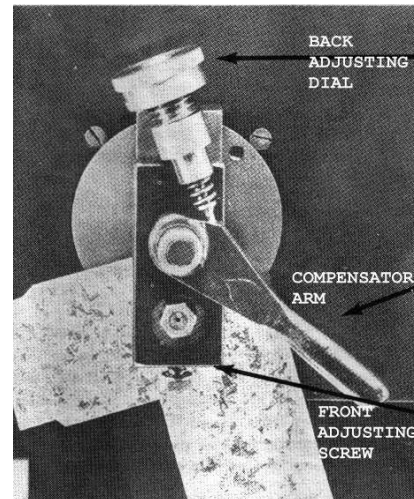


TIN KNOCKER

20 GAUGE POWER FLANGER

OPERATORS MANUAL



If there seems to be similarities between this power flanger manual and that of the power flanging attachment, that is because they are virtually the same, except that the No. 20 Power Flanger has its own motor and gearbox to power it.

Flanging Attachment 20 GAUGE PARTS LIST



MODEL	FINE#	PART#	NOMANCLATURE
TK20 Power Flanger	32	20PITTS001	Cast Iron Base 1
TK20 Power Flanger	33	20PITTS002	Steel Forming Head 1
TK20 Power Flanger	34	20PITTS003	Thumb Head Screw 1
TK20 Power Flanger	35	20PITTS004	Special Machine Key - 1
TK20 Power Flanger	36	20PITTS005	Compression Spring 3/8 ID 1
TK20 Power Flanger	37	20PITTS006	Cover 1
TK20 Power Flanger	38	20PITTS007	Gear Bevel 1
TK20 Power Flanger	39	20PITTS008	Gear Comb. Spur & Bevel 1
TK20 Power Flanger	40	20PITTS009	Lifter Plug 1
TK20 Power Flanger	41	20PITTS010	Knurled Forming Roll 1
TK20 Power Flanger	42	20PITTS011	Plain Forming Roll 1
TK20 Power Flanger	43	20PITTS012	Spacer Plate 1
TK20 Power Flanger	44	20PITTS013	Dowel Pin 15.875 x 57.15 mm 1
TK20 Power Flanger	45	20PITTS014	Hex Bolt M10-1.5 x 40 mm 2
TK20 Power Flanger	46	20PITTS015	Inner Race Assembly 1
TK20 Power Flanger	47	20PITTS016	Roll Shaft 1
TK20 Power Flanger	48	20PITTS017	Bearing B1020 2
TK20 Power Flanger	49	20PITTS018	Hex Nut M12-1.75 1
TK20 Power Flanger	50	20PITTS019	Adjustable Guide Roll 1
TK20 Power Flanger	51	20PITTS020	Hex Bolt M10-1.5 x 50 mm 4
TK20 Power Flanger	52	20PITTS021	Gear 2
TK20 Power Flanger	53	20PITTS022	Lock Washer 10 mm 4
TK20 Power Flanger	54	20PITTS023	Washer 10mm 2
TK20 Power Flanger	55	20PITTS024	Phillips Head Stove Bolt M6-1x15mm-4
TK20 Power Flanger	56	20PITTS025	Key 4.76 SQ. x 38.1 mm 1
TK20 Power Flanger	57	20PITTS029	Bearing Torr. B108 4
TK20 Power Flanger	58	20PITTS030	61 Woodruff Key Modified 1
TK20 Power Flanger	59	20PITTS031	Compensator Arm 1
TK20 Power Flanger	60	20PITTS032	Tension Screw Nut 1
TK20 Power Flanger	61	20PITTS033	Gauge Dial 1
TK20 Power Flanger	62	20PITTS034	Tension Screw 1
TK20 Power Flanger	63	20PITTS035	Tension Spring Push Rod 1
TK20 Power Flanger	64	20PITTS037	Spring 1
TK20 Power Flanger	65	20PITTS040	Collar 15.875 mm 1
POWER/DRIVE SYSTEM			
TK 20 Power Flanger	66	20 Power01	Motor
TK 20 Power Flanger	67	20 Power02	Gearbox
TK 20 Power Flanger	68	20 Power03	V Belt
TK 20 Power Flanger	69	20 Power04	On/off switch
TK 20 Power Flanger	70	20 Power05	Pulley/Sheave



66 Motor (under mounting bracket)

67 Gear Box

68 V-Belt

69 Switch

70 Pulley/Sheave

Drive System for TK No. 20 Power Flanger

To Operate Power Flanger

Adjust Unit For Gauge Material To Be Used

To adjust clearance between flanging rolls, tighten the adjusting screw on the front of the block of the machine all the way, then loosen the screw approximately one eighth of a turn. (This setting is usually correct for 26-gauge material) Do not set front gauge adjusting screw too tight. It should be set just tight enough to draw the metal through the rolls. Too tight a setting will stretch and wrinkle the material. To adjust the spring tension on the compensator arm, tighten the adjusting dial on the backside of the flanger to the stop and then turn back to the proper gauge setting shown on the adjusting dial.

Turn Up A "Starting Flange" on the material before inserting it into the rolls.

This is done by inserting the leading edge of the work to be flanged in the slot cut into the table and bending the piece away from the operator approximately 45°.

Start the leading edge of the material into the rolls. As the material passes through the rolls, the compensator arm will make contact with the material and guide it through the rolls. If the material pulls out of the rolls, it is an indication that either the front adjusting screw is too loose or the back adjusting dial is not tight enough.

Important

When starting a partially formed section that contains an inside curve, push the compensator arm back until it locks out of position. Feed partially formed section into the rolls and the machine will pull the material through. As the rolls approach the section that is not formed, bring the compensator arm tight to the material holding the spring tension off the piece until the unformed section comes to the rolls; then bear pressure to the piece until the flange picks up, then release compensator arm so that "automatic" guiding is resumed.