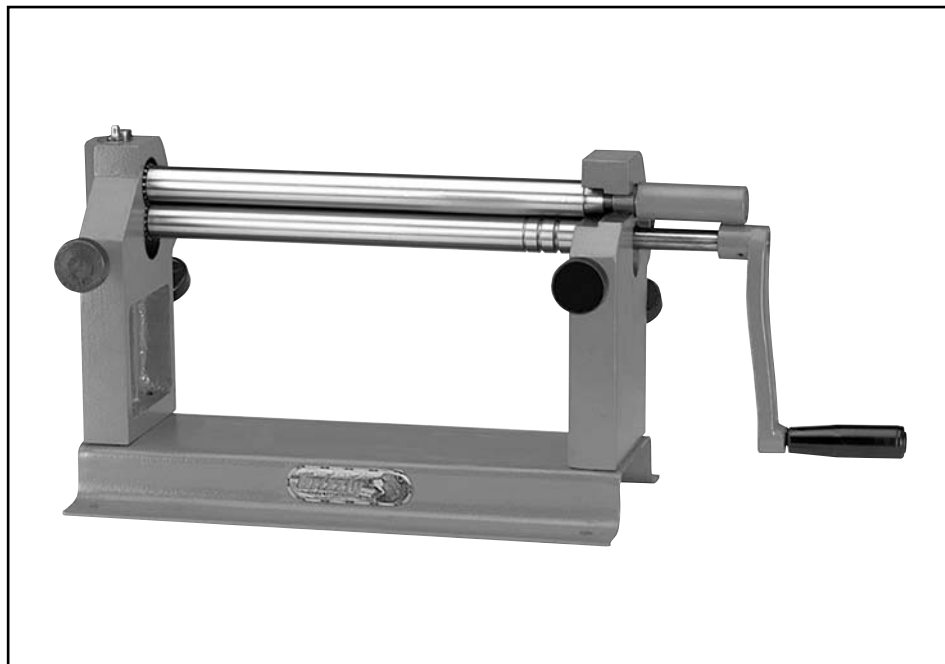


Grizzly *Industrial, Inc.*®

12" SLIP ROLL MODEL G7148 INSTRUCTION MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
PRINTED IN CHINA

SAFETY

WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment.

WARNING

Safety Instructions

1. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
2. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.
3. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
4. **NEVER FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
5. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.
6. **ALWAYS USE SAFETY GLASSES.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
7. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
8. **NEVER OVERREACH.** Keep proper footing and balance at all times.

GENERAL INFORMATION

Commentary

Grizzly Industrial, Inc. is proud to offer the Model G7148 12" Slip Roll. This tool is part of Grizzly's growing family of fine machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation.

We are also pleased to provide this manual with the Model G7148. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any criticisms that you feel we should address in our next printing, please write to us at the address below:

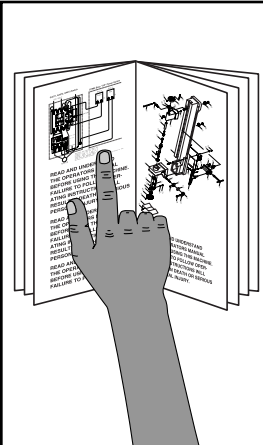
Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227

Most important, we stand behind our machines. We have an excellent service department at your disposal should the need arise.

If you have any service questions or parts requests, please call or write to us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Pennsdale, PA 17756
Phone:(570) 546-9663
Fax:(800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>

The specifications, drawings, and photographs illustrated in this manual represent the Model G7148 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.

	<p>!WARNING</p> <p>Read the manual before assembly and operation. Become familiar with the machine and its operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.</p>
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Specifications

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 3/4" x 9 1/2"




Unpacking

If you discover the slip roll is damaged after you've signed for delivery, and the truck and driver are gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for possible inspection by the carrier or its agent. Without the packing materials, filing a freight claim can be difficult. *If you need assistance determining whether you need to file a freight claim, or with the procedure to file one, please contact our Customer Service.*



Cleaning

The slip roll is covered with a protective grease for shipping purposes. Clean this with a non-solvent cleaner such as the Model G7895 Citrus Degreaser in the Grizzly catalog.

	<p>⚠ WARNING Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur.</p>
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Site Considerations

WORKBENCH LOAD

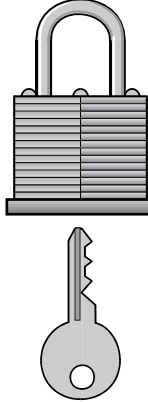
Your Model G7148 Slip Roll represents a relatively small weight load. However, the combined weight of materials and operating forces may be too much for light duty workbenches. Make sure your workbench is strong enough to handle the anticipated weight of materials and operating forces required to manipulate those materials.

WORKING CLEARANCES

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely operate your machines in any foreseeable operation.

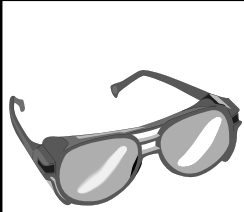
LIGHTING AND OUTLETS

Lighting should be bright enough to eliminate shadow and prevent eye strain.

	<p>⚠ CAUTION Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your area when assembling, adjusting or operating equipment.</p>
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MOUNTING & ADJUSTMENTS



! WARNING

Wear safety glasses during the entire assembly process. Failure to comply may result in serious personal injury.



! CAUTION

Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.

Mounting Slip Roll

To mount the Model G7148 you will need to provide four $\frac{5}{16}$ " bolts, nuts, lock washers, and eight flat washers. To determine the length of the bolts, add 1" to the thickness of your workbench.

1. Place the Model G7148 in the desired location on the workbench. Make sure there is enough room for the handle to move. (The handle should be positioned on the right when looking at the slip roll from the front.) Make sure there is enough room behind the slip roll to accommodate the material.
2. Mark the bench through the base, remove the slip roll, and drill $\frac{11}{32}$ " holes in the workbench.
3. Place the slip roll so the holes in the base line up with the drilled holes, and install the hardware in the following order: (1) Bolt, (2) Flat Washer, (3) Slip Roll, (4) Workbench, (5) Flat Washer, (6) Lock Washer, and (7) Nut.



Adjusting

MATERIAL THICKNESS

The distance between the fixed shaft and the front movable shaft allow for varying thicknesses of material.

To increase the gap between the fixed shaft and the front shaft, screw the front adjustment knobs counterclockwise. Make sure you adjust both knobs an equal amount. To decrease this distance, turn the knurled adjustment knobs clockwise. See **Figure 1** for control locations and part identification.

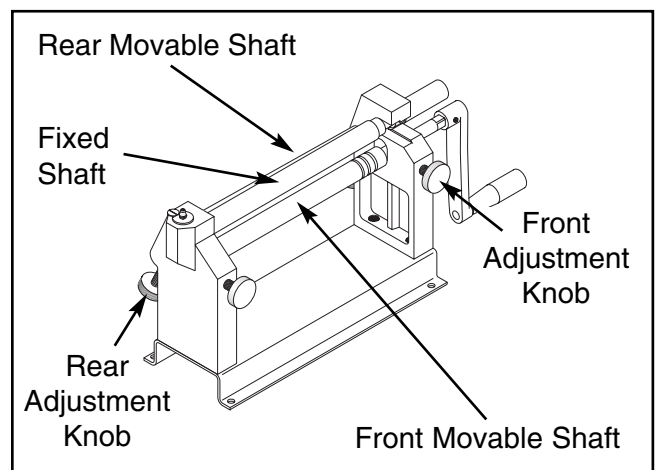


Figure 1.

ROLL DIAMETER

The distance between the fixed shaft and the rear movable shaft control the diameter of the roll.

To increase the distance between the fixed shaft and the rear movable shaft, turn the knurled adjustment knob counterclockwise. To decrease this distance, move the adjustable knobs clockwise. Make sure you adjust both knobs an equal amount.



SECTION 6: OPERATION



Using The Slip Roll

1. Perform all adjustments as required by the material thickness and whether you are engaging in straight rolls or cones.
2. Insert material edge between the fixed shaft and the front movable shaft.
3. Turn the handle to process the material.
4. If you are only performing partial rolls and need to remove the material, slide out release rod shown in **Figure 2** and pull the fixed shaft forward. You can now remove the material from the slip roll.

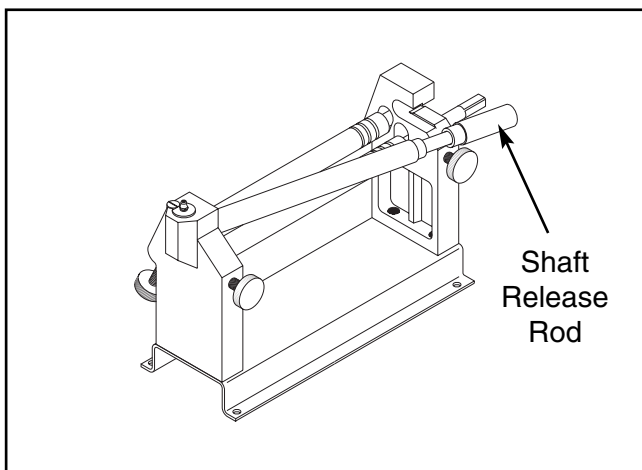


Figure 2.



Forming Wires

1. To form wires, select the smallest groove that you can use (see grooves shown in **Figure 3**) and put the edge of that wire on the groove of the front movable shaft.
2. Turn the handle to process the wire.
3. If you are only rolling part of the wire, slide out the release rod and pull the fixed shaft forward. You can now remove the wire from the slip roll.
4. If you want to form rings from wire, process the wire until the end meets the length of the stock. Remove the fixed shaft and cut the wire where the end meets it.

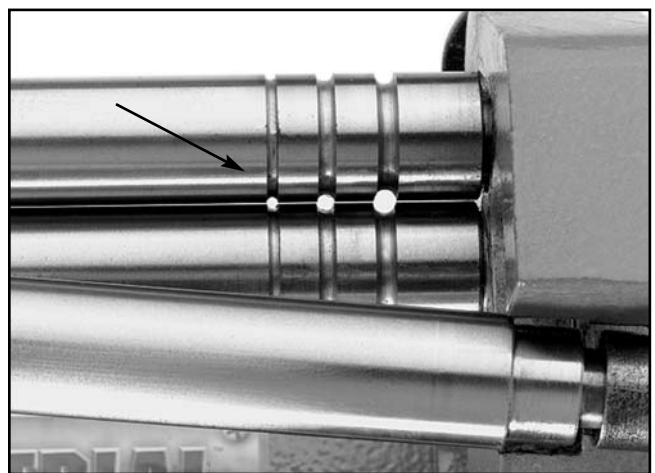


Figure 3. Wire grooves.



MAINTENANCE

Lubrication

Occasionally lubricate the gears with a medium weight wheel bearing grease through the grease fitting shown in **Figure 4**. Frequency of lubrication will depend on the amount of use.

Roller shafts should also be maintained with rust protecting oil such as Boeshield® T-9 or Model G2870/G2871 in the Grizzly catalog.

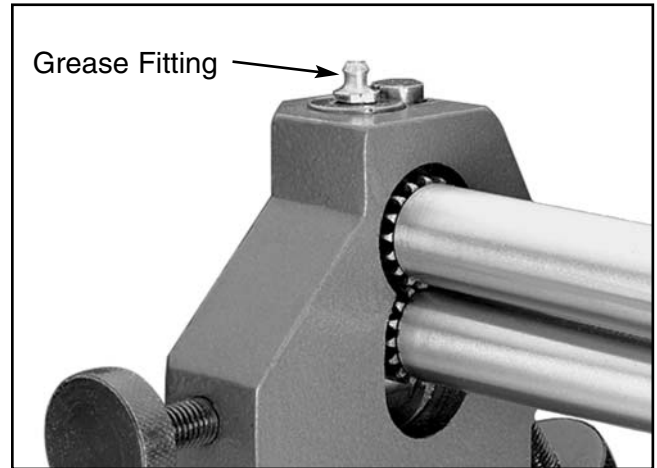


Figure 4. Grease fitting.

CLOSURE

The following pages contain general machine parts diagrams/lists, and Warranty/Return information for your Model G7148 12" Slip Roll.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the **General Information** section. The specifications, drawings, and photographs illustrated in this manual represent the Model G7148 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to the operation of this tool. While most safety measures are generally universal, Grizzly reminds you that each work-

shop is different and safety rules should be considered as they apply to your specific situation.

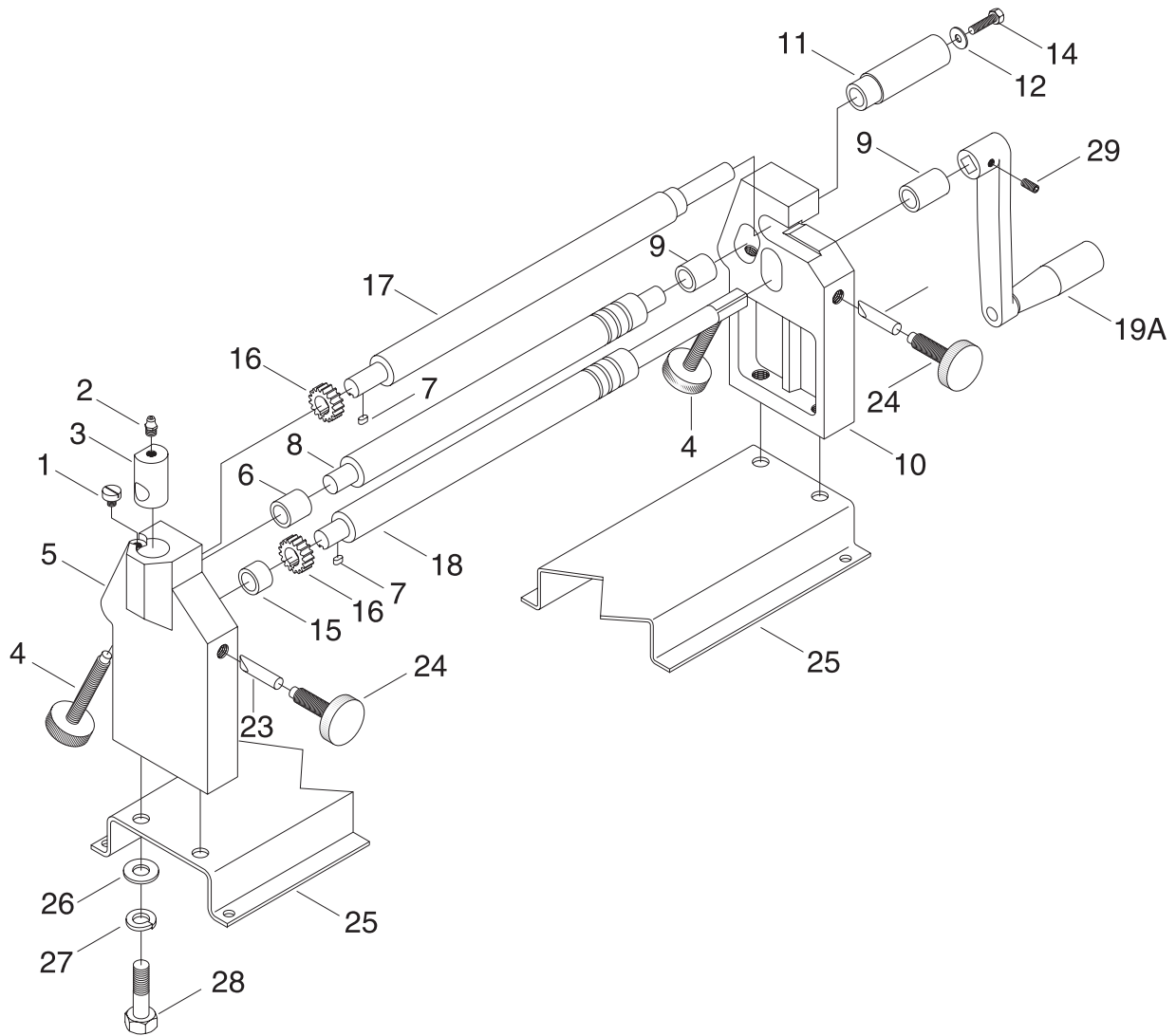
We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department listed in the **General Information** section.

Additional information sources are necessary to realize the full potential of this machine. Trade magazines, books and formal training are good sources to begin with.

WARNING

DO NOT MODIFY AND/OR USE THIS MACHINE FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty. If you are confused about any aspect of this machine, DO NOT use it until all your questions have been answered, or serious personal injury may occur.





REF	PART #	DESCRIPTION
01	P7148001	Adjustment Screw
02	P7148002	Grease Cup
03	P7148003	Rotating Support
04	P7148004	Adjustment Knob
05	P7148005	Left Stand
06	P7148006	Bushing
07	P7148007	Flat Key 4 x 8
08	P7148008	Rear Movable Shaft
09	P7148009	Handle Shaft
10	P7148010	Right Stand
11	P7148011	Release Rod
12	PW03M	Flat Washer 6mm
14	PS11M	Screw M6-1 x 16

REF	PART #	DESCRIPTION
15	P7148015	Bushing
16	P7148016	Gear
17	P7148017	Fixed Shaft
18	P7148018	Front Movable Shaft
19A	P7148019A	Handle Assembly
23	P7148023	Pin
24	P7148024	Adjustment Knob
25	P7148025	Base
26	PW04M	Flat Washer 10mm
27	PLW06M	Lock Washer 10mm
28	PB047M	Hex Bolt M10-1.25 x 20
29	PSS02M	Setscrew M6-1 x 6

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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