

Grizzly[®]

Industrial, Inc.

MODEL T10727

12" VISE-MOUNT SLIP ROLL

OWNER'S MANUAL

(For models manufactured since 12/12)



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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.**
#TS15554 PRINTED IN CHINA

 **WARNING!**

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

 **WARNING!**

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Machine Description

The Model T10727 is a 12" slip roll that mounts in a sturdy bench-mounted vise instead of being directly fastened to a workbench. This provides you with the strength and stability you need when forming sheet metal—without sacrificing precious workbench space or requiring time-consuming setups before operating.

The slip roll has three specially positioned metal rollers to make bends, cones, and cylinders from sheet metal. The rollers have grooves at one end that also allow wire to be rolled into various circles or curves.

The slip roll has a hand crank on one end that the operator uses to rotate the rollers as they feed the sheet metal into the slip roll. Two sets of adjustment knobs allow the operator to adjust the spacing distance between certain rollers to either control the radius of ends or accommodate varying thicknesses of sheet metal or wire.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

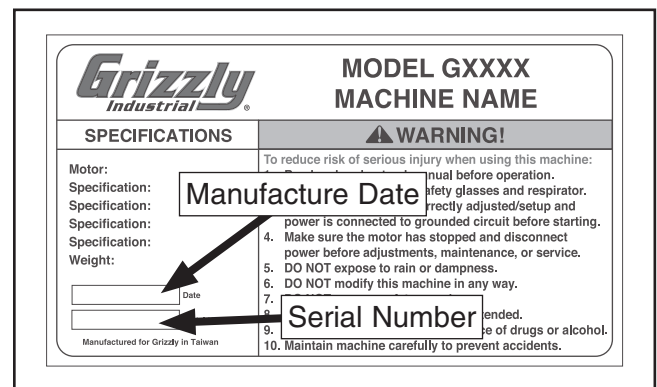
Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

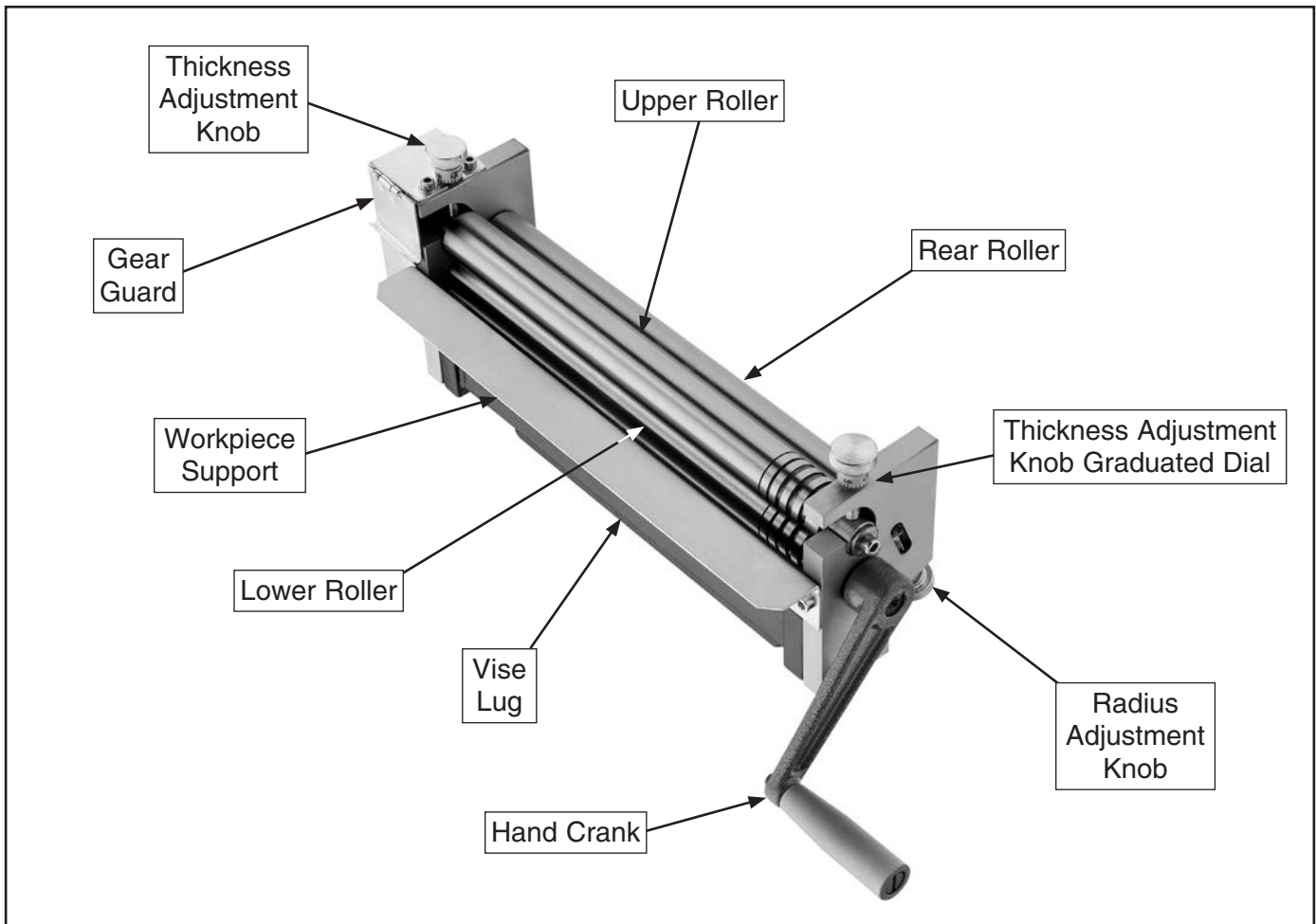
We made every effort to be exact with the instructions, specifications, drawings, and photographs contained inside. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive will be slightly different than what is shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused about a procedure, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

Alternatively, you can call our Technical Support for help. Before calling, please write down the **Manufacture Date** and **Serial Number** stamped into the machine ID label (see below). This information helps us determine if updated documentation is available for your machine.



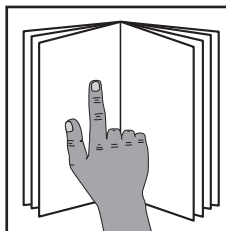
Identification



Specifications

Maximum Forming Width 12"
 Maximum Forming Capacity ... 20 Ga. Mild Steel
 Number of Wire Grooves..... 5
 Wire Groove Sizes..... $\frac{3}{16}$ " , $\frac{5}{32}$ " , $\frac{1}{8}$ " , $\frac{1}{16}$ " , $\frac{1}{32}$ "

Roller Diameters..... $1\frac{3}{16}$ "
 Minimum Forming Diameter $1\frac{3}{4}$ "
 Weight 22 lbs.



!WARNING

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

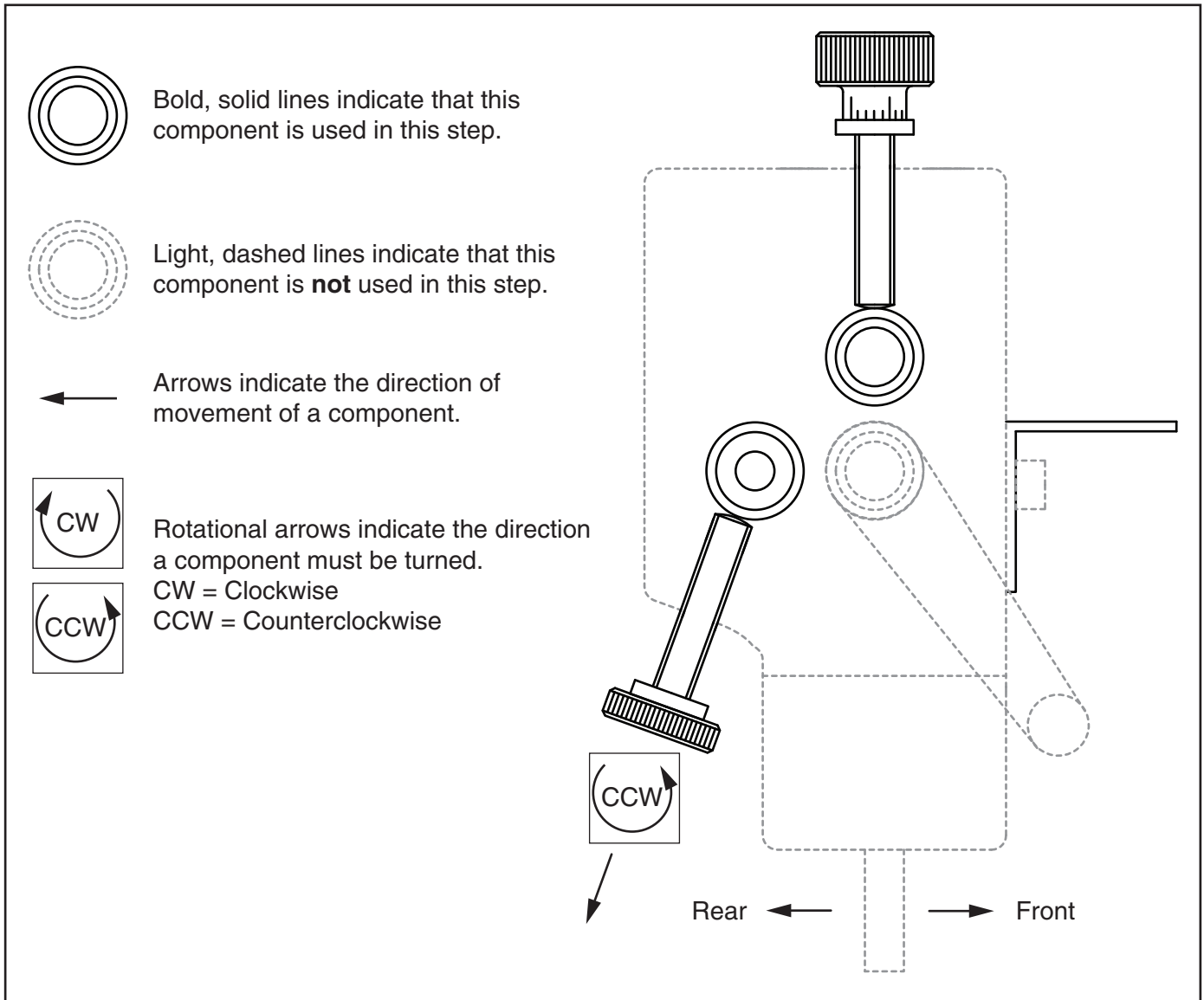


Illustration Key

Throughout this manual, illustrations are used to explain how the components of the slip roll are used during the various steps of operation.

Familiarize yourself with the following illustration, its relationship to the slip roll, and the symbols used in it before proceeding through this manual.

We recommend book marking this page so you can quickly turn back to it as a reference.



SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words 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. Always use common sense and good judgment.



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 machine.

Safety Instructions for Machinery

WARNING

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

INTENDED USAGE. Only use machine for its intended purpose and never make modifications not approved by Grizzly. Modifying machine or using it differently than intended may result in malfunction or mechanical failure that can lead to serious personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.



WARNING

Additional Safety for Slip Rolls

OVERLOADING. Overloading this machine can cause injury from flying parts or property damage. Do not exceed the machine capacities.

SECURING SLIP ROLL. Before using, secure the slip roll to a sturdy vise that is securely fastened to a workbench that can support the weight and dynamic forces involved in forming sheet metal. Otherwise, the slip roll may unexpectedly move or fall, causing serious injury or property damage.

METAL EDGES. Sharp edges on sheet metal can result in severe cuts. Always wear leather gloves before handling sheet metal, and chamfer and debur edges.

TOOLS IN POOR CONDITION. Using the slip roll with loose or damaged hardware could result in sudden, uncontrolled movements during use. Inspect the slip roll for any cracked linkage, controls, or loose fasteners. Correct any problems before use.

GLOVES AND GLASSES. Always wear leather gloves and approved safety glasses when using the slip roll.

HEATING METAL. Heating the workpiece with a torch while it is in the slip roll will weaken the metal of the rollers and the frame. Do not use a torch or other similar heating tool near the slip roll.

BACK INJURIES. The cranking motion required to operate this slip roll is potentially harmful if proper technique is not used. To avoid back injuries, keep your back vertical and never over-exert yourself or operate the slip roll in awkward positions.

CRUSHING & PINCHING INJURIES. Slip rolls can quickly crush or pinch fingers or hands. Never place fingers or hands between or near the rollers during operation.

WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



SECTION 2: SETUP

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

| Description | Qty |
|---|-----------|
| • Cleaner/Degreaser (Page 9) | As Needed |
| • Disposable Shop Rags..... | As Needed |
| • Sturdy Workbench..... | 1 |
| • Sturdy Vise Secured to Workbench | 1 |
| • Standard Screwdriver #2..... | 1 |
| • Hex Wrench 5mm..... | 1 |

Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

| Shipping Inventory: (Figure 1) | Qty |
|--------------------------------|-----|
| A. Slip Roll Assembly | 1 |
| B. Crank Handle | 1 |
| C. Workpiece Support..... | 1 |

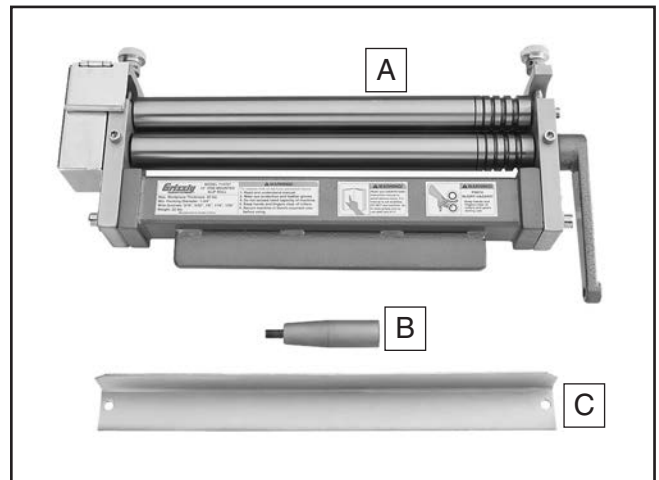


Figure 1. Model T10727 shipping inventory.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

Site Considerations

Workbench Load

Refer to **Specifications** on **Page 3** for the weight of your machine. Some workbenches may require additional reinforcement to support both the machine and materials.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 2** for the minimum working clearances.

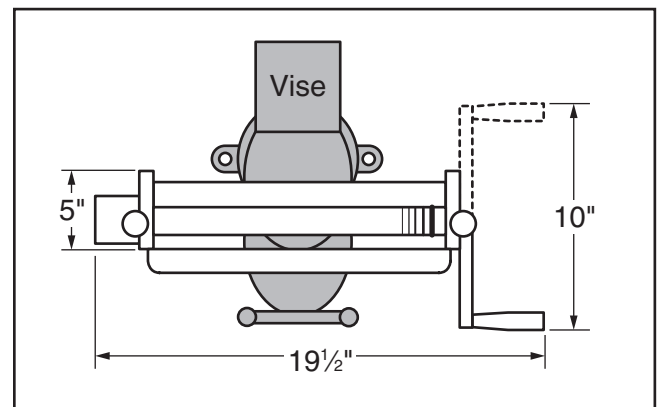
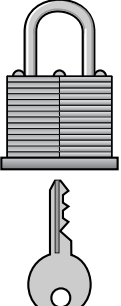


Figure 2. Minimum working clearances.

| | |
|--|--|
|  | <p>CAUTION</p> <p>Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p> |
|--|--|



Assembly

Except for the crank handle and the workpiece support, the Model T10727 has been assembled and adjusted at the factory.

To complete the assembly:

1. Thread the handle into the crank arm and tighten with a screwdriver, as shown in **Figure 3**.

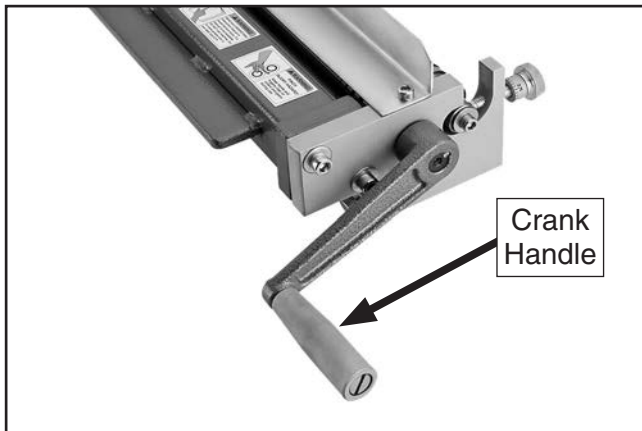


Figure 3. Crank handle attached.

2. Attach the workpiece support to the front of the slip roll with the two pre-installed M6-1 x 12 cap screws, as shown in **Figure 4**.

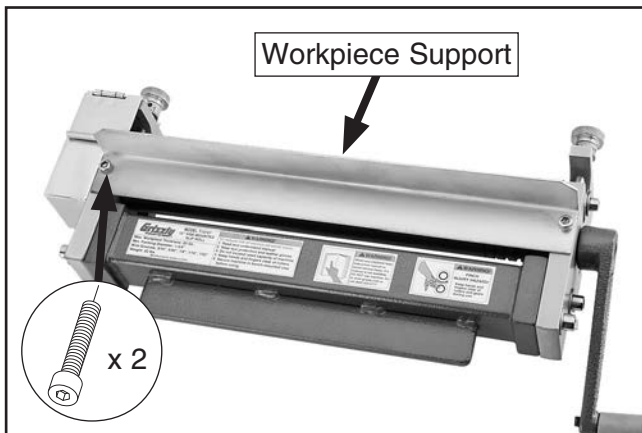


Figure 4. Workpiece support attached.

Mounting in Vise

The forces exerted on the slip roll during operation are substantial. The slip roll must be firmly secured in a vise (see **Figure 5** for an example) that is solidly attached to a workbench that will support the weight and dynamic forces of the operation (refer to **Page 18** for options from Grizzly).

Make sure you have a vise secured to a workbench, then mount the slip roll by tightening the vise jaws against the lug provided at the bottom of the slip roll.

Note: Use pieces of cardboard, wood, or padded jaw faces between the vise jaws and the vise lug to prevent damage to the slip roll.

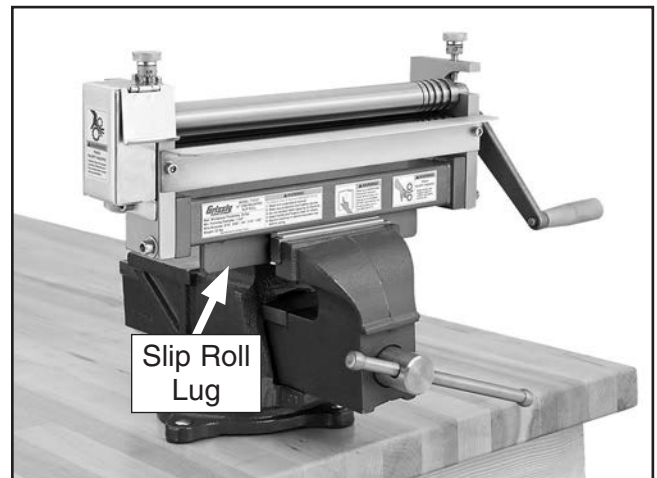


Figure 5. Example of Model T10727 secured in a vise mounted to a workbench.

⚠ CAUTION

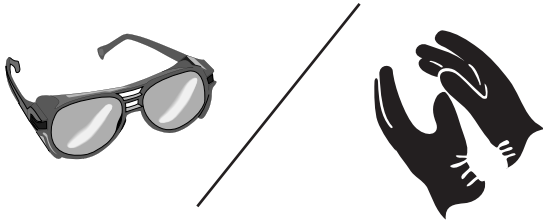
Make sure the workbench that the slip roll is mounted on is stable and can support the weight of the tool, the workpiece, and the forces exerted during operation.



SECTION 3: OPERATIONS

! WARNING

Damage to your eyes or hands could result from using this slip roll without proper protective gear. Always wear safety glasses and leather gloves when operating this slip roll.



! CAUTION

Sharp edges of sheet metal can easily cut fingers, hands, or arms. Always wear leather gloves when handling sheet metal, and always chamfer and debur the edges.



NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Controls

Use the descriptions below and **Figure 6** below to become familiar with the basic controls and components of the slip roll.

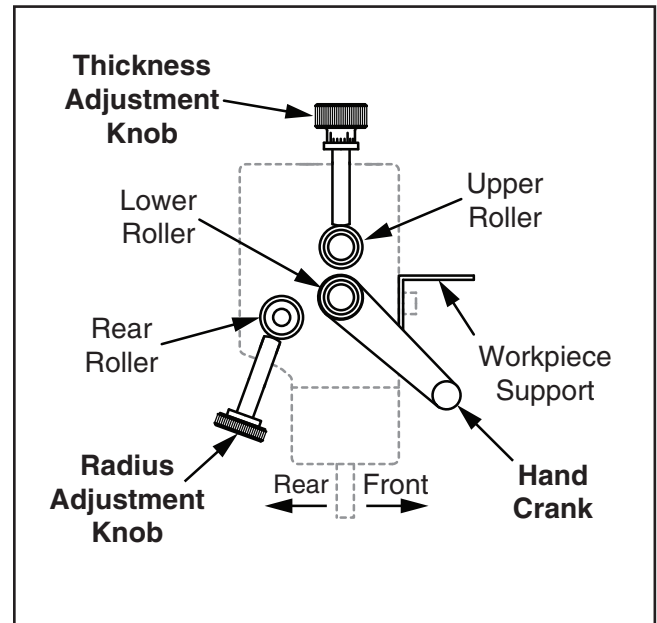


Figure 6. Model T10727 basic controls and components.

Thickness Adjustment Knob. Raises and lowers the upper roller to adjust for the thickness of different workpieces. The graduated dial has 0.05mm increments with one full revolution equaling 1.25mm of upper roller movement.

Radius Adjustment Knob. Raises and lowers the rear roller to create smaller and larger radius bends.

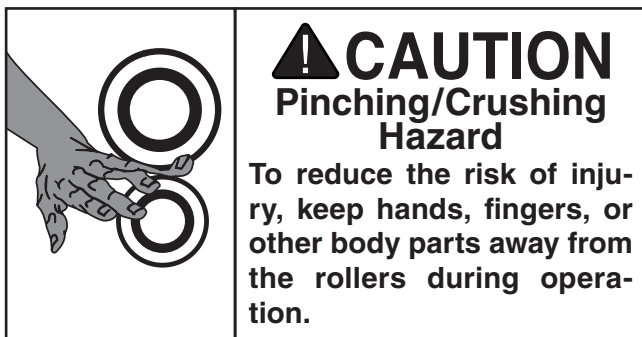
Hand Crank: Rotates the rollers to feed the workpiece through the machine.



Flat Rolling

The Model T10727 Slip Roll can be used to flat roll sheet metal up to 20 gauge mild steel. This is done to flatten or slightly reduce the thickness of workpieces.

When you raise and lower the upper roller with the thickness adjustment knobs, it is important to keep the upper and lower rollers parallel by adjusting the knobs in even amounts. This keeps the space and pressure even along the length of the rollers.



To flat roll a workpiece:

1. Rotate the radius adjustment knob clockwise to lower the rear roller below the workpiece path, as illustrated in **Figure 7**. This will prevent the rear roller from bending a curve in the workpiece as it is fed through the slip roll.

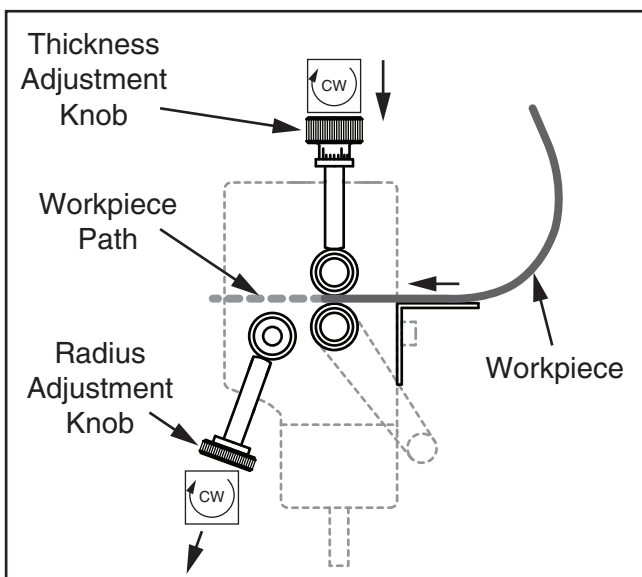


Figure 7. Workpiece positioned between the upper and lower rollers.

2. Use the thickness adjustment knobs to adjust the height of the upper roller so the workpiece fits between the upper and lower rollers, as illustrated in **Figure 7**.
3. Rotate the thickness adjustment knobs clockwise in even amounts to lower the upper roller until the workpiece is held snug between the rollers.
4. Turn the hand crank counterclockwise to back the workpiece out of the rollers. Set the workpiece aside for now.
5. Rotate the thickness adjustment knobs clockwise five increments on the dials (0.25mm) to slightly lower the upper roller and increase roller pressure.
6. Place the front of the workpiece on the workpiece support. Slowly rotate the hand crank clockwise to feed the workpiece through the rollers, as illustrated in **Figure 8**.

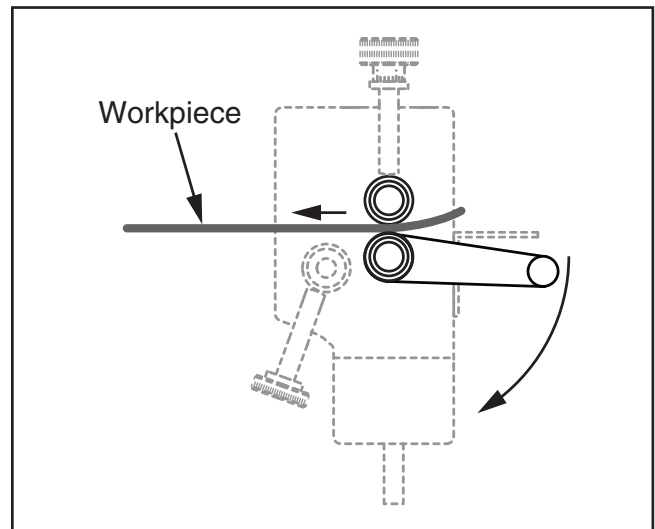


Figure 8. Workpiece fed between the rollers to flatten it.

7. Repeat **Steps 5–6** as necessary until you are satisfied with the results.



Creating Bends

The Model T10727 Slip Roll can easily create constant-radius bends in sheet metal up to 20 gauge.

Note: *The method for creating a specific radius is a trial-and-error process. Due to the many variations among metal workpieces, no single positioning will create the same curve on all materials. We recommend that you experiment with scrap material before using the actual workpiece until you find the settings that will achieve your desired curve.*

To create a bend in a workpiece:

1. Use the thickness adjustment knobs to adjust the height of the upper roller so that you can place the workpiece between the upper and lower rollers, as illustrated in **Figure 9**.

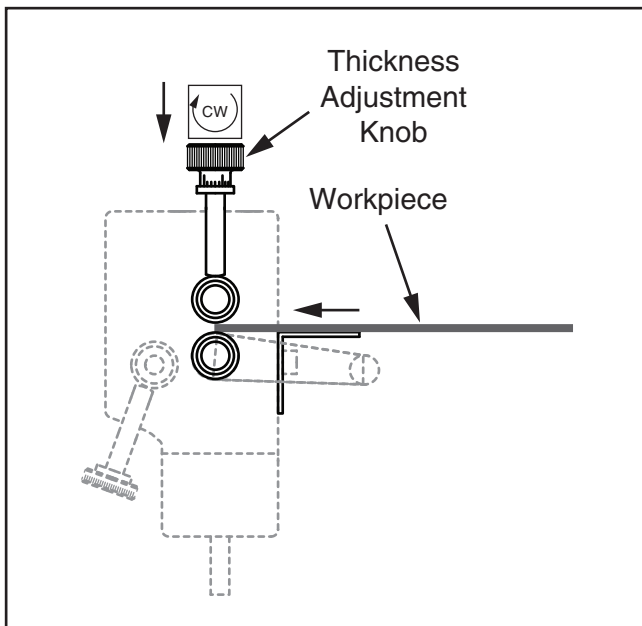
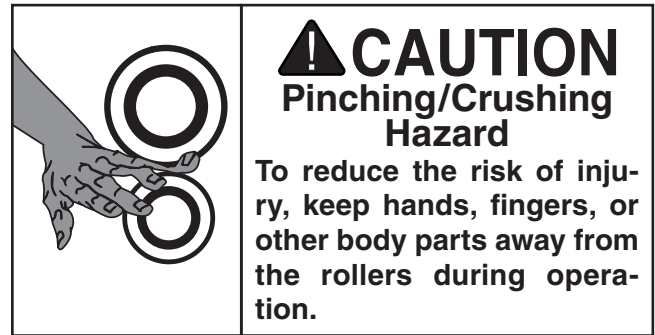


Figure 9. Workpiece positioned for bending.

2. Turn the thickness adjustment knobs clockwise to lower the upper roller until the workpiece is held snug between the rollers.

Be sure to turn the thickness adjust knobs equal amounts to keep the space and pressure between the rollers even.



3. Turn the hand crank clockwise to feed the workpiece until its leading edge is just above the rear roller, as illustrated in **Figure 10**.

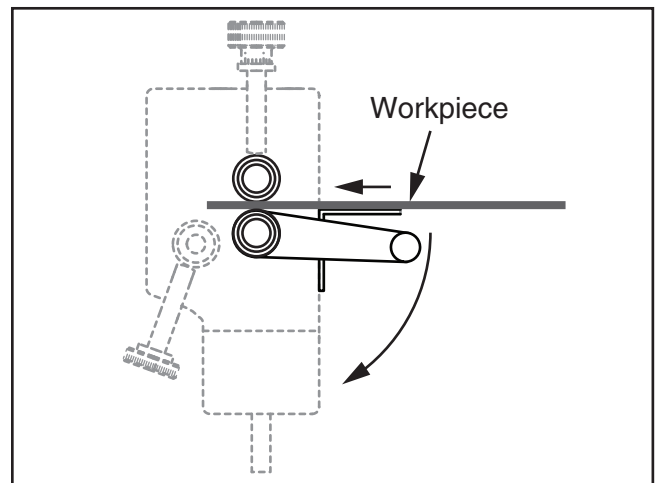


Figure 10. Leading edge of workpiece above rear roller.

Continued on next page →



- Rotate the radius adjustment knobs counterclockwise to raise the rear roller until the desired radius bend is reached (see **Figure 11**).

Note: You must turn the radius adjustment knobs in equal amounts so the rear roller is always parallel with the other rollers. Otherwise, a larger radius will be created on one end of the workpiece, resulting in a cone or spiral shape.

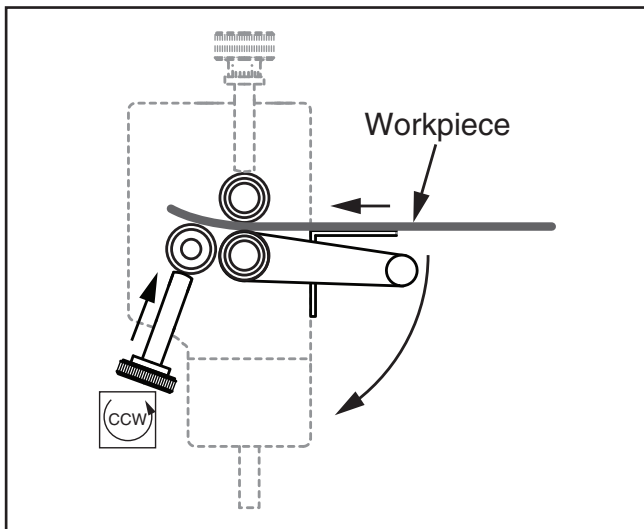


Figure 11. Setting the bend radius.

- Rotate the hand crank clockwise to feed the workpiece completely through the rollers and produce the bend (see **Figure 12**).

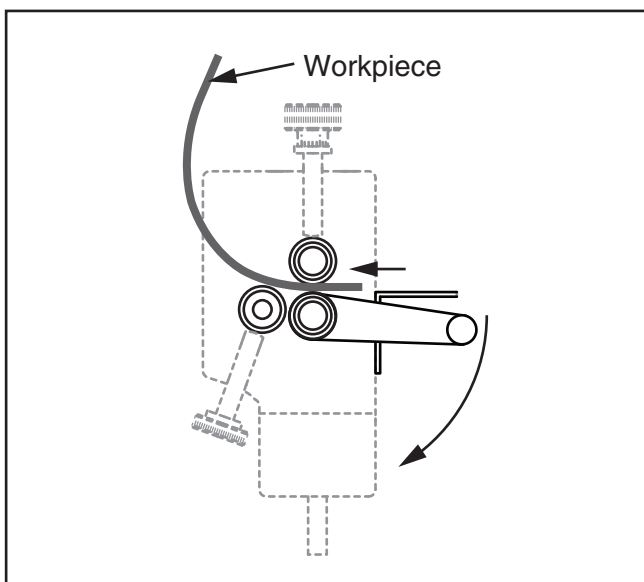


Figure 12. Forming the bend.

Creating Cylinders

The Model T10727 Slip Roll can be used to easily and accurately create cylinders.

To make sure the ends of the completed cylinder meet correctly, use the formula below to calculate the required beginning workpiece length.

$$C = \pi D$$

C = Circumference
(Length of Material Needed)

π = Pi (Approximately 3.142)

D = Diameter of Cylinder

Example: Suppose you want to create a 6" diameter cylinder. You would use the above formula as follows:

$$\begin{aligned} C &= \pi D \\ C &= 3.142 \times 6" \\ C &= 18.852" \end{aligned}$$

The result of 18.852" indicates that you need to start with a piece of sheet metal that is approximately 18.852" in length in order to create a 6" diameter cylinder.

You can use the slip roll to create a bend with the correct radius so that the two ends meet, forming a 6" diameter cylinder (see **Figure 13**).

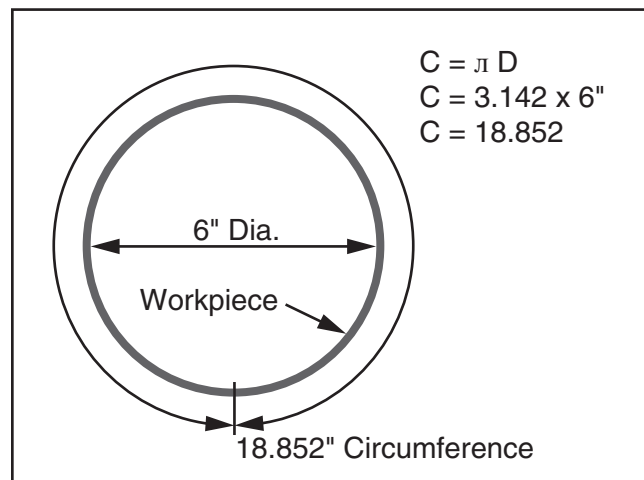


Figure 13. Cylinder calculation example.



Once you have the necessary workpiece length, follow the steps below to create the cylinder.

Note: The method for creating a specific radius for a cylinder is a trial-and-error process. Due to the many variations among metal workpieces, no single positioning will create the same curve on all materials. We recommend that you experiment with scrap material before using the actual workpiece until you find the settings that will achieve your desired cylinder.

To create a cylinder:

1. Use the thickness adjustment knobs to adjust the height of the upper roller so that you can place the workpiece between the upper and lower rollers, as illustrated in **Figure 14**.

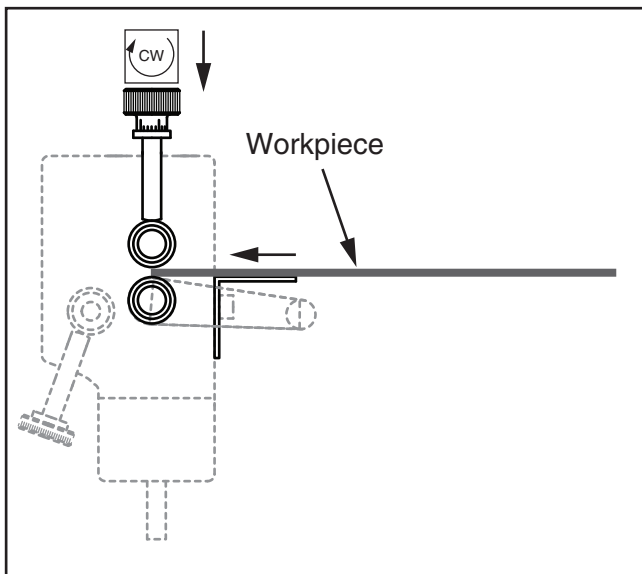


Figure 14. Workpiece positioned for creating a cylinder.

2. Turn the thickness adjustment knobs clockwise to lower the upper roller until the workpiece is held snug between the rollers.

Be sure to turn the thickness adjust knobs equal amounts to keep the space and pressure between the rollers even.

NOTICE

In the following step, always err on the side of making the cylinder too large rather than too small. It is easy to decrease the radius of a cylinder later, but very difficult to increase the radius.

3. Rotate the hand crank clockwise to feed the workpiece until it is approximately half way through the rollers.
4. Rotate the radius adjustment knobs counterclockwise to raise the rear roller for the desired cylinder radius, as illustrated in **Figure 15**.

Note: You must turn the radius adjustment knobs in equal amounts so the rear roller is always parallel with the other rollers. Otherwise, a larger radius will be created on one end of the workpiece than the other, resulting in a cone or spiral shape.

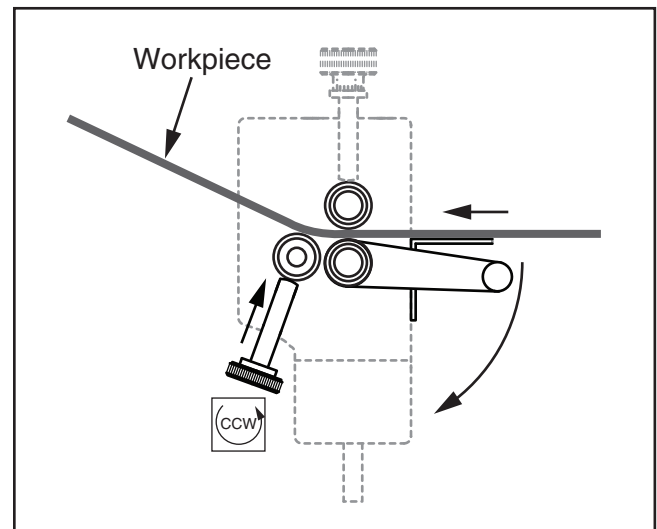


Figure 15. Initial cylinder bend.



5. Rotate the hand crank clockwise to feed the workpiece until it is completely through the rollers, as illustrated in **Figure 16**.

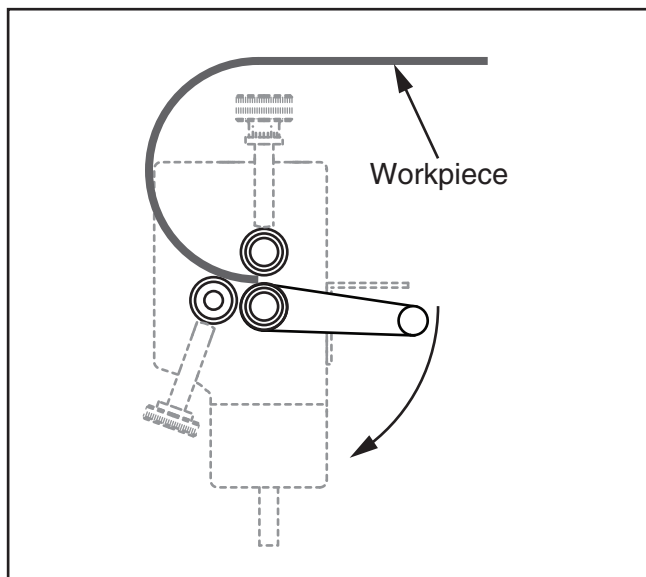


Figure 16. First bend completed.

6. Rotate the workpiece 180°, then insert the curved end back into the slip roll, as illustrated in **Figure 17**.

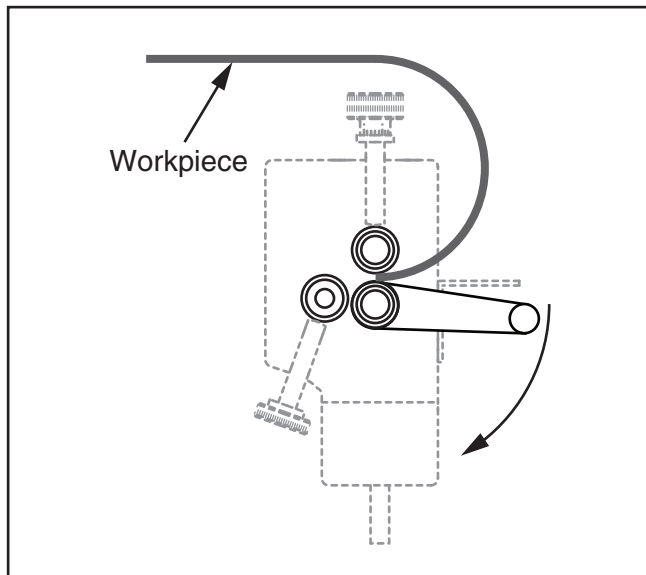


Figure 17. Re-inserting workpiece to complete the cylinder.

7. Continue to feed the workpiece through the rollers until the cylinder is formed, as illustrated in **Figure 18**.

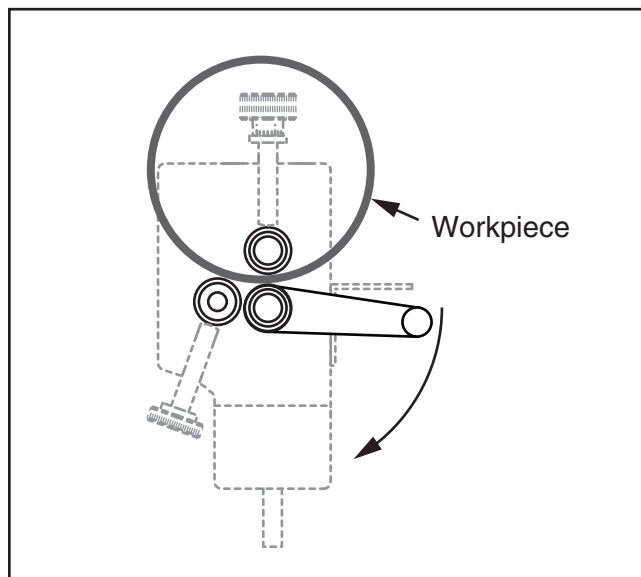


Figure 18. Completing the cylinder.

—If the ends of the cylinder do not meet, equally raise the rear roller at both ends a small amount, then process the entire cylinder through the slip roll again. Repeat as necessary.

—If the ends of the cylinder overlap, remove the cylinder from the upper roller (refer to **Removing Workpiece** on **Page 17** for detailed instructions). Then, either attempt to increase the radius by manually bending it and reprocessing it, or scrap the workpiece and start again.

8. Remove the workpiece from the upper roller, as described in the **Removing Workpiece** subsection on **Page 17**.



Bending Wire

The Model T10727 Slip Roll has five matching grooves on the upper and lower rollers (see **Figure 19**) for bending wire, rods, and small tubing in diameters of $\frac{3}{16}$ ", $\frac{5}{32}$ ", $\frac{1}{8}$ ", $\frac{1}{16}$ ", and $\frac{1}{32}$ ".



Figure 19. Roller grooves in five diameters.

To use the grooves:

1. Place your workpiece into the smallest possible groove on the wheel.

Example: Suppose you want to bend a piece of $\frac{3}{32}$ " diameter rod. Though it would fit in the $\frac{3}{16}$ " and $\frac{5}{32}$ " grooves, you would use the $\frac{1}{8}$ " groove since it is the smallest possible groove that the rod will fit into.

2. Create bends in the workpiece as described in **Creating Bends** on **Page 13**, or create loops as described in **Creating Cylinders** on **Page 14**.

NOTICE

The roller grooves can also be used when forming sheet metal that has a wire bead at one end.

Removing Workpiece

A completed workpiece that does not have an opening wide enough to roll it off the slip roll can be removed by lifting the upper roller from the brackets.

To remove cylindrical workpieces:

1. Rotate both thickness adjustment knobs so that the threads no longer protrude into the roller bushing space, as shown in **Figure 20**.

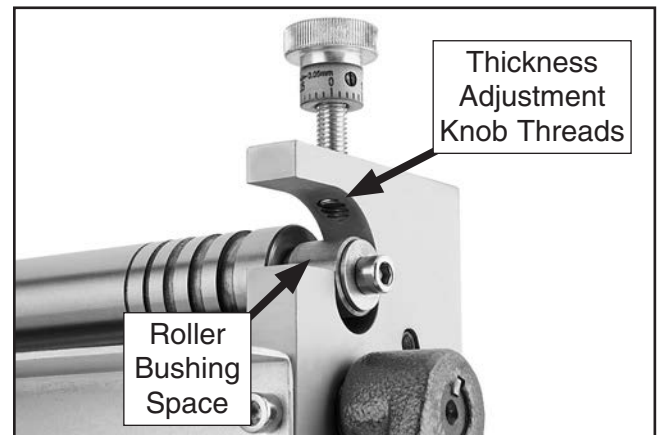


Figure 20. Thickness adjustment knob unthreaded from bushing space.

2. Lift the gear guard cover (see **Figure 21**), then lift the upper roller up and out from the slip roll frame. Take care not to displace the compression springs underneath the bushings.

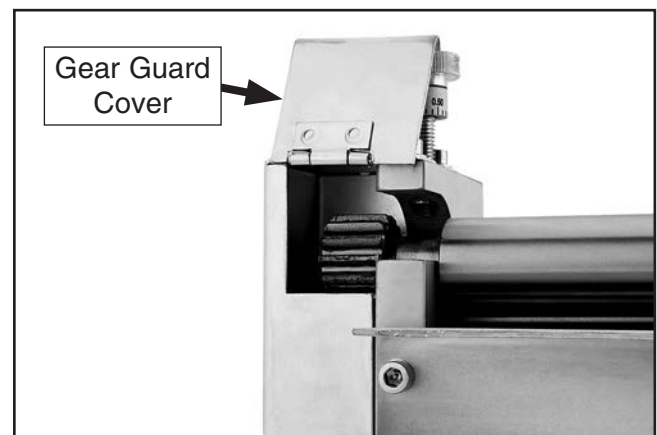


Figure 21. Gear guard cover opened.

3. Remove the workpiece, then re-install the upper roller with the gears meshed.



SECTION 4: ACCESSORIES

! WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

Super Heavy-Duty Birch Workbench

H8361—60" x 30"

H8362—72" x 36"

Sized to fit the needs of any shop, these Super Heavy-Duty Birch Workbenches have solid 3" thick tops that stand 38" above the floor. The end vise measures 14³/₄" wide (H8361) or 17³/₄" wide (H8362) and has a 7" maximum capacity. Stable laminated birch provides strength and durability. You'll be proud to have this workbench in your shop!



Figure 22. Super Heavy-Duty Birch Workbench.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz Spray

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

H3788—G96® Gun Treatment 12 oz Spray

H3789—G96® Gun Treatment 4.5 oz Spray



Figure 23. Recommended products for protecting unpainted cast iron/steel part on machinery.

Heavy-Duty Bench Visas with Anvils

G7059—5", 45 lbs.

G7060—6", 68 lbs.

These tough vises are ideal for all bench work applications. Large machined center slide keeps jaws aligned under maximum pressure. Other features include large Acme screws, anvil faces, and 0°–90° swivel.



Figure 24. Heavy-Duty Bench Vise with Anvil.

order online at www.grizzly.com or call 1-800-523-4777



SECTION 5: MAINTENANCE

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Any other unsafe condition.

Weekly Maintenance:

- Clean machine.
- Lubricate roller gears.
- Lubricate roller bushings.

Cleaning & Protecting

Cleaning the Model T10727 is relatively easy. Periodically wipe down the rollers to remove dust and debris—this ensures rust-promoting material does not remain on the bare metal surfaces.

Treat all unpainted metal surfaces with quality metal protectants like SLIPIT®, or Boeshield® T-9 (see previous page for offerings from Grizzly).

Lubrication

Lubricating the Model T10727 Slip Roll consists of periodically (depending upon usage) applying grease to the roller gears and oil to the roller bushings.

Roller Gears

Lift the gear guard cover and apply a dab of white lithium grease to the upper roller gear (see **Figure 25**). Rotate the hand crank several times in both directions to distribute the grease to both gears, then wipe away any excess and close the cover.

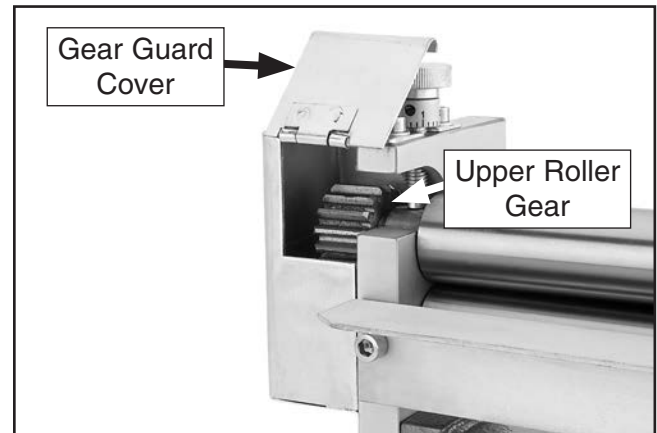


Figure 25. Upper roller gear exposed.

Roller Bushings

Use an oil can to apply a few drops of light machine oil to the brass bushings at the either end of the three rollers (see **Figure 26**). Rotate the hand crank several times in both directions to distribute the oil, then wipe away any excess.

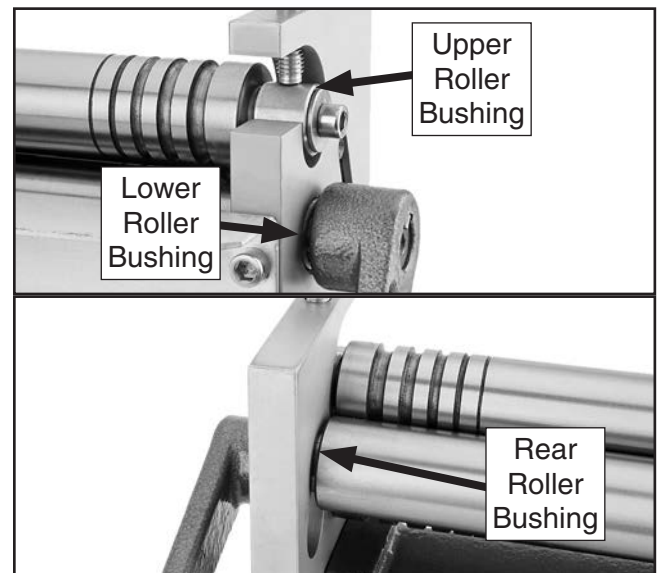


Figure 26. Roller bushings (one on either end of each roller).



SECTION 6: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

Note: Please gather the serial number and manufacture date of your machine before calling.

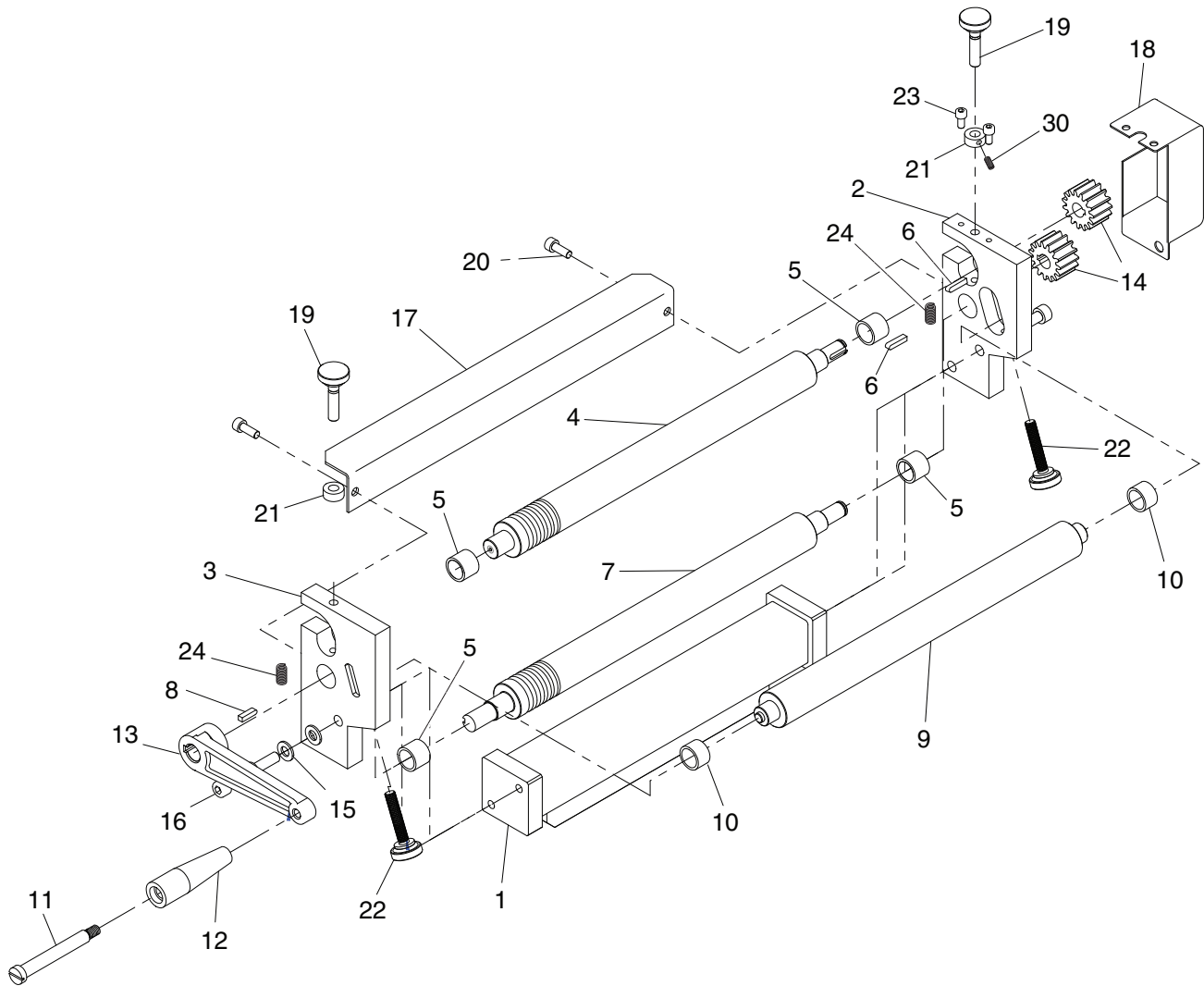
Troubleshooting

| Symptom | Possible Cause | Possible Solution |
|--|---|--|
| Slip roll creates cones when trying to create cylinders. | 1. Rollers are not parallel. | 1. Use thickness and radius adjustment knobs to make sure all rollers are parallel with each other. |
| A noticeable crease is formed in workpiece. | 1. Excessive pressure applied in one spot. | 1. Raise upper roller to reduce pressure; create form in multiple light passes. |
| Hand crank does not turn upper and lower rollers. | 1. Upper roller too high, gears not meshed. 2. Gears damaged. | 1. Use thickness adjustment knobs to lower upper roller until gears mesh. 2. Replace gears. |
| Slip roll does not properly bend material. | 1. Slip roll capacity exceeded. 2. Rear roller not engaged with workpiece. | 1. Use material within slip roll forming capacity. 2. Use radius adjustment knobs to engage rear roller with workpiece. |



SECTION 7: PARTS

Main



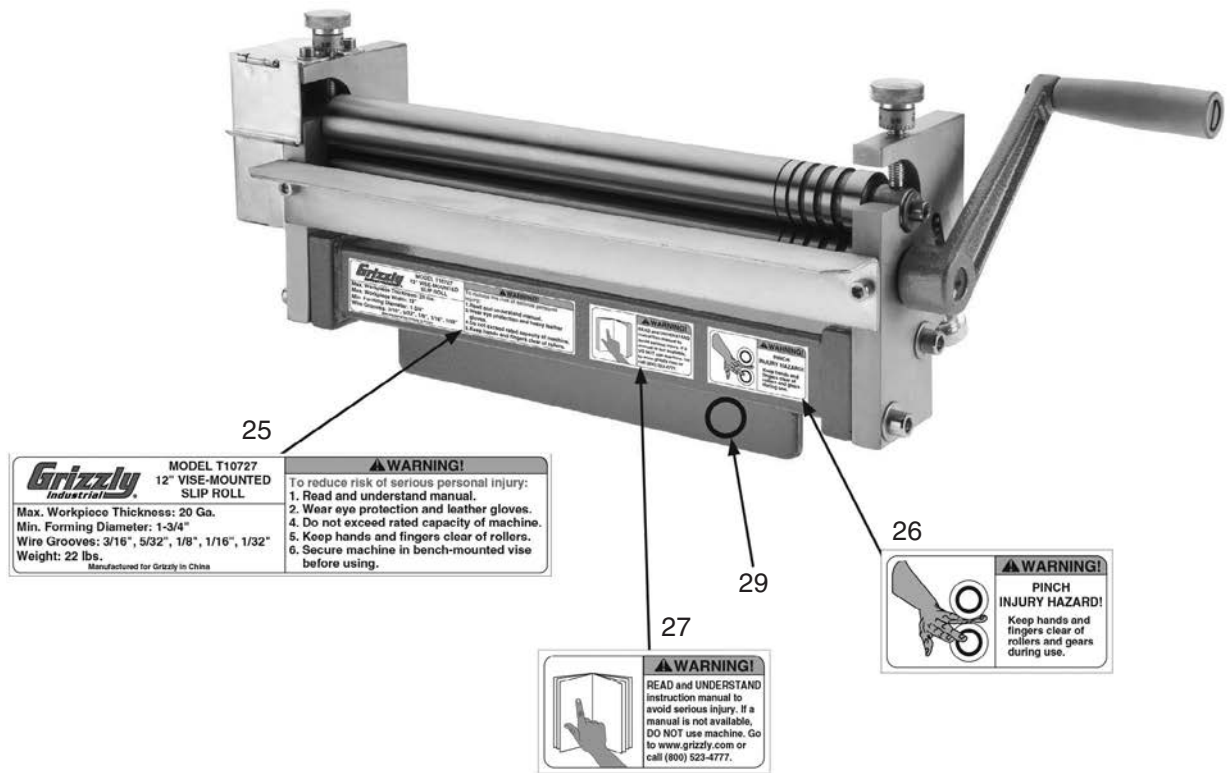
| REF | PART # | DESCRIPTION |
|-----|------------|------------------------------------|
| 1 | PT10727001 | BASE |
| 2 | PT10727002 | LEFT ROLLER BRACKET |
| 3 | PT10727003 | RIGHT ROLLER BRACKET |
| 4 | PT10727004 | UPPER ROLLER |
| 5 | PT10727005 | UPPER/LOWER ROLLER BRASS BUSHING |
| 6 | PK48M | KEY 4 X 4 X 20 |
| 7 | PT10727007 | LOWER ROLLER |
| 8 | PK37M | KEY 4 X 4 X 16 |
| 9 | PT10727009 | REAR ROLLER |
| 10 | PT10727010 | REAR ROLLER BRASS BUSHING |
| 11 | PT10727011 | HANDLE SHOULDER SCREW M8-1.25 X 15 |
| 12 | PT10727012 | CRANK HANDLE |
| 13 | PT10727013 | CRANK |

| REF | PART # | DESCRIPTION |
|-----|------------|---------------------------------|
| 14 | PT10727014 | ROLLER GEAR 15T |
| 15 | PW01M | FLAT WASHER 8MM |
| 16 | PCAP31M | CAP SCREW M8-1.25 X 25 |
| 17 | PT10727017 | WORKPIECE SUPPORT |
| 18 | PT10727018 | GEAR GUARD ASSEMBLY |
| 19 | PT10727019 | KNURLED KNOB SCREW M8-1.25 X 35 |
| 20 | PCAP26M | CAP SCREW M6-1 X 12 |
| 21 | PT10727021 | GRADUATED DIAL |
| 22 | PT10727022 | KNURLED KNOB SCREW M8-1.25 X 40 |
| 23 | PCAP50M | CAP SCREW M5-.8 X 10 |
| 24 | PT10727024 | COMPRESSION SPRING |
| 30 | PT10727030 | SLOTTED SET SCREW M4-.7 X 4 |

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.



Labels & Cosmetics



Grizzly Industrial
MODEL T10727
12" VISE-MOUNTED
SLIP ROLL
 Max. Workpiece Thickness: 20 Ga.
 Min. Forming Diameter: 1-3/4"
 Wire Grooves: 3/16", 5/32", 1/8", 1/16", 1/32"
 Weight: 22 lbs.
Manufactured for Grizzly in China

WARNING!
 To reduce risk of serious personal injury:
 1. Read and understand manual.
 2. Wear eye protection and leather gloves.
 4. Do not exceed rated capacity of machine.
 5. Keep hands and fingers clear of rollers.
 6. Secure machine in bench-mounted vise before using.

WARNING!
PINCH INJURY HAZARD!
 Keep hands and fingers clear of rollers and gears during use.

WARNING!
 READ and UNDERSTAND instruction manual to avoid serious injury. If a manual is not available, DO NOT use machine. Go to www.grizzly.com or call (800) 523-4777.

WARNING!
PINCH INJURY HAZARD!
 Always keep this guard properly attached and the access door closed during operation.



| REF | PART # | DESCRIPTION |
|-----|------------|---------------------------|
| 25 | PT10727025 | MACHINE ID LABEL |
| 26 | PT10727026 | PINCH INJURY HAZARD LABEL |
| 27 | PT10727027 | READ MANUAL LABEL |

| REF | PART # | DESCRIPTION |
|-----|------------|------------------------------|
| 28 | PT10727028 | GUARD WARNING LABEL |
| 29 | PPAINT-01 | GRIZZLY GREEN TOUCH-UP PAINT |

⚠ WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.





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20-29 30-39 40-49
 50-59 60-69 70+

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7. Do you think your machine represents a good value? Yes No

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9. Would you allow us to use your name as a reference for Grizzly customers in your area?

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WARRANTY & 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 back 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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