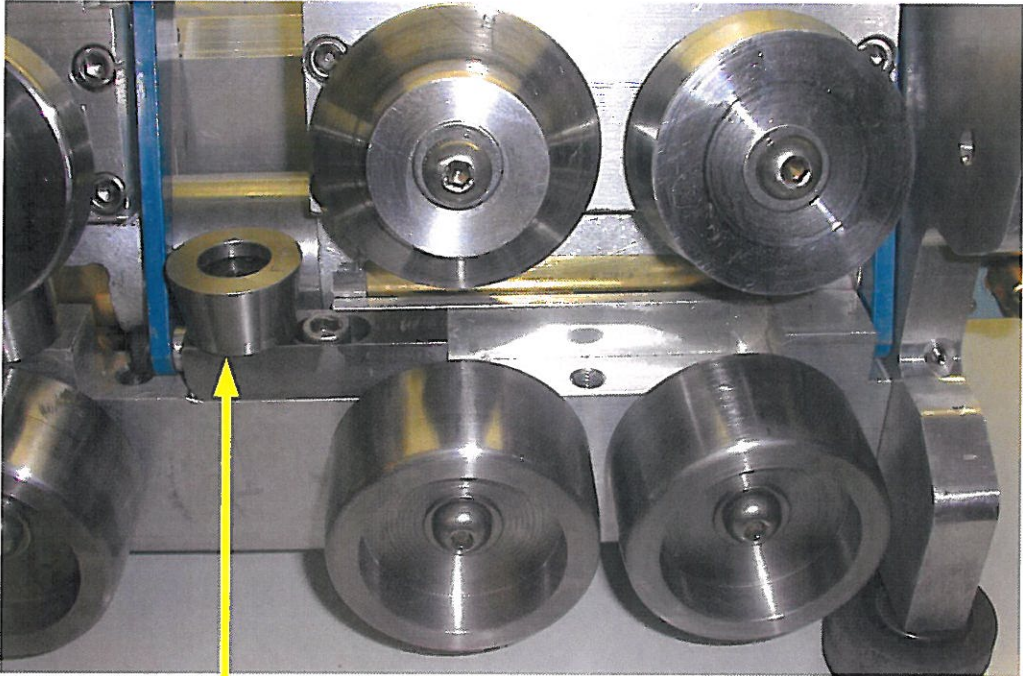
1. Remove screws from the bottoms of forming rolls on stage 3-135° and stage 4-180°.
2. Slide rolls off shafts **loosen** the stage 3 and 4 stationary rolls.
3. Remove bar with angled cam
4. Install bar with triple cams (supplied in kit).
5. Place barrel keys in slots on shafts.
6. Slide additional stage 2-90° roll (supplied) on shaft in stage 3 position.
7. Slide additional stage 1-45° roll (supplied) on shaft in stage 4 position.
8. Install screws and washers
9. To rough adjust stages 3 and 4, place a piece of .060 material and place between the forming rolls and friction rolls and lock handle down. Adjust until material is lightly pinched
10. Run test panel to fine tune settings.



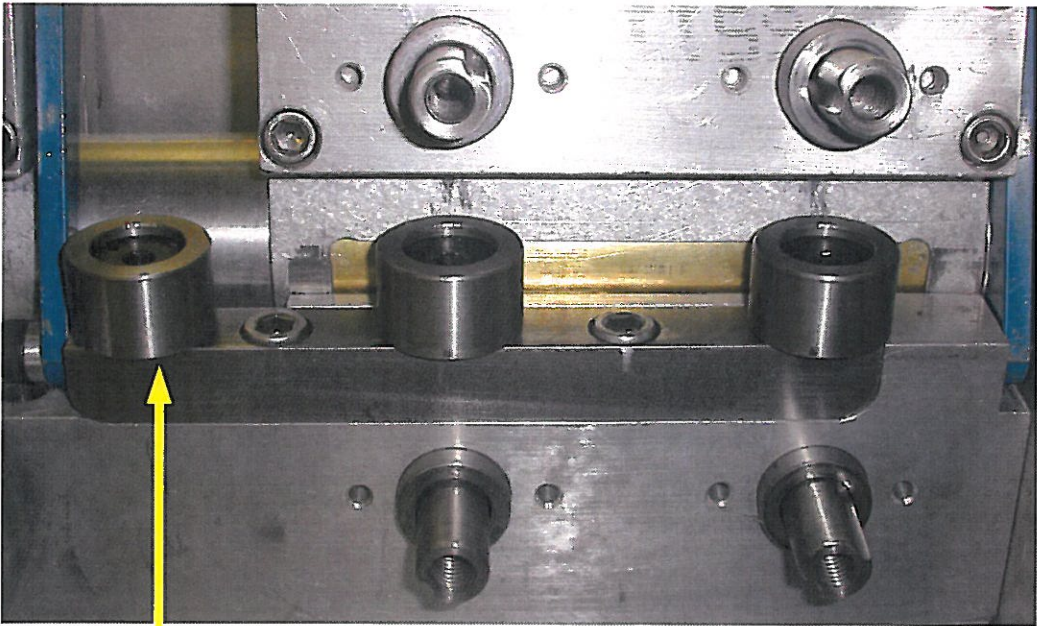
To return to 180° Seaming

1. Reverse the steps above, returning the stage 3-135° roll to Stage 3, stage 4 -180° roll to stage 4, and replace bar with angled cam with bar with triple cam.
2. To rough adjust stages 3 and 4, place a piece of .060 material and place between the forming rolls and friction rolls and lock handle down. Adjust until material is lightly pinched.
3. Run test panel to fine tune settings.

Cams



Single Angled Cam
On short bar for 180°
Double lock



Triple Cams on
Long bar for 90°
Single lock

Spacers



Shaft Spacer

Barrel Key

Shaft

SPECIFICATIONS

| | |
|--------|----------|
| Volts | 110-125V |
| AMPS | 11.0 |
| Weight | 89 lbs |

BRUSHES AND COMMUTATOR

Failure of the motor to start or to operate efficiently can usually be attributed to worn or damaged brushes, brushes sticking in the holders and failing to make proper contact with the commutator, or the commutator being dirty and rough. Frequent inspection of the brushes and commutator is recommended. Replace the brushes when worn down to 1/4". Always replace both brushes at the same time.

PLUGS AND EXTENSION CORDS

The tool should be grounded while in use to protect the operator from electric shock. The tool is equipped with an approved three-prong grounding-type plug to fit the proper grounding-type receptacle.

Use only three-wire extension cords, which have three-prong grounding-type plugs and three-pole receptacles, which accept the tools' plug.

As the distance of the supply outlet increases, heavier gauge extensions are required. The use of extension cords of inadequate size wire causes a serious drop in voltage, loss of power and possible motor damage.

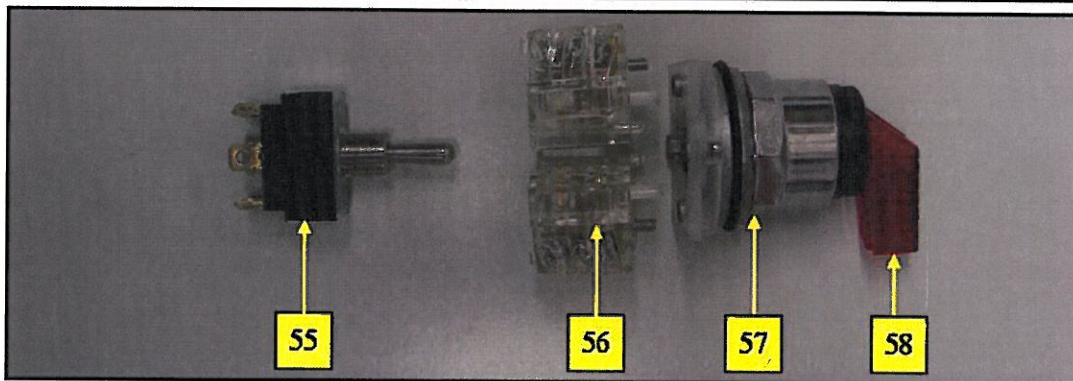
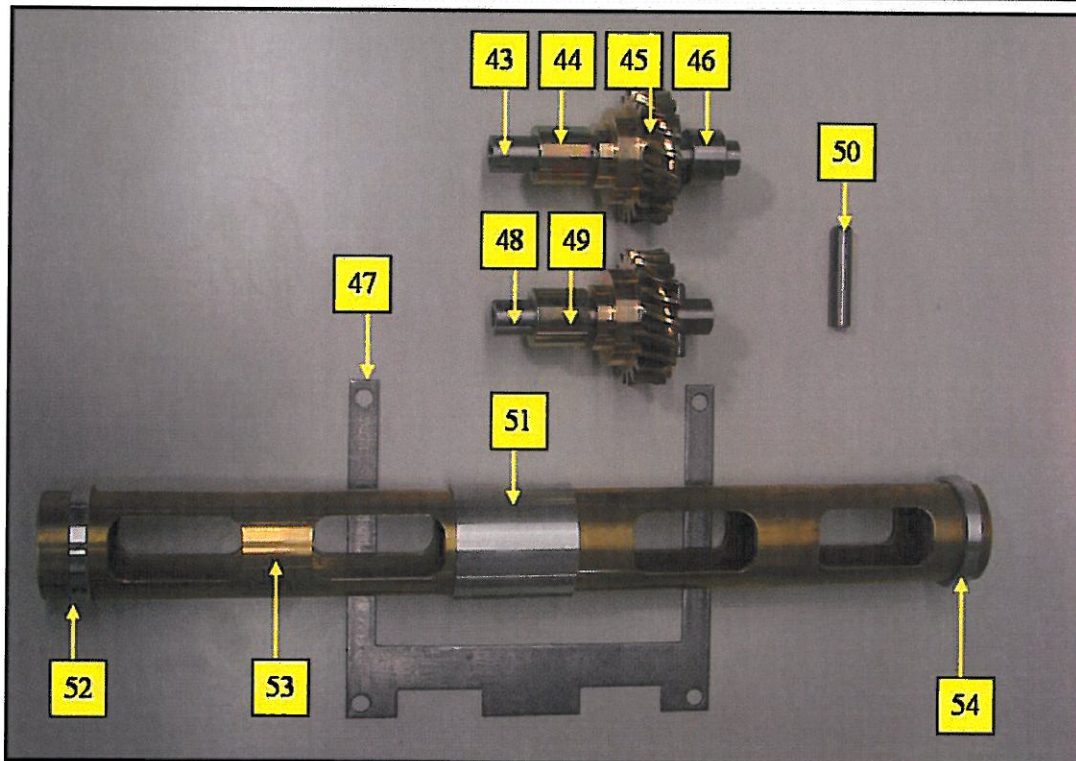
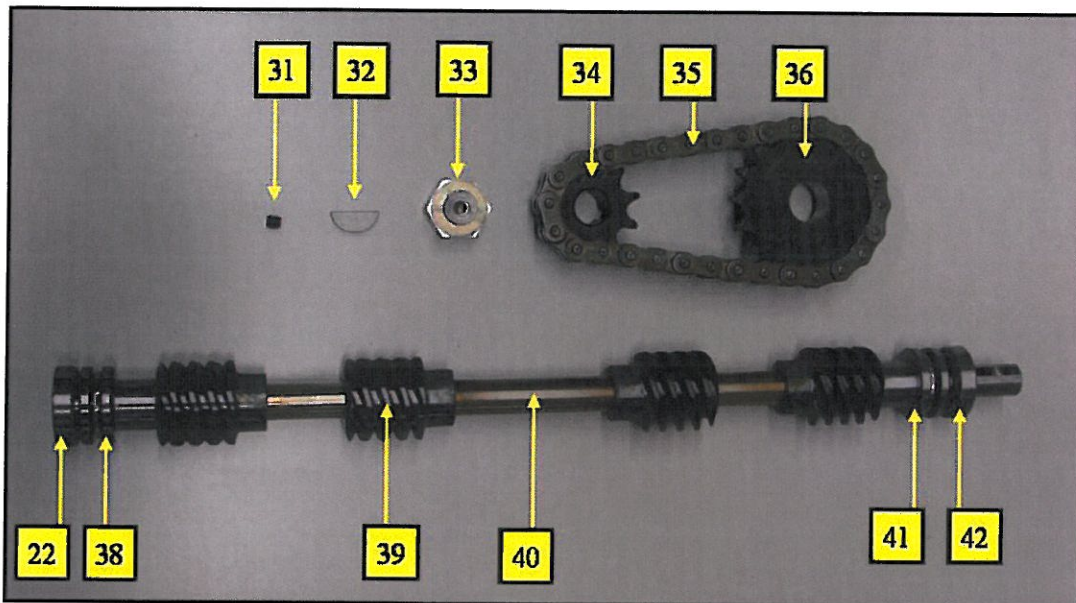
| Extension Cable Length | Wire Size |
|------------------------|-----------|
| 25 ft. | 16 |
| 50 ft | 14 |
| 75 ft. | 12 |
| 150 ft | 8 |
| 200 ft. | 8 |

VERY IMPORTANT

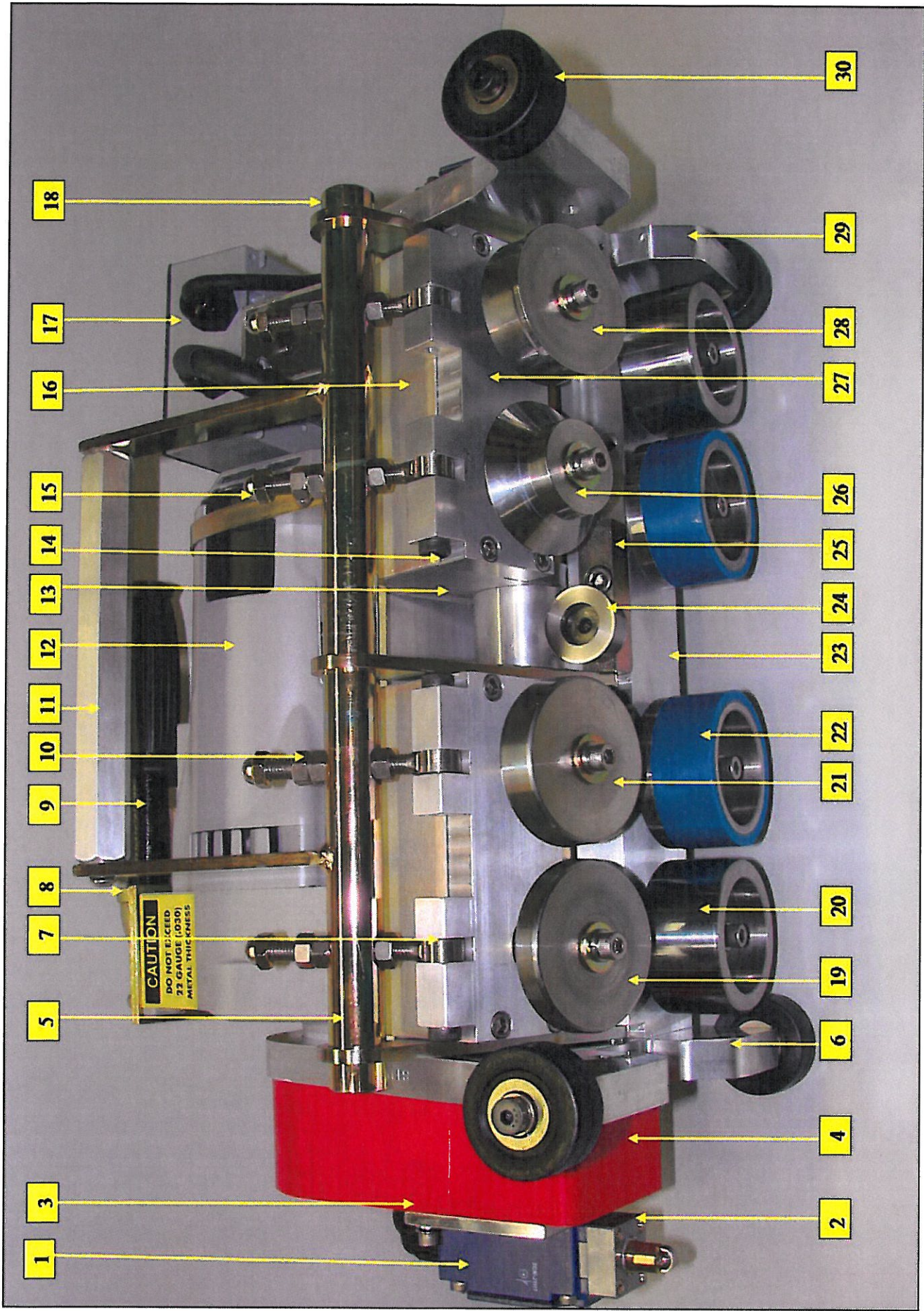
Disconnect all power before removing any covers on the machine.

Disconnect all power before servicing and adjusting the machinery.

Do not operate the machine at any time with the covers removed.



SSIND PARTS



SS INDUSTRIAL PARTS BREAKDOWN LIST

| | |
|-----------------------------|---------------------------------|
| 1. Micro switch body | 46. Gear spacer (.600) |
| 2. Micro switch head | 47. Wing Strap |
| 3. Micro switch plate | 48. Stationary roll shaft |
| 4. Chain cover | 49. Roll spacer (.907) |
| 5. Locking bar | 50. Linkage pin |
| 6. Front plate | 51. Large wing spacer |
| 7. Eye bolt | 52. Small wing spacer |
| 8. Carry handle elbow-plate | 53. Brass Tube |
| 9. Carry handle | 54. Small wing spacer |
| 10. Adjustment nut | 55. Toggle switch (fwd-off-rev) |
| 11. Locking bar handle | 56. Contact Block |
| 12. Motor | 57. Run-Jog switch |
| 13. Wing side plate | 58. Red Indicator |
| 14. Eye bolt shoulder bolt | |
| 15. Acorn nut | |
| 16. Wing cover | |
| 17. Switch box | |
| 18. Linkage arm | |
| 19. Forming roll – Stage 1 | |
| 20. Steel friction roll | |
| 21. Forming roll – Stage 2 | |
| 22. Rubber friction roll | |
| 23. Stationary plate | |
| 24. Angle roll | |
| 25. Angle roll block | |
| 26. Forming roll – Stage 3 | |
| 27. Movable wing bottom | |
| 28. Forming roll – Stage 4 | |
| 29. Back plate | |
| 30. Balance wheel | |
| 31. Set screw | |
| 32. Half moon key | |
| 33. Motor spacer assembly | |
| 34. Drive sprocket | |
| 35. Chain | |
| 36. Motor sprocket | |
| 37. Back plate bearing | |
| 38. Thrust bearing | |
| 39. Worm gear (welded) | |
| 40. Drive shaft | |
| 41. Drive shaft spacer | |
| 42. Front plate bearing | |
| 43. Movable roll shaft | |
| 44. Roll spacer (.907) | |
| 45. Bronze gear | |

STANDARD EQUIPMENT WARRANTY

Roll Former Corporation warrants to the original purchaser that the equipment is free from defects in material and workmanship in normal use and service. Normal use and service does not extend to defects from mishandling, tampering or modifying the equipment.

The term of this warranty is for a period of *ninety (90) days for the Seamer and one hundred and eighty (180) days for all other Roll Forming Equipment from the date of the receipt of the equipment to the original purchaser*. Roll Former Corporation shall repair or replace the defective parts at their place of business without charge to the original purchaser of the equipment.

The equipment subject to this warranty must first be returned to Roll Former Corporation with freight charges prepaid, which after examination by Roll Former Corporation shall disclose to its satisfaction to have been defective. Roll Former Corporation shall correct the defect and ship the prepaid equipment to the location of the purchaser's facility within the continental United States.

The foregoing warranties are in lieu of all other warranties expressed or implied, and of all obligation or liabilities on the part of Roll Former Corporation for breach of warranty.

Roll Former Corporation's sole liability for any breach of warranty shall be limited to the repair or replacement of any defective parts in the accordance with the above.

Roll Former Corporation's warranty does not extend to equipment that has been used under a lease or rental agreement from the original purchaser.

CUSTOM EQUIPMENT - WARRANTY AND LIABILITY

Roll Former Corporation's liability for custom equipment prior to acceptance, is the amount of deposit from the customer. Roll Former warrants, after acceptance, all custom equipment for a period of one hundred and eighty (180) days from the date of the receipt of the equipment to the original purchaser that the equipment is free from defects in material and workmanship in normal use and service.

The equipment subject to this warranty must first be returned to Roll Former Corporation with freight charges prepaid, which after examination by Roll Former Corporation shall disclose to its satisfaction to have been defective. Roll Former Corporation shall correct the defect and ship the prepaid equipment to the location of the purchaser's facility within the continental United States.

The foregoing warranties are in lieu of all other warranties expressed or implied, and of all obligation or liabilities on the part of Roll Former Corporation for breach of warranty.

Roll Former Corporation's sole liability for any breach of warranty shall be limited to the repair or replacement of any defective parts in the accordance with the above.

Warranty will not be available if any of the following occurs:

1. Mishandling - tampering or modifying equipment.
2. Leasing or renting equipment.