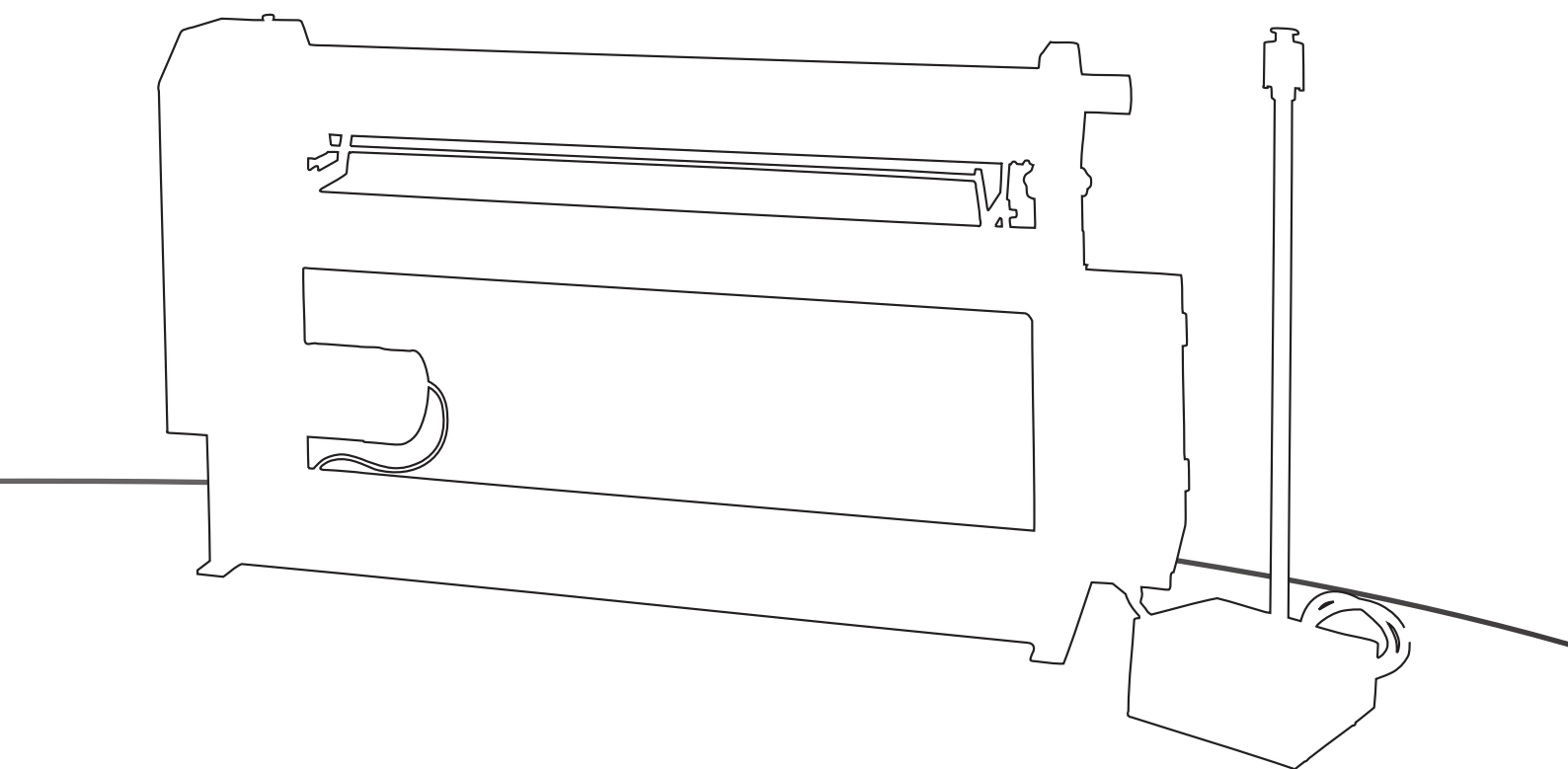


Electric slip roll machine

HU W1016x1,5

HU W1300x1,5



Operation manual

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Note: This manual is only for your reference. We reserve the right to improve the machine without notice. Please note the local voltage for operating this electric machine.

1 Main specification

NO.	MODEL	HU W1016X1.5	HU W-1300X1.5
1	Max rolling width	40" (1010mm)	50" (1280mm)
2	Max rolling thickness	16gauge(1.5mm)	16gauge(1.5mm)
3	Rolling diameter	2"(50mm)	3"(75mm)
4	Rotate speed	22rpm	22rpm
5	Motor Power	0.75kw	0.75kw
6	Overall dimension	1285x520x935(mm)	1650x520x960(mm)
7	Weight	350kg	400kg

H Machinery general safety warnings

1. Misuse of this machine can cause serious injury. For safety, machine must be set up, used and serviced properly. Read, understand and follow instructions in the operator's and parts manual which was shipped with your machine.
2. Wear proper apparel. No loose clothing or jewelry which can get caught in moving parts. Gloves and rubber soled footwear is recommended for best footing.
3. Do not overreach. Failure to maintain proper working position can cause you to fall into the machine or cause your clothing to get caught - pulling you into the machine.
4. Keep guards in place and in proper working order. Do not operate the machine with guards removed.
5. Avoid dangerous working environments. Do not use stationary machine tools in wet or damp locations. Keep work areas clean and well lit.
6. Avoid accidental starts by being sure the start switch is "OFF" before plugging in the machine.
7. Never leave the machine running while unattended. Machine shall be shut off whenever it is not in operation.
8. Disconnect electrical power before servicing. Whenever changing accessories or general maintenance is done on the machine, electrical power to the machine must be disconnected before work is done.
9. Machinery must be anchored to the floor.
10. Use the right tool. Don't force a tool or attachment to do a job it was not designed for.
11. Keep hands in sight and clear of all moving parts and rolling surfaces.
12. All visitors should be kept at a safe distance from the work area. Make workshop completely safe by using padlocks, master switches, or by removing starter keys.
13. Know the tool you are using - its application, limitations, and potential hazards.
14. General Electrical Cautions :This machine should be grounded in accordance with the National Electrical Code and local codes and ordinances. This work should be done by a qualified electrician. The machine should be grounded to protect the user from electrical shock.

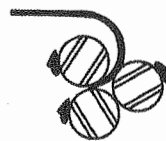
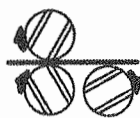
III INSTRUCTION

1. HOW TO FORM CIRCLES IN JUST TWO PASSES.- Length of material necessary to form the desired size circle is the first consideration in circle forming. To determine approximate length of material needed, use the formula $C=\pi D$. C is Circumference. π equals 3.1417. D is Diameter. For example, to find the length of material needed (C or Circumference) to form a circle 4" in diameter multiply 3.1417 by 4". Result -12.5667 is the circumference of approximate length of material needed. Cut a few pieces of material to this length for test forming. Material may have to be lengthened or shortened depending upon results of the test forming run.

2. TO ADJUST ROLLER- for material thickness, loosen the thumb screw to the right of the adjusting screws. Turn the adjusting screws to raise or lower the lower pinch roll. Insert the material between the rolls from the front of the machine and set rolls so the material fits tightly. Retighten the thumb screws and remove the material from between the rolls.

3. NO EXACT FORMULA- can be followed when making this adjustment because material "spring back" varies with the kind of material being formed. Only by test forming several pieces can the correct adjustments be obtained. Rolls must be adjusted exactly parallel or the material will spiral during the rolling process.

4. TO OPERATE ROLLER- after diameter adjustments have been made, insert material from front of roller and turn operating handle in a clockwise direction until about half of the material has passed through the rolls; if roller is power operated make sure that the upper pinch roll is rotating in a counter clockwise direction. Then, while feeding material, raise the idler roll. Continue turning until a half circle has been formed. It is important that you operate the roller while engaging the cam lever. For if the cam lever is engaged while the rolls are not turning, a noticeable flat spot or line will be formed across the width of the material.



5. AFTER HALF CIRCLE- has been formed, reinsert the formed end of the material in to the roller (as follows illustrated) and turn operating handle in a clockwise direction to form a complete circle. If roller is power operated, turn switch in a position that allows the upper pinch roll to rotate in a counter clockwise direction.



6. FRONT AND REAR ADJUSTMENT SCREWS- The four adjustment screws (two located in the front and two located in the rear) have been built into the left and right side

frames.

The two front adjusting screws enable the operator to raise or lower the pinch roll, so that the correct gap between the upper and lower pinch roll may be obtained to feed the desired stock in to the machine.

The left and right rear adjusting screws assist the operator in raising or lowering the idler roll which determines the degree of bend in the stock that is being fed through the machine. The right and left side frames are each equipped with a scale to aid the operator in determining.

7. TO REMOVE THE FORMED PART- lift clamp handle and slide the support lever handle to the right. The upper pinch roll will rise. Slide the material off roll. If the material is not long enough or if the formed part is not the proper diameter, additional samples will have to be made. Thousands of identical parts can be precisely duplicated when proper adjustment of the roller have been made.



8. REVERSE ROLLING CIRCLES- the same diameter as the diameter of the rolls and slightly larger, can be formed with the Roller in just one pass. To make the adjustment for material thickness and to determine the length of material needed, see the instructions given under "How To Form Circles In Just Two Passes".



IV Electric System

1, Preparation :The consumer should prepare a 10A power switch. Connect $3 \times 4 \text{ mm}^2$ + $1 \times 4 \text{ mm}^2$ yellow/green with the power switch. The earth-line should be connected with the earth-plate.

2, Operation of the machine

Combine the breaker in the electric appliance box and turn right the power switch. At this time the indicator lighted, which means the machine had been connected with power correctly. Pedal down the right starting pedal, the machine rolls clockwise continuously until loosen the pedal. Pedal down the left starting pedal, the machine rolls on the contrary of the above direction. If there is some wrong with the machine, push the lash-up switch on the handle to stop the machine. After the trouble is solved, turn off the switch to work.

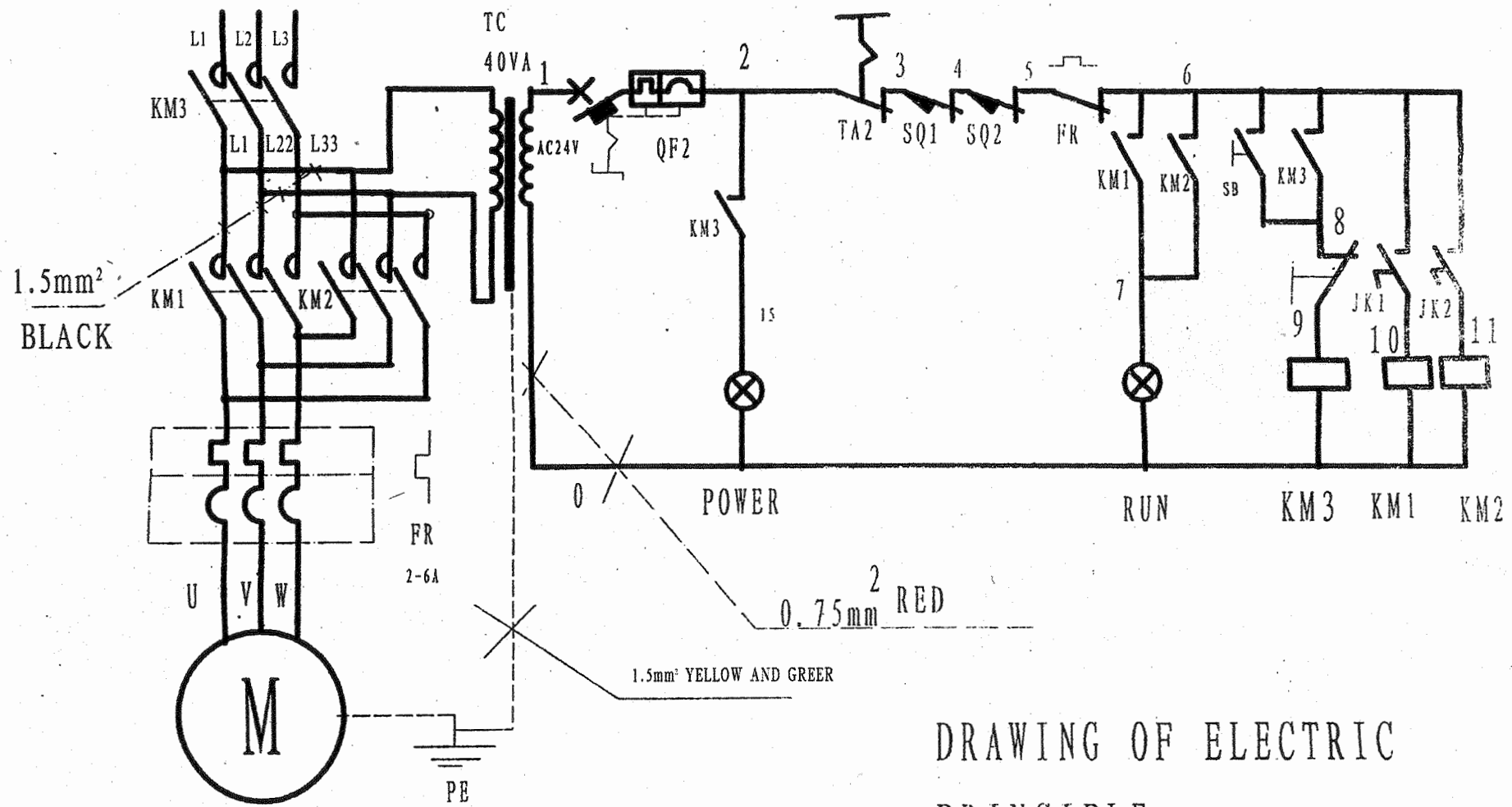
3, Maintenance of the machine

The machine has a compact structure. It is easy to be operated and maintained. Some problems maybe exist as follows:

1) The indicator lights, the machine can't work when pedal down the starting pedal, then turn off the lash-up switch on the handle.

- 1) The indicator doesn't light, then combine the breaker in the electric appliance box.
- 2) The indicator lights and the spindle works, but motor doesn't work, that means the connecting wire is loose or disconnected.
- 4, Electric principle drawing (refer to the attached drawing)
- 5, Main electric appliance list

No.	Symbol	Name	Quantity
1	LW	Power switch	1
2	QF	Breaker	2
3	TC	Transformer	1
4	KM	Alternating contactor	2
5	EL	Indicator light	2
6	TA	Lash-up switch	1
7	M	Motor	1



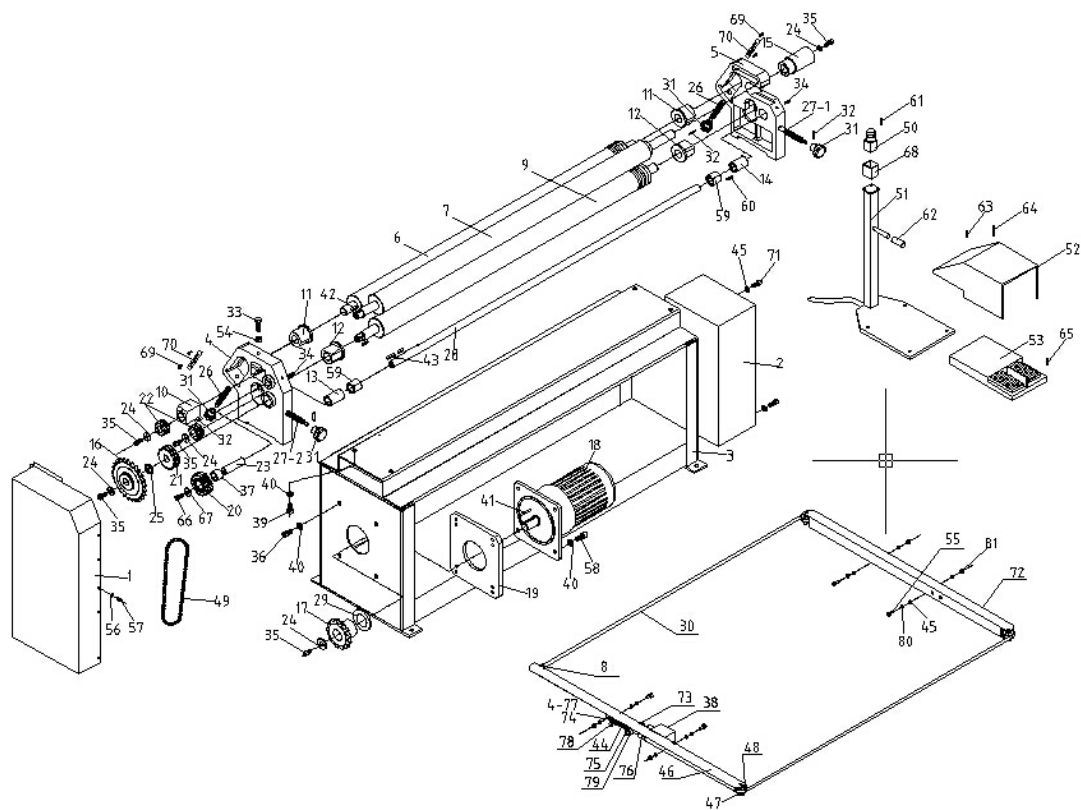
3PH 220/400v

DRAWING OF ELECTRIC PRINCIPLE

Part lists

Part No	Description	QTY	Part No	Description	QTY
1	Slide cover	1	41	Key	1
2	Electric box	1	42	Key	3
3	Stand	1	43	Key	1
4	Left support	1	44	Spring	1
5	Right support	1	45	Flat washer	12
6	Rear roll	1	46	Fixed mount	1
7	Upper roll	1	47	Bolt	3
8	Lock sleeve	1	48	wheel	3
9	Lower roll	1	49	Chain	1
10	Square bushing upper roll	1	50	Emergency switch	1
11	Busing real roll	2	51	Pole	1
12	Bushing lower roll	2	52	Box cover	1
13	Left bushing trans shaft	1	53	Pedal switch	1
14	Right bushing trans shaft	1	54	Nut	1
15	Sleeve handle	1	55	Bolt	4
16	Large sprocket	1	56	Flat washer	5
17	Small sprocket	1	57	Socket head button screw	5
18	Motor	1	58	Socket head cap screw	4
19	Motor mount	1	59	Connecting bushing	2
20	Gear	1	60	Fixing screw	2
21	Drive gear	1	61	Cross head screw	4
22	Driven gear	2	62	Handle sleeve	1
23	Gear wheel shaft	1	63	Phillips pan head machine screw	2
24	Flat washer	6	64	Cross head screw	2
25	Adjusting washer	1	65	Phillips pan head machine screw	4
26	Bolt for adjusting roller	2	66	Hex cap screw	1
27-1	Bolt for auxiliary roller	1	67	Flat washer	1
27-2	Bolt for auxiliary roller	1	68	Switch box	1
28	Transmission shaft	1	69	Rivet for scale	4

29	Washer	1	70	Scale	2
30	Safeguard rope	1	71	Hex cap screw	2
31	Handle	4	72	Fixed mount	1
32	Pin	4	73	Stop block	1
33	Bolt	1	74	L plate	1
34	Set screw	2	75	L plate	1
35	Hex cap screw	5	76	Lock sleeve	1
36	Bolt	4	77	Bolt	8
37	Bushing	1	78	Screw	1
38	Emergency switch	1	79	Screw	1
39	Hex cap screw	4	80	Spring washer	4
40	Flat washer	8	81	Nut	4



Our products are frequently updated and improved. Minor changes may not yet be incorporated in this manual. Always state the year of build, type and serial number of the machine in correspondence.

Manufacturer and importer assume no responsibility for defects which result from not reading the manual carefully or wrong use of the machine. No rights can be derived from this manual.

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CE DECLARATION OF CONFORMITY

(in accordance with supplement II A of the Machinery Directive)

Industrie & Handelonderneming Huberts bv, Kennedylaan 14, 5466 AA Veghel, the Netherlands, in the capacity of importer, is to be held responsible for declaring that the Huvema machines:

HU W1016X1,5 & HU W1300X1,5

which this declaration relates to, are conform the following norms:

NEN-EN ISO 12100:2010, NEN-EN IEC 60204-1:2006/C11:2010, NEN-EN-ISO 13857:2008, NEN-EN-ISO 13849-2:2012

and meet the basic requirements of the:

- Machinery Directive 2006/42/EC
- Electromagnetic Compatibility Directive 2014/35/EC
- Low Voltage Directive 2014/30/EC

Veghel, the Netherlands, January 2019

A handwritten signature in black ink, appearing to read 'L. Verberkt', is written over a light grey grid background.

L. Verberkt
Managing director

