

TIN KNOCKER FOURPLEX CLEAT FORMER

INSTRUCTIONS & PARTS DIAGRAM



RED RIVER MACHINERY
1-800-729-0759
www.redrivermachinery.com

TIN KNOCKER SAFETY RULES FOURPLEXCLEAT FORMER



1. **WARNING:**

Electrical Danger---Misuse or improper installation of machinery connected to a source of electricity may result in accidental shock that could cause injury or death. Installation must conform to National Electric Code (Article 250- Grounding, etc.)

A trained and qualified electrician must make electrical connections. Electrical characteristics shown on motor plate and control panel must match the power source; and all electrically powered equipment must be grounded.



2. **WARNING:**

Mechanical Danger- the power driven forming rolls rotate at all times when power is supplied to the motor. Never place any part of the body including loose clothing near or onto the rotating rolls. (KEEP HANDS AWAY). Failure to comply will lead to personal body injury.

3. Never clean forming rolls while rolls are rotating—turn power off to clean rolls.
4. Machine to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operator's Manual.
5. Do not operate FOURPLEX CLEAT FORMER without reading operator's Manual and without proper supervisory instructions.

6. Perform all installation and set-up operations before applying power for electrical start-up.
7. Never operate machine with any guard removed; i.e., all required guarding to be installed and effective. Do not override the safety features of the equipment. Do not remove, paint over, alter, or deface any machine-mounted warning and instruction plates and signs.
8. Never leave machine running unattended. When not in use, turn off electrical power.
9. Never adjust machine with power on.
10. Avoid accidental start-up.
11. Do not use machine if servicing is required.
12. Safety glasses and protective tools are recommended.

WARRANTY

All new machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. TAAG Machinery Co. at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. TAAG Machinery Co. will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to TAAG Machinery Co., at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to TAAG Machinery Co. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

NOTE: 1. This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Following the procedures described within can easily do readjustment. These are procedures with which you, as a user, should be familiar, as you will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you.

2. Opening rolls (for Philipsburg Lock) are consumable items and not subject to warranty.

FOURPLEXCLEAT FORMER

Instructions

ELECTRICALS:

5 HP 230/460 volts three phase motor and controls, standard machine wired for 230 volt unless otherwise indicated.

MACHINE SPECIFICATIONS:

“S” CLEAT

Capacity: 22 gauge galvanize or lighter
Stock Width: 3-5/8” + 000-1/32

DRIVE CLEAT

Capacity: 20 gauge galvanize or lighter
Stock Width: 2-1/8” + 000-1/32

OPERATION:

A. Strip Stock

Start machine and place properly sheared material between properly aligned gauge bars and feed material into the rolls.

Check end results and make changes accordingly.

B. Sheet Feed with Slitter (Optional)

Start machine and place sheet against proper gauge bar and feed material into the slitting rolls being sure to keep sheet against gauge bar. Do not force or try to influence the sheet in any way. Machine will automatically feed cut sheet into forming rolls and deflect balance of sheet over machine cover. On long sheets, best results will be had by turning sheet so that the trail end on the first cut becomes the lead end on the second cut, etc. This procedure will eliminate any tendency for “Trailing-Off” on the slit part.

FOURPLEX CLEAT FORMER

Instructions / Trouble Shooting

ADJUSTMENTS:

The top plate and roll assembly is split into 3 zones of 3 rolls each with simple six point adjustment for each zone. Begin adjustment by tightening all hold down nuts to their solid position then loosen as follows:

- A. Zone 1 all studs $\frac{1}{2}$ turn loose
- B. Zone 2 all studs $\frac{3}{4}$ turn loose
- C. Zone 3 all studs 1 turn loose

Should machine labor under load stud settings should be loosened $\frac{1}{8}$ to $\frac{1}{4}$ turn.

Upward bow can be adjusted by lowering the exit adjusting screw located on the exit adjustment gauge assembly. Downward bow can be compensated by adjusting the hold down studs located at the exit end of the machine. Side bow is caused by an unbalanced stud adjustment.

LUBRICATION: / MAINTAINCE

Lubrication fittings for the high-speed shafts are located under the stand auxiliary side panel. The high-speed bearings should be lubricated after every eight hours of operation (recommended lubricant-Standard Oil Viscous #3, or equivalent.)

Roll station #4 and #5 (part 11144 and 11145) on "S" Cleat are supplied with polished angle surface to eliminate friction and allow the material to flow smoothly during the forming sequence. The rolls should be lubricated periodically with an application of #20 or #30 SAE lubricating oil to insure a smooth sliding surface.

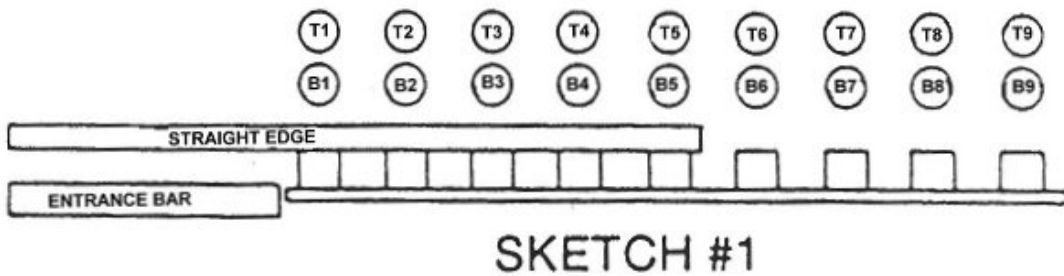
NOTE: If machine is to be used or stored out-of-doors, an oil or grease film will prevent rusting of surfaces.

INSTRUCTIONS FOR AUXILIARY ROLLS:

Machine auxiliary shafts are designed to accommodate various auxiliary roll sets listed below. To install these rolls, proceed as follows:

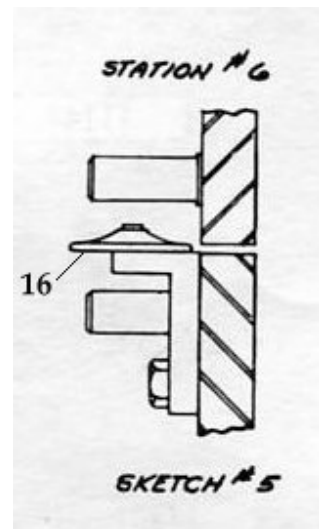
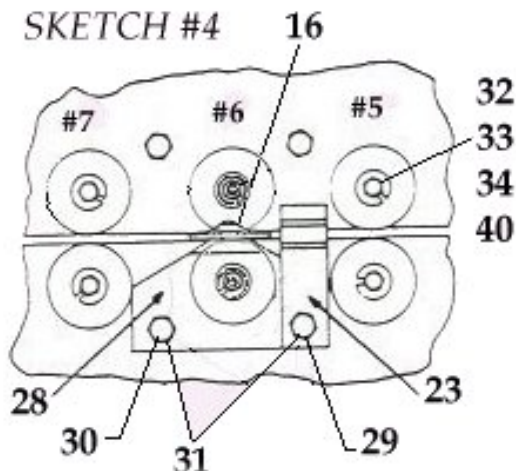
1. Remove machine cover.

2. Remove tabletop side plate on side of machine rolls are to be mounted.
3. If auxiliary rolls are now on machine, remove retaining bolts and washers. Remove all parts not pertaining to the set to be used.
4. Place keys on shafts.
5. Select the first pair of rolls, which are marked "T-1" and "B-1" and place them on the shafts at the entrance of the machine (Feed Side). Place the "T-1" roll on the upper shafts and "B-1" on the lower. Repeat procedure with roll stations #2, #3, and #4, etc. until all rolls have been mounted. All rolls marked "T" should be mounted on the top shafts and "B" rolls on the bottom shafts in numerical order. **NUMBER SIDE OF ROLLS MUST FACE OUTWARD.**
6. After rolls are installed, fasten rolls with retaining cap screws and washers.
7. Mount entrance and exit gauge bars to stand, using slotted holes provided in stand table top and set entrance gauge by placing a straight edge along the outer edge of the auxiliary rolls; measure the required amounts in from this straight edge to the extreme ends of the entrance gauge bar. See schedule below for various auxiliary sets.



- A. 5/16" Auxiliary Pittsburgh (20 gauge and lighter) uses approximately 1" material.
 Gauge Setting.....1/11/19" to 1-3/4"
 A slight taper in gauge setting may be required.

NOTE: To install auxiliary opening roll holder, remove rolls from the #6 roll station and bolts that straddle the bottom 6 roll shafts (See Sketches #4 and #5). Place opening roll holder and slide on machine and fasten with the two 1/2- 13 x 2" Hex Head Cap Screws Provided.



- B. Drive Cleat Auxiliary (20 gauge and lighter) uses 2-1/8" material.
Gauge Setting.....2-1/8"
- C. Combination 3-in-1 rolls (capacity 22 gauge and lighter), also 2-in-1, uses approx. 1-3/4"
On "T" section, 1-1/8" on standing seam and 1/2" on right angle flange.

Gauge Setting- 3-in-1 Gauge Bar:

- Top Step – "T" Section.....2-1/16"
- Middle Step – Standing Seam.....1-1/2"
- Bottom Step – Right Angle Flange.....15/16"

Gauge Settings-Combination 2-in-1

- Top Step – "T" Section.....2-1/16"
- Bottom Step-Standing Seam.....1-1/2"

NOTE: When the first setting is made, the other two will automatically be correct. Placing material to the proper gauge step can make the other two shapes. The exit angle iron gauge has an adjustable bar that can be lowered to exert pressure on the material as it emerges from the rolls; thereby, straightening the finished section. See Sketch #3.

NOTE: WHEN ADJUSTING THE EXIT GAUGE FROM THE 3-IN-1 COMBINATION, BE SURE TO SET IT TO THE "T" SECTION OR DAMAGE WILL RESULT BY MATERIAL INTERFERENCE WITH THE GAUGE BAR.

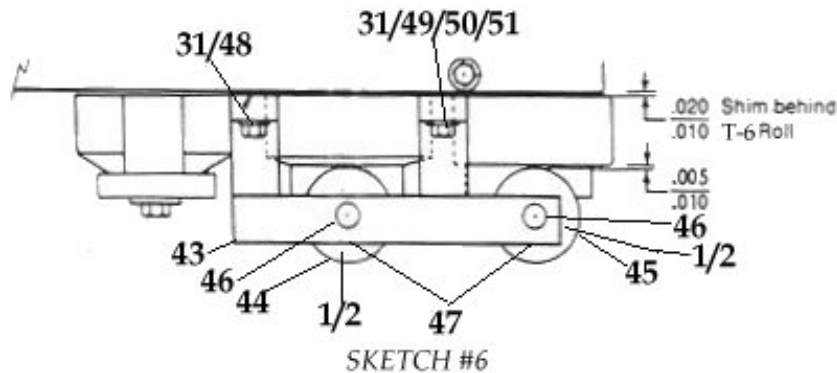
- D. Female Button Punch Snap lock (20 to 24 gauge galvanize or optional 24 to 28 gauge) uses approx. 1-5/16" of material.
Gauge Setting: 2-5/16" closest to forming rolls, 2-11/32" furthest from forming rolls. Taper may be increased or decreased as required for most satisfactory results.

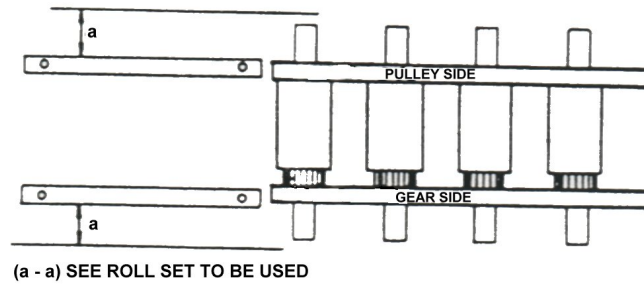
Upward bow can be adjusted by rising or lowering the straightener roll located between stations 8 & 9.

NOTE: To install slide between stations 2 and 3, remove existing idler gear bolt and replace with longer bolt furnished with roll set.

- E. Male Button Punch Snap lock (20 to 24 gauge galvanize or optional 24 to 28 gauge) uses approx. 7/16" of material.
Gauge Setting.....15/16"

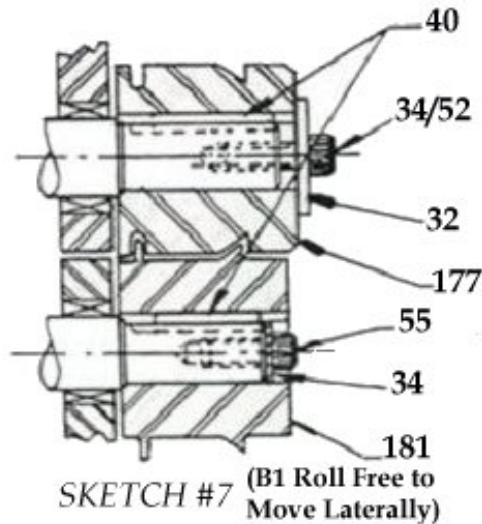
NOTE: Remove existing bolts between Top 4 and 5 rolls and Top 5 and 6 rolls and replace with idler bracket and bolts provided with roll set. See Sketch #6 and #6A.





SKETCH #6A

CAUTION: Bottom #1 roll is not fastened with retaining “C” washer. Severe damage will result to roll if instructions are not followed. See Sketch #7.



8. When changing rolls, loosen the exit gauge and move it to the extreme ends of the table slots away from where the material will pass. Run a test piece of material through the rolls and stop the machine as the lead edge of the material formed reaches the end of the exit table. Set the exit gauge to the formed material – the gauge should be flush with, but not bearing against, the material unless side pressure is required for straightening. Adjustment of the pressure on the 3/8” studs that pass through the plates will affect the shape and the tendency of the

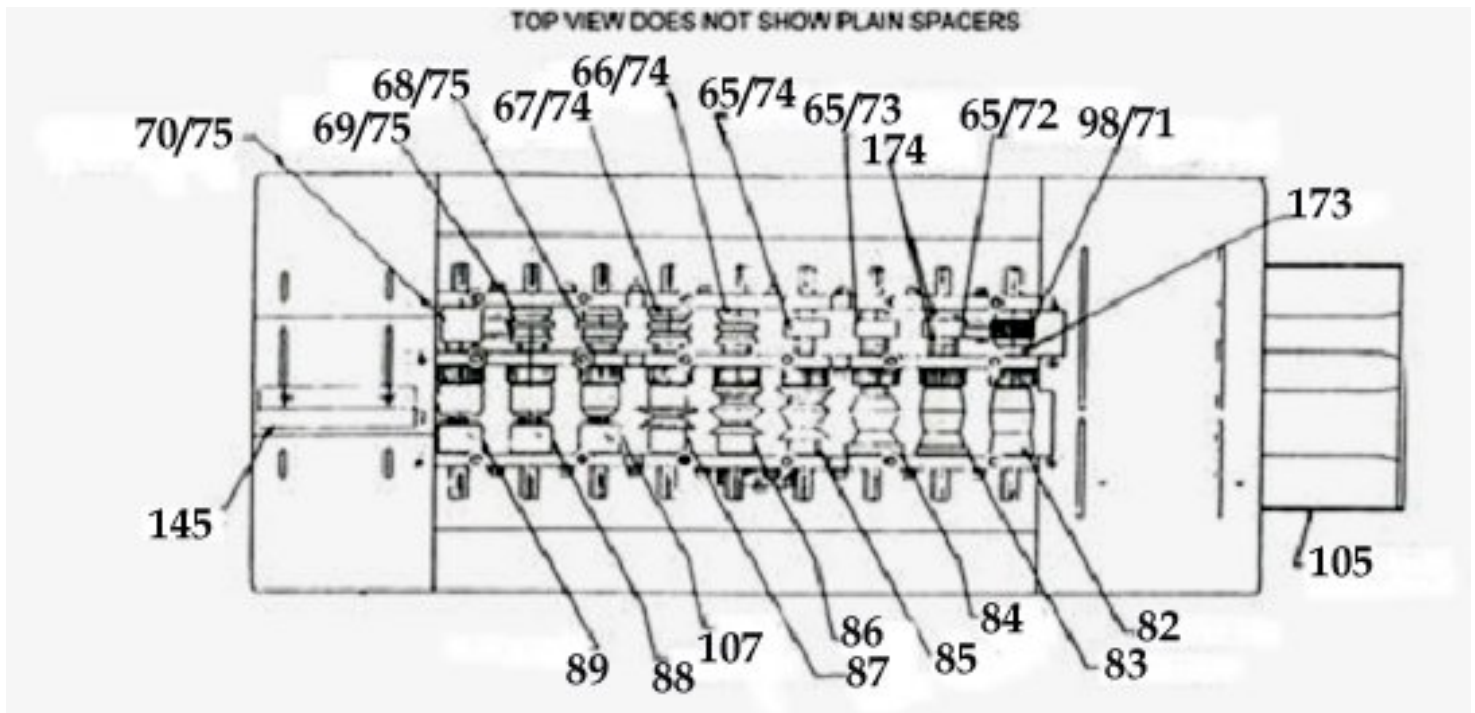
material to hold the entrance gauge. It is important that, when changing rolls, all parts pertaining to each set be removed from the machine and all parts for the set to be mounted be included on assembly.

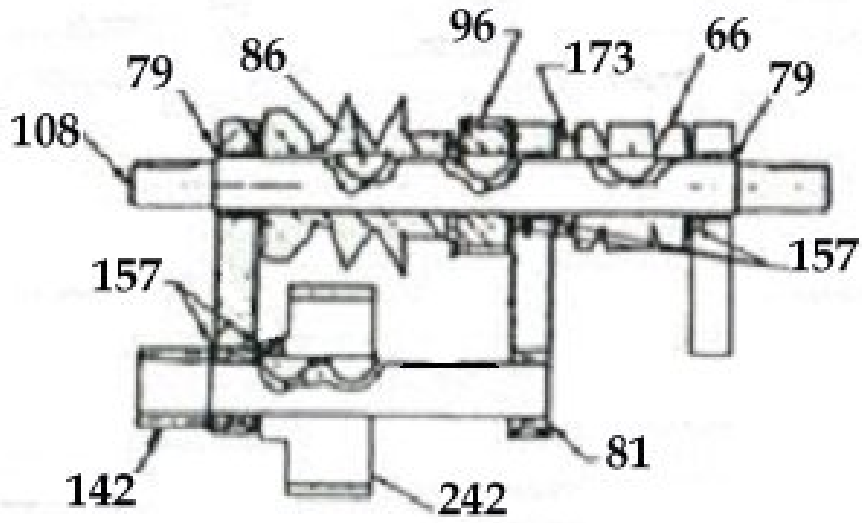
9. Replace top cover and stand side plate.
10. Place material against gauge bar and feed into machine.

NOTE: Roll coding is such that on similar rolls, the numbers will designate more than one Station. EXAMPLE: Combination 3-in-1 rolls have three rolls stamped LTC-2-3-B-7-8-9. These rolls are to be placed one on the bottom 7 shafts and the other two on B-8 and 9.

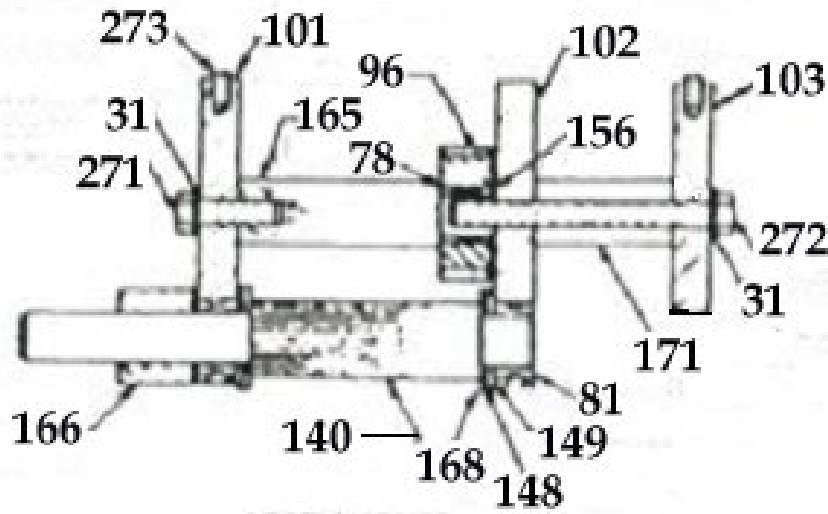
PREVENTATIVE MAINTENANCE:

To provide efficient, trouble free operation and to prolong the life of this tool, we suggest periodic cleaning of all rolls to remove any galvanize build-up. Galvanize build-up can be reduced to a minimum by applying a light bodied lubricant to the forming rolls every six to eight hours of operation. All bolts and nuts should be tightened every month or more often as required. Transmission belts should be checked for wear and proper tension periodically. Air intake vents on motor should be kept clean to insure proper ventilation.

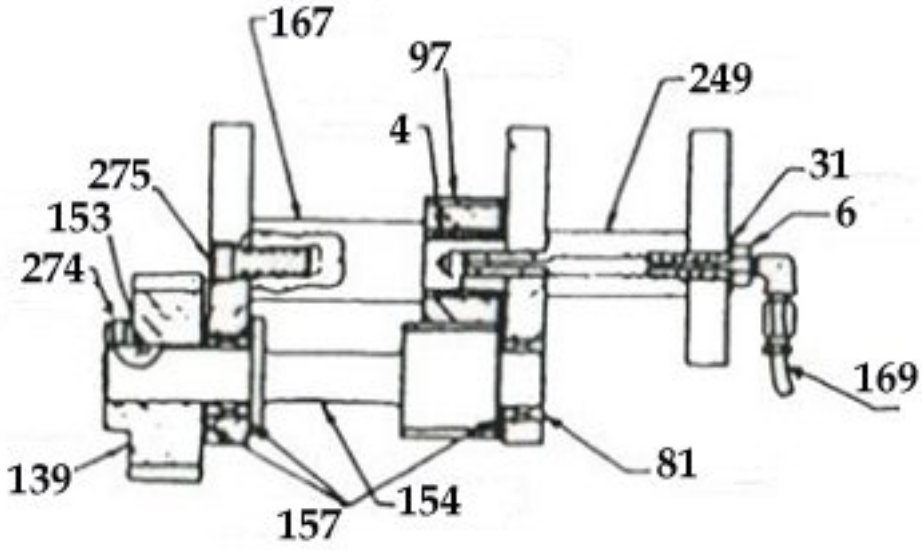




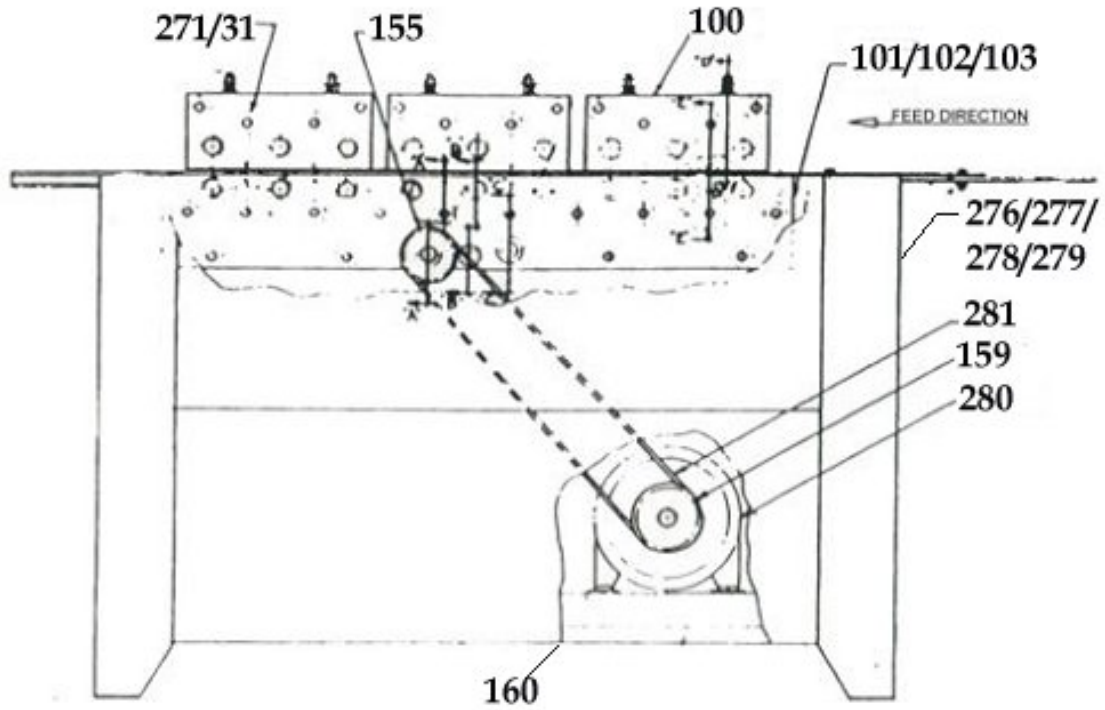
SECTION 'B-B'



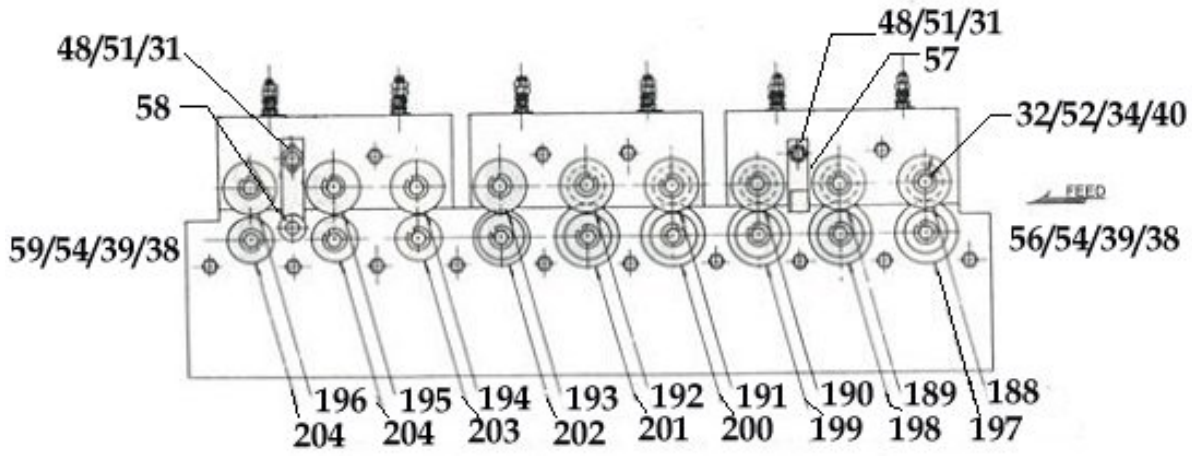
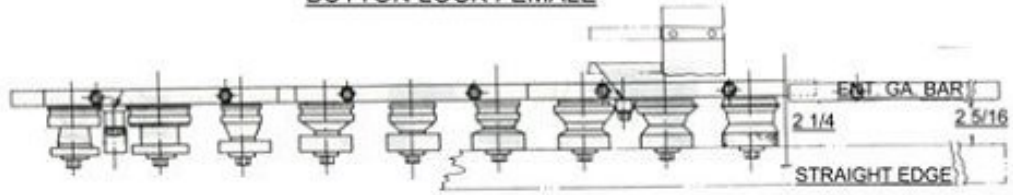
SECTION 'A-A'



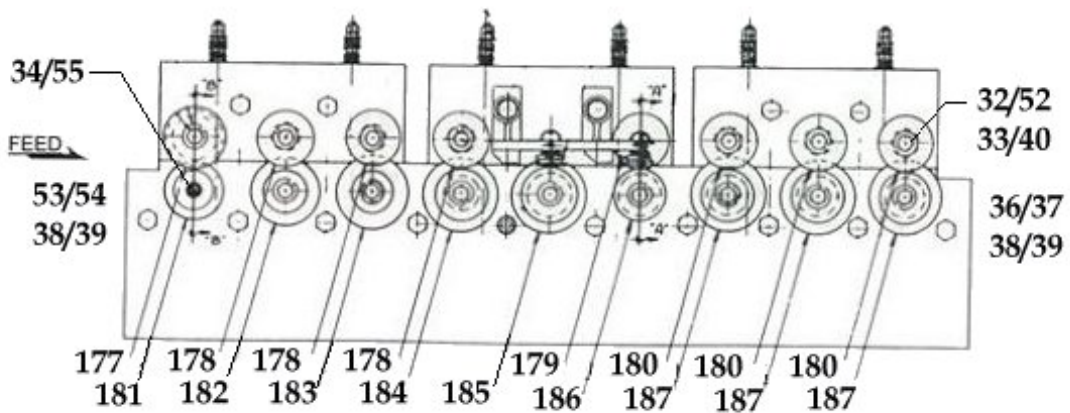
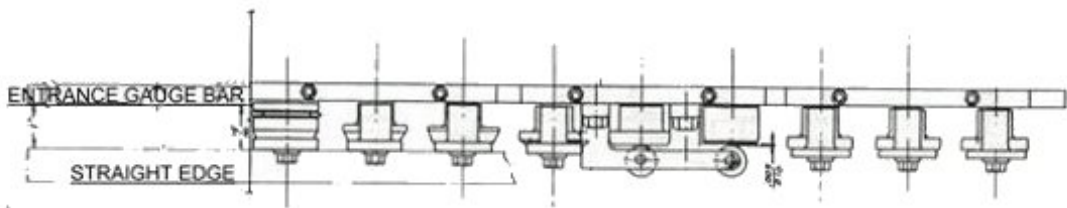
SECTION "C-C"



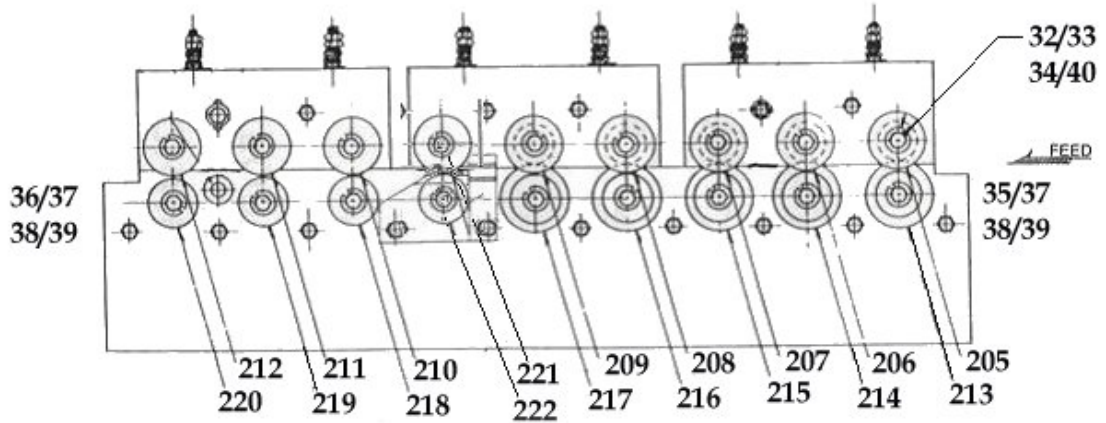
BUTTON LOCK FEMALE



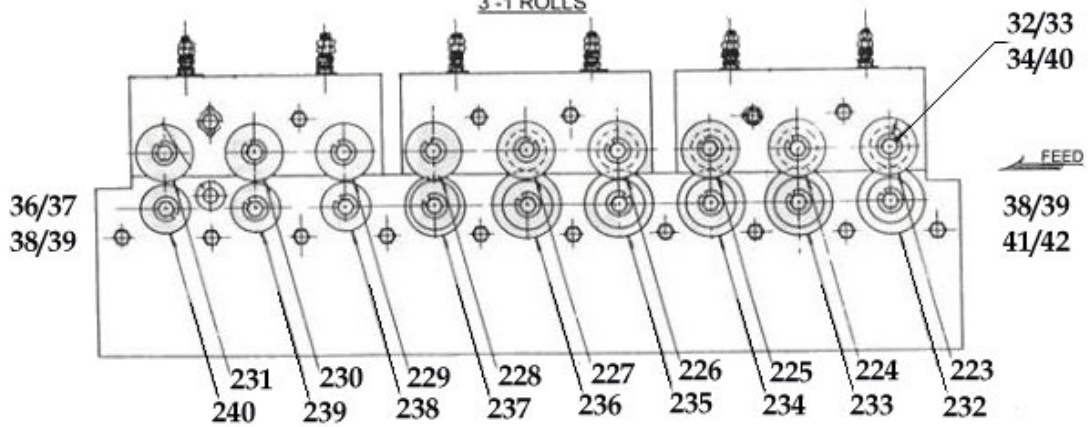
BUTTON LOCK MALE

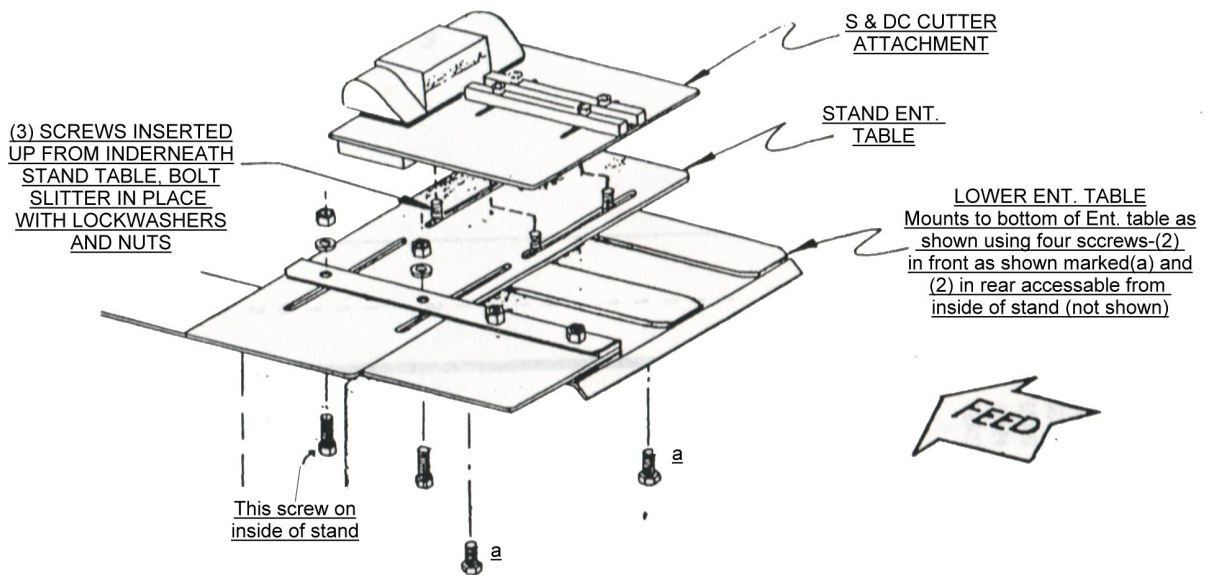


20 GAUGE PITTSBURGH



3-1 ROLLS





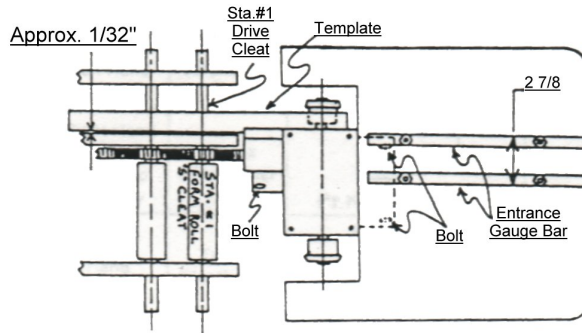
S" AND DRIVE CLEAT CUTTER ATTACHMENTS Installation Instructions

Maximum Capacity of Unit: 22 Ga. Galv. (.0350" Material) Minimum Length of Cleat to be cut: 9" minimum

1. Set slitting attachment on entrance table so that so that the spur gear of the Attachment meshes with the gear of the No. 1 forming roll. Refer to Sketch #1 or set-up.
2. By placing the template (furnished) across the splitter casting; thinnest side against

casting and widest side against machine plate; leave an approximate 1/32" clearance between machine plate and template. Then bolt in place per Sketch #1. A slight adjustment to the left or right may be required to provide the desired size of cut.

NOTE: Template edge must be parallel to machine plate and slitter attachment casting.

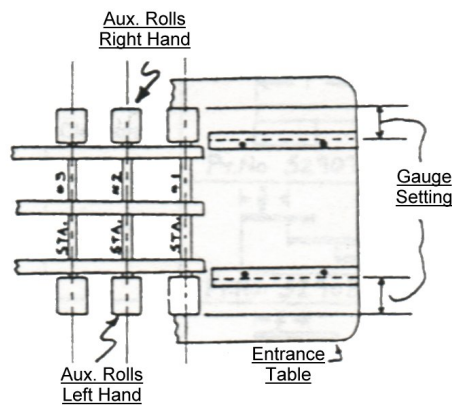


Alternate Set-Up Procedure:

Place straight edge across the back of the slitter attachment casting and measure 7/32" from straight edge to machine plate. Take measurements at least 12" apart to insure slitter attachment is parallel to machine plate.

NOTE: Entrance gauge bar is factory set and should not need adjustment. Setting is given for reference only.

3. Replace machine cover.



“S” AND DRIVE CUTTER

CLEAT

ATTACHMENT
Operation Instructions

1. Check settings and make sure all mounting bolts are tight.
2. Start machine and place the material against the entrance gauge bar of the slitting

attachment and feed the stock into the slitting rolls. The slit material will automatically deflect downward to the forming roll while the piece in the operator's hand will deflect upward to clear the machine. The slitter will cut straight as long as the material, which has not gone thru the slitting rolls, is held against the entrance gauge bar.

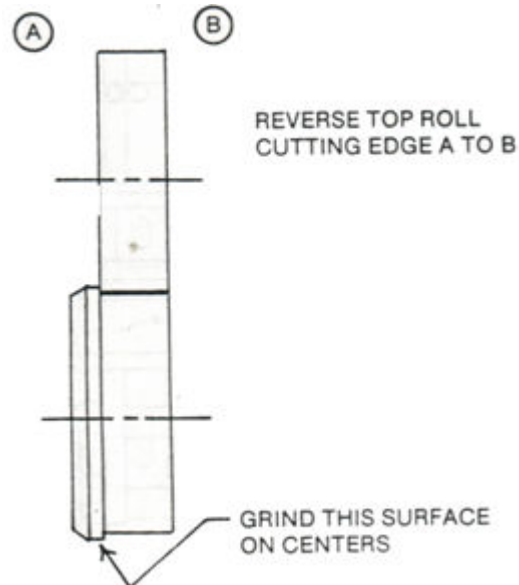
NOTE: WHEN RUNNING LONG SHEETS IT IS ADVISABLE THAT THE SHEET BE SUPPORTED AT APPROXIMATELY THE SAME HEIGHT AS THE SLITTING ATTACHEMENT ENTRANCE TABLE.

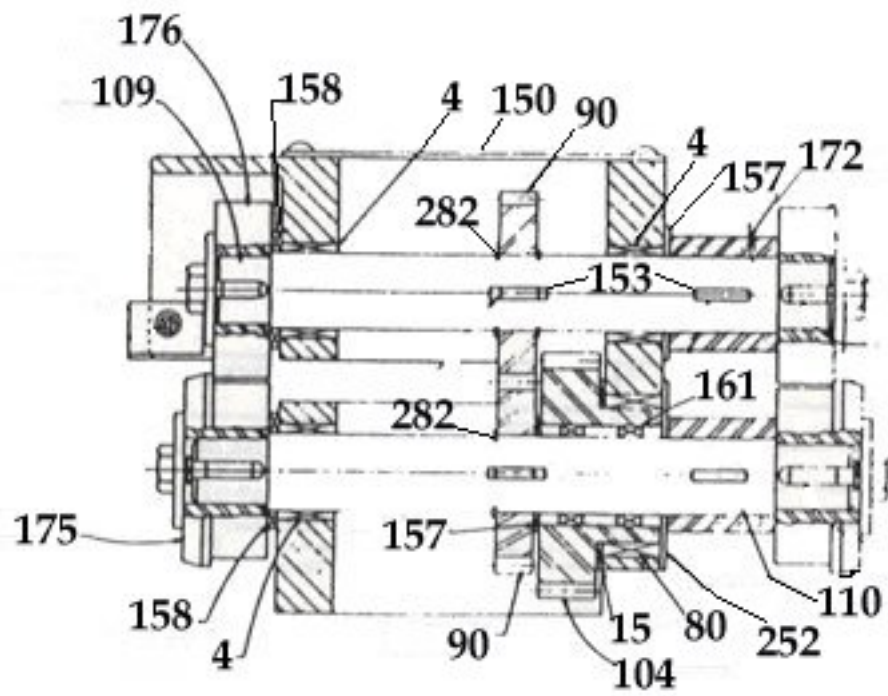
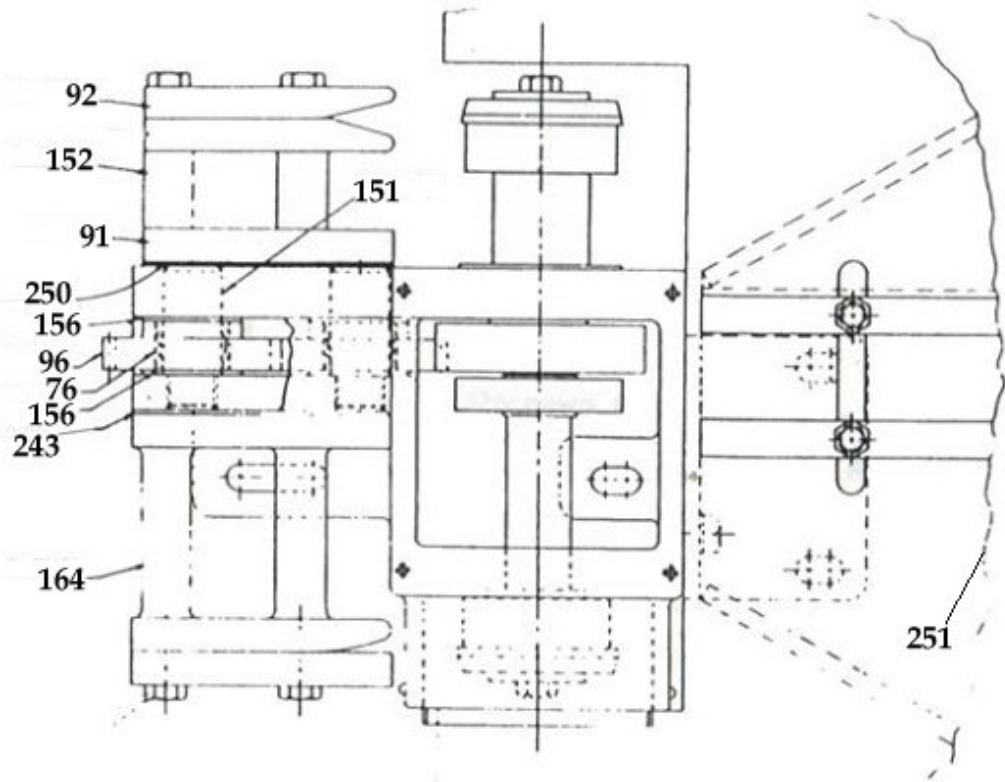
ADJUSTMENT

The slitter is properly adjusted and tested before shipment. Should the gauge accidentally become misaligned, refer to installation instructions paragraph 2. If the cleat runs out, or if material distribution is not correct, check the mounting of the attachment making sure the unit is mounted parallel to the machine side plates and settings are correct.

When the slitting rolls need resharpening remove the bottom roll and grind it on the O.D. to remove any nicks and present a clear sharp edge. The top roll has two cutting edges, when the resharpened lower roll is reinstalled, merely reverse the side of the roll presenting a new cutting edge. When ordering parts for this unit, please SPECIFY the SERIAL NUMBER of the machine.

CAUTION: Machine will jam if pieces less than 9" are used.
In case of jam-up, remove sheet deflector and remove material from unit.





Machine Name	Find No.	Part Number	Description
FourPlex Cleat Former	1	FOUR-795080176	NTA 815 TORR. BEARING
FourPlex Cleat Former	2	FOUR-795080177	TRA 815 BEARING
FourPlex Cleat Former	3	FOURcab	Fourplex cabinet
FourPlex Cleat Former	4	FOURPLE100	B1612 Torr Bearing
FourPlex Cleat Former	5	FOURPLEX000	Grease Fit Shim
FourPlex Cleat Former	6	FOURPLEX001	Lube Bolt
FourPlex Cleat Former	7	FOURPLEX003	Belleville Washers
FourPlex Cleat Former	8	FOURPLEX004	Electrical Switch
FourPlex Cleat Former	9	FOURPLEX005	Plate Studs
FourPlex Cleat Former	10	FOURPLEX006	Shim Washers .060
FourPlex Cleat Former	11	FOURPLEX007	Shim Washers .065
FourPlex Cleat Former	12	FOURPLEX008	Shim Washers .070
FourPlex Cleat Former	13	FOURPLEX009	Shim Washers .075
FourPlex Cleat Former	14	FOURPLEX010	Shim Washers .080
FourPlex Cleat Former	15	FOURPLEX021	Thrust Bearing 66427
FourPlex Cleat Former	16	FOURPLEX-02-39	Opening Roll
FourPlex Cleat Former	17	FOURPLEX03001	Switch 30 AmpLGMCCB
FourPlex Cleat Former	18	FOURPLEX03002	Cover Plate
FourPlex Cleat Former	19	FOURPLEX03003	Switch 30 Amp mounting box
FourPlex Cleat Former	20	FOURPLEX03004	Switch 30 Amp mounting box Link
FourPlex Cleat Former	21	FOURPLEX03005	Side pannel Cover the Motor
FourPlex Cleat Former	22	FOURPLEX03006	slitter guard drive side
FourPlex Cleat Former	23	FOURPLEX03007	Pitts Rolls Guide Bracket
FourPlex Cleat Former	24	FOURPLEX03008	Set of Male Button Lock Rolls (24 - 28 gauge)
FourPlex Cleat Former	26	FOURPLEX03009	Set of Female Button Lock Rolls (24 - 28 gauge)
FourPlex Cleat Former	28	FOURPLEX03010	Opening Roll Holder
FourPlex Cleat Former	29	FOURPLEX03011	Bolt (Pitts Rolls Guide Bracket)
FourPlex Cleat Former	30	FOURPLEX03012	Bolt (Pitts Opening Roll Holder)
FourPlex Cleat Former	31	FOURPLEX03013	Lockwasher
FourPlex Cleat Former	32	FOURPLEX03014	Moonwasher
FourPlex Cleat Former	33	FOURPLEX03015	Bolts (roll retaining)
FourPlex Cleat Former	34	FOURPLEX03016	Flat washer (roll retaining)
FourPlex Cleat Former	35	FOURPLEX03017	Entrance Guide
FourPlex Cleat Former	36	FOURPLEX03018	Exit Guide
FourPlex Cleat Former	37	FOURPLEX03019	Carriage Bolt for (Entrance / Exit Guide)
FourPlex Cleat Former	38	FOURPLEX03020	Lockwasher for (Carriage Bolt)
FourPlex Cleat Former	39	FOURPLEX03021	Nut for (Carriage Bolt)
FourPlex Cleat Former	40	FOURPLEX03022	Key

FourPlex Cleat Former	41	FOURPLEX03023	3-1 Entrance Guide
FourPlex Cleat Former	42	FOURPLEX03024	3-1 Entrance Guide Bolts
FourPlex Cleat Former	43	FOURPLEX03025	Idler Roll Bracket
FourPlex Cleat Former	44	FOURPLEX03026	T-5 Idler Roll
FourPlex Cleat Former	45	FOURPLEX03027	T-6 Idler Roll
FourPlex Cleat Former	46	FOURPLEX03028	Idler Pins
FourPlex Cleat Former	47	FOURPLEX03029	Set Screw
FourPlex Cleat Former	48	FOURPLEX03030	Bolt Idler Roll Bracket (T4-T5)
FourPlex Cleat Former	49	FOURPLEX03031	Bolt Idler Roll Bracket (T5-T6)
FourPlex Cleat Former	50	FOURPLEX03032	Nut
FourPlex Cleat Former	51	FOURPLEX03033	Flat Washer
FourPlex Cleat Former	52	FOURPLEX03034	Bolt (Roll Retaining)
FourPlex Cleat Former	53	FOURPLEX03035	Entrance Guide (M B/L)
FourPlex Cleat Former	54	FOURPLEX03036	Carriage Bolt (Entrance Guide B/L)
FourPlex Cleat Former	55	FOURPLEX03037	Cap Screw
FourPlex Cleat Former	56	FOURPLEX03038	Female B/L Entrance Guide
FourPlex Cleat Former	57	FOURPLEX03039	Female B/L Entrance Deflector
FourPlex Cleat Former	58	FOURPLEX03040	Female B/L exit deflector
FourPlex Cleat Former	59	FOURPLEX03041	Female B/L exit Guide
FourPlex Cleat Former	60	FOURPLEX041	Cover
FourPlex Cleat Former	61	FOURPLEX-04-11	Entrance Guide S-cleat (lower)
FourPlex Cleat Former	62	FOURPLEX-04-12	Entrance Guide Drive-cleat (lower)
FourPlex Cleat Former	63	FOURPLEX-04-14	Drive Cleat Exit ramp
FourPlex Cleat Former	64	FOURPLEX048	Bar Jack
FourPlex Cleat Former	65	FOURPLEX070	Top Forming Roll Drive Cleat T2, T3 & T4
FourPlex Cleat Former	66	FOURPLEX071	Top Forming Roll Drive Cleat T5
FourPlex Cleat Former	67	FOURPLEX072	Top Forming Roll Drive Cleat T6
FourPlex Cleat Former	68	FOURPLEX073	Top Forming Roll Drive Cleat T7
FourPlex Cleat Former	69	FOURPLEX074	Top Forming Roll Drive Cleat T8
FourPlex Cleat Former	70	FOURPLEX075	Top Forming Roll Drive Cleat T9
FourPlex Cleat Former	71	FOURPLEX076	Bottom Forming Roll Drive Cleat B1
FourPlex Cleat Former	72	FOURPLEX077	Bottom Forming Roll Drive Cleat B2
FourPlex Cleat Former	73	FOURPLEX078	Bottom Forming Roll Drive Cleat B3
FourPlex Cleat Former	74	FOURPLEX079	Bottom Forming Roll Drive Cleat B4, B5 & B6
FourPlex Cleat Former	75	FOURPLEX080	Bottom Forming Roll Drive Cleat B7, B8 & B9
FourPlex Cleat Former	76	FOURPLEX080s	B1412 Torr Bearing
FourPlex Cleat Former	77	FOURPLEX081	5 HP Phase 60 Cycle 1800 RPM (184)
FourPlex Cleat Former	78	FOURPLEX090	Bearing (B1416 Torr)

FourPlex Cleat Former	79	FOURPLEX100	Bearing (B1612 Torr)
FourPlex Cleat Former	80	FOURPLEX110	B2812 Torr Bearing
FourPlex Cleat Former	81	FOURPLEX111	Hj 162412 Torr Bearing
FourPlex Cleat Former	82	FOURPLEX141	T&B Forming Roll "S" Cleat T1 & B1
FourPlex Cleat Former	83	FOURPLEX142	T&B Forming Roll "S" Cleat T2 & B2
FourPlex Cleat Former	84	FOURPLEX143	T&B Forming Roll "S" Cleat T3 & B3
FourPlex Cleat Former	85	FOURPLEX144	T&B Forming Roll "S" Cleat T4 & B4
FourPlex Cleat Former	86	FOURPLEX145	T&B Forming Roll "S" Cleat T5 & B5
FourPlex Cleat Former	87	FOURPLEX146	T&B Forming Roll "S" Cleat T6 & B6
FourPlex Cleat Former	88	FOURPLEX147	T&B Forming Roll "S" Cleat T7 & B7
FourPlex Cleat Former	89	FOURPLEX148	T&B Forming Roll "S" Cleat T8 & B8
FourPlex Cleat Former	89B	FOURPLEX149	T&B Forming Roll "S" Cleat T9 & B9
FourPlex Cleat Former	90	FOURPLEX150	Gear Driven
FourPlex Cleat Former	91	FOURPLEX151	Deflector Plate Back
FourPlex Cleat Former	92	FOURPLEX152	Outer Deflector Plate
FourPlex Cleat Former	93	FOURPLEX155	Slide (Drive Cleat)
FourPlex Cleat Former	94	FOURPLEX156	Slide Holder
FourPlex Cleat Former	95	FOURPLEX160	Driven Gear
FourPlex Cleat Former	96	FOURPLEX161	Idler Gear (needs 1-66090 Bearing)
FourPlex Cleat Former	97	FOURPLEX162	Main Idler Gear (needs 2-66100 Bearings)
FourPlex Cleat Former	98	FOURPLEX170	Top Forming Roll Drive Cleat T1
FourPlex Cleat Former	99	FOURPLEX171	Gear Idler (needs 1-66080 Bearing)
FourPlex Cleat Former	100	FOURPLEX218	Top Plate
FourPlex Cleat Former	101	FOURPLEX219	Bottom Front Plate
FourPlex Cleat Former	102	FOURPLEX220	Bottom Center Plate
FourPlex Cleat Former	103	FOURPLEX221	Bottom Back Plate
FourPlex Cleat Former	104	FOURPLEX226	Gear Clutch (needs 1-66500 Bearing)
FourPlex Cleat Former	105	FOURPLEX234	Lower Entrance Table
FourPlex Cleat Former	106	FOURPLEX250	Housing Casting 88250
FourPlex Cleat Former	107	FOURPLEX257	T&B Forming Roll "S" Cleat T7 & B7
FourPlex Cleat Former	108	FOURPLEX284	Roll Shafts
FourPlex Cleat Former	109	FOURPLEX287	T1 Roll Shaft
FourPlex Cleat Former	110	FOURPLEX288	B1 Roll shaft

FourPlex Cleat Former	111	FOURPLEX28801	Button lock male T-1 (24 - 28 gauge)
FourPlex Cleat Former	112	FOURPLEX28802	Button lock male T-2 T-3 T-4 (24 - 28 gauge)
FourPlex Cleat Former	113	FOURPLEX28803	Button lock male T-6 (24 - 28 gauge)
FourPlex Cleat Former	114	FOURPLEX28804	Button lock male T-7 T-8 T-9 (24 - 28 gauge)
FourPlex Cleat Former	115	FOURPLEX28805	Button lock male B-1 (24 - 28 gauge)
FourPlex Cleat Former	116	FOURPLEX28806	Button lock male B-2 (24 - 28 gauge)
FourPlex Cleat Former	117	FOURPLEX28807	Button lock male B-3 (24 - 28 gauge)
FourPlex Cleat Former	118	FOURPLEX28808	Button lock male B-4 (24 - 28 gauge)
FourPlex Cleat Former	119	FOURPLEX28809	Button lock male B-5 (24 - 28 gauge)
FourPlex Cleat Former	120	FOURPLEX28810	Button lock male B-6 (24 - 28 gauge)
FourPlex Cleat Former	121	FOURPLEX28811	Button lock male B-7 B-8 B-9 (24 - 28 gauge)
FourPlex Cleat Former	122	FOURPLEX28820	Button lock female T-1 (24 - 28 gauge)
FourPlex Cleat Former	123	FOURPLEX28821	Button lock female T-2 (24 - 28 gauge)
FourPlex Cleat Former	124	FOURPLEX28822	Button lock female T-3 (24 - 28 gauge)
FourPlex Cleat Former	125	FOURPLEX28823	Button lock female T-4 (24 - 28 gauge)
FourPlex Cleat Former	126	FOURPLEX28824	Button lock female T-5 (24 - 28 gauge)
FourPlex Cleat Former	127	FOURPLEX28825	Button lock female T-6 (24 - 28 gauge)
FourPlex Cleat Former	128	FOURPLEX28826	Button lock female T-7 (24 - 28 gauge)
FourPlex Cleat Former	129	FOURPLEX28827	Button lock female T-8 (24 - 28 gauge)
FourPlex Cleat Former	130	FOURPLEX28828	Button lock female T-9 (24 - 28 gauge)
FourPlex Cleat Former	131	FOURPLEX28829	Button lock female B-1 (24 - 28 gauge)
FourPlex Cleat Former	132	FOURPLEX28830	Button lock female B-2 (24 - 28 gauge)
FourPlex Cleat Former	133	FOURPLEX28831	Button lock female B-3 (24 - 28 gauge)
FourPlex Cleat Former	134	FOURPLEX28832	Button lock female B-4 (24 - 28 gauge)
FourPlex Cleat Former	135	FOURPLEX28833	Button lock female B-5 (24 - 28 gauge)

FourPlex Cleat Former	136	FOURPLEX28834	Button lock female B-6 (24 - 28 gauge)
FourPlex Cleat Former	137	FOURPLEX28835	Button lock female B-7 (24 - 28 gauge)
FourPlex Cleat Former	138	FOURPLEX28836	Button lock female B-8 B-9 (24 - 28 gauge)
FourPlex Cleat Former	139	FOURPLEX301	Driven Gear Main
FourPlex Cleat Former	140	FOURPLEX302	1st Drive Shafts
FourPlex Cleat Former	141	FOURPLEX303	Entrance Gauge Bar
FourPlex Cleat Former	142	FOURPLEX304	2nd Drive Shaft
FourPlex Cleat Former	144	FOURPLEX305	Drive Cleat Exit Bar
FourPlex Cleat Former	145	FOURPLEX306	Exit Gauge ("S" Cleat)
FourPlex Cleat Former	146	FOURPLEX309	Entrance Gauge Bar
FourPlex Cleat Former	147	FOURPLEX3-1A1	Set of 3 in 1 Rolls
FourPlex Cleat Former	148	FOURPLEX320	Bearing (NTA 1625 Torr)
FourPlex Cleat Former	149	FOURPLEX321	Bearing (TRC 1625 Race)
FourPlex Cleat Former	150	FOURPLEX322	Cover Plate
FourPlex Cleat Former	151	FOURPLEX326	Idle Gear Stud
FourPlex Cleat Former	152	FOURPLEX332	Deflector Spacer
FourPlex Cleat Former	153	FOURPLEX401	9 Woodruff Key 62401
FourPlex Cleat Former	154	FOURPLEX406	3rd Drive Shafts
FourPlex Cleat Former	155	FOURPLEX421	Sheave 2BK32 x 1
FourPlex Cleat Former	156	FOURPLEX422	Bearing (TT1503-2 Thrust)
FourPlex Cleat Former	157	FOURPLEX425	Bearing (TT1709-1 Thrust)
FourPlex Cleat Former	158	FOURPLEX430	TT1502-2 Thrust Bearing
FourPlex Cleat Former	159	FOURPLEX442	Sheave 2BK 45 x 1-1/8
FourPlex Cleat Former	160	FOURPLEX464	Motor Base
FourPlex Cleat Former	161	FOURPLEX500	RCB162117 Clutch Bearing
FourPlex Cleat Former	162	FOURPLEX505	Plain Spacer "S" Cleat 1-1/4" x 5-1/64"
FourPlex Cleat Former	163	FOURPLEX512	Stand
FourPlex Cleat Former	164	FOURPLEX574	Deflector Assembly
FourPlex Cleat Former	165	FOURPLEX605	Idler Spacer
FourPlex Cleat Former	166	FOURPLEX640	Collar
FourPlex Cleat Former	167	FOURPLEX657	Main Idler Spacer
FourPlex Cleat Former	168	FOURPLEX661	Thrust Collar
FourPlex Cleat Former	169	FOURPLEX700	Plastic Tubes 4 pcs. -14" & 3 pcs. - 18"
FourPlex Cleat Former	170	FOURPLEX700s	Deflector Guard
FourPlex Cleat Former	171	FOURPLEX701	Plain Spacer Drive Cleat 1-1/4" x 2-21/32"
FourPlex Cleat Former	172	FOURPLEX702	Spacer
FourPlex Cleat Former	173	FOURPLEX703	Plain Spacer Drive Cleat 1-1/2" x 3/8"
FourPlex Cleat Former	174	FOURPLEX704	Roll Spacer Drive Cleat 1-3/8" x 17/32" 2/keyway
FourPlex Cleat Former	175	FOURPLEX711	B1 Roll

FourPlex Cleat Former	176	FOURPLEX712	T1 Roll
FourPlex Cleat Former	177	FOURPLEX801	Button lock male T-1
FourPlex Cleat Former	178	FOURPLEX802	Button lock male T-2 T-3 T-4
FourPlex Cleat Former	179	FOURPLEX803	Button lock male T-6
FourPlex Cleat Former	180	FOURPLEX804	Button lock male T-7 T-8 T-9
FourPlex Cleat Former	181	FOURPLEX805	Button lock male B-1
FourPlex Cleat Former	182	FOURPLEX806	Button lock male B-2
FourPlex Cleat Former	183	FOURPLEX807	Button lock male B-3
FourPlex Cleat Former	184	FOURPLEX808	Button lock male B-4
FourPlex Cleat Former	185	FOURPLEX809	Button lock male B-5
FourPlex Cleat Former	186	FOURPLEX810	Button lock male B-6
FourPlex Cleat Former	187	FOURPLEX811	Button lock male B-7 B-8 B-9
FourPlex Cleat Former	188	FOURPLEX820	Button lock female T-1
FourPlex Cleat Former	189	FOURPLEX821	Button lock female T-2
FourPlex Cleat Former	190	FOURPLEX822	Button lock female T-3
FourPlex Cleat Former	191	FOURPLEX823	Button lock female T-4
FourPlex Cleat Former	192	FOURPLEX824	Button lock female T-5
FourPlex Cleat Former	193	FOURPLEX825	Button lock female T-6
FourPlex Cleat Former	194	FOURPLEX826	Button lock female T-7
FourPlex Cleat Former	195	FOURPLEX827	Button lock female T-8
FourPlex Cleat Former	196	FOURPLEX828	Button lock female T-9
FourPlex Cleat Former	197	FOURPLEX829	Button lock female B-1
FourPlex Cleat Former	198	FOURPLEX830	Button lock female B-2
FourPlex Cleat Former	199	FOURPLEX831	Button lock female B-3
FourPlex Cleat Former	200	FOURPLEX832	Button lock female B-4
FourPlex Cleat Former	201	FOURPLEX833	Button lock female B-5
FourPlex Cleat Former	202	FOURPLEX834	Button lock female B-6
FourPlex Cleat Former	203	FOURPLEX835	Button lock female B-7
FourPlex Cleat Former	204	FOURPLEX836	Button lock female B-8 B-9
FourPlex Cleat Former	205	FOURPLEX840	Pittsburgh T-1
FourPlex Cleat Former	206	FOURPLEX841	Pittsburgh T-2
FourPlex Cleat Former	207	FOURPLEX842	Pittsburgh T-3
FourPlex Cleat Former	208	FOURPLEX843	Pittsburgh T-4
FourPlex Cleat Former	209	FOURPLEX844	Pittsburgh T-5
FourPlex Cleat Former	210	FOURPLEX845	Pittsburgh T-7
FourPlex Cleat Former	211	FOURPLEX846	Pittsburgh T-8
FourPlex Cleat Former	212	FOURPLEX847	Pittsburgh T-9
FourPlex Cleat Former	213	FOURPLEX848	Pittsburgh B-1
FourPlex Cleat Former	214	FOURPLEX849	Pittsburgh B-2
FourPlex Cleat Former	215	FOURPLEX850	Pittsburgh B-3
FourPlex Cleat Former	216	FOURPLEX851	Pittsburgh B-4
FourPlex Cleat Former	217	FOURPLEX852	Pittsburgh B-5
FourPlex Cleat Former	218	FOURPLEX853	Pittsburgh B-7
FourPlex Cleat Former	219	FOURPLEX854	Pittsburgh B-8
FourPlex Cleat Former	220	FOURPLEX855	Pittsburgh B-9

FourPlex Cleat Former	221	FOURPLEX856	Pittsburgh T-6
FourPlex Cleat Former	222	FOURPLEX857	Pittsburgh B-6
FourPlex Cleat Former	223	FOURPLEX860	3-1 Rolls T-1
FourPlex Cleat Former	224	FOURPLEX861	3-1 Rolls T-2
FourPlex Cleat Former	225	FOURPLEX862	3-1 Rolls T-3
FourPlex Cleat Former	226	FOURPLEX863	3-1 Rolls T-4
FourPlex Cleat Former	227	FOURPLEX864	3-1 Rolls T-5
FourPlex Cleat Former	228	FOURPLEX865	3-1 Rolls T-6
FourPlex Cleat Former	229	FOURPLEX866	3-1 Rolls T-7
FourPlex Cleat Former	230	FOURPLEX867	3-1 Rolls T-8
FourPlex Cleat Former	231	FOURPLEX868	3-1 Rolls T-9
FourPlex Cleat Former	232	FOURPLEX869	3-1 Rolls B-1
FourPlex Cleat Former	233	FOURPLEX870	3-1 Rolls B-2
FourPlex Cleat Former	234	FOURPLEX871	3-1 Rolls B-3
FourPlex Cleat Former	235	FOURPLEX872	3-1 Rolls B-4
FourPlex Cleat Former	236	FOURPLEX873	3-1 Rolls B-5
FourPlex Cleat Former	237	FOURPLEX874	3-1 Rolls B-6
FourPlex Cleat Former	238	FOURPLEX875	3-1 Rolls B-7
FourPlex Cleat Former	239	FOURPLEX876	3-1 Rolls B-8
FourPlex Cleat Former	240	FOURPLEX877	3-1 Rolls B-9
FourPlex Cleat Former	241	FOURPLEX895	Deflector Weldment
FourPlex Cleat Former	242	FOURPLEX900	Fiber Gear Assembly
FourPlex Cleat Former	243	FOURPLEX902	Wear Plate
FourPlex Cleat Former	244	FOURPLEX904	Exit Gauge ("S" Cleat)
FourPlex Cleat Former	245	FOURPLEX907	Sheet Slide ("S" cleat Gear side)
FourPlex Cleat Former	246	FOURPLEX907s	Entrance Gauge Bar Assembly
FourPlex Cleat Former	247	FOURPLEX908	Sheet Slide Roll
FourPlex Cleat Former	248	FOURPLEX928	Back Enclosure
FourPlex Cleat Former	249	FOURPLEX930	Hex Spacer Lube
FourPlex Cleat Former	250	FOURPLEX960	Wear Plate
FourPlex Cleat Former	251	FOURPLEX963	Entrance Table Weldment
FourPlex Cleat Former	252	FOURPLEX976	Thrust Washer
FourPlex Cleat Former	253	FOURPLEX979	Slitter Template
FourPlex Cleat Former	254	FOURPLEX993	Roll Cover Weldment
FourPlex Cleat Former	255	FOURPLEXDRA1	Set of Drive cleat Rolls
FourPlex Cleat Former	256	FOURPLEXF/BL	Set of Female Button Lock Rolls
FourPlex Cleat Former	257	FOURPLEXHE1	Complete fourplex head
FourPlex Cleat Former	258	FOURPLEXM/BL	Set of Male Button Lock Rolls
FourPlex Cleat Former	259	FOURPLEXPRA1	Set of Pitts Rolls
FourPlex Cleat Former	260	FOURPLEXSA1	Complete Slitter including hardware
FourPlex Cleat Former	261	FOURPLEXS-CA1	Set of "S" cleat Rolls
FourPlex Cleat Former	263	FOUR-k0875-c-062	.875 x .406 x .062

FourPlex Cleat Former	264	FOUR-RCB-162117	Drawn Cup RLR clutch Brg Assy
FourPlex Cleat Former	265	FOURPLEX3x443-9	slow down sheave, two groove
FourPlex Cleat Former	266	FOURPLEX3X533	DRIVE PULLEY, TWO GROOVE
FourPlex Cleat Former	267	FOURPLEX6K026	5hp 1 phase motor
FourPlex Cleat Former	268	FOURPLEX5k677	7.5 Hp 1 phase motor
FourPlex Cleat Former	269	FOURPLEX3X449	Two Groove Sheave for 71/2 hp motor
FourPlex Cleat Former	270	FOURPLEX3x534	Drive Pulley, Top Sheave, Two Groove Slow down machine
FourPlex Cleat Former	271	FOURPLEX03042	Bolt
FourPlex Cleat Former	272	FOURPLEX03043	Bolt
FourPlex Cleat Former	273	FOURPLEX03044	Dowel Pin
FourPlex Cleat Former	274	FOURPLEX03045	Set Screw
FourPlex Cleat Former	275	FOURPLEX03046	Cap Screw
FourPlex Cleat Former	276	FOUR-796000003	Switch, Electrical 15 amp LGMCCB
FourPlex Cleat Former	277	FOUR-796000004	Electrical switch cover
FourPlex Cleat Former	278	FOURPLEX03047	Switch 15 Amp mounting box Link
FourPlex Cleat Former	279	FOURPLEX03048	Switch 15 Amp mounting box
FourPlex Cleat Former	280	FOURPLEX03049	5HP (1800)rpm 230 volt, 3 phase, 60Hz
FourPlex Cleat Former	281	FOURPLEX03050	Matched Drive belts
FourPlex Cleat Former	282	FOURPLEX03051	5100-100 Ret Ring
FourPlex Cleat Former	283	FOURPLEX54448	4 IN 1 Entrance Bar