

TIN KNOCKER

TK MANUAL FLANGER

INSTRUCTIONS & PARTS DIAGRAMS



RED RIVER MACHINERY
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TIN KNOCKER SAFETY RULES MANUAL FLANGER

1. Keep the work area well lighted, clean, neat, and orderly to avoid accidents. Do not use compressed air for cleaning debris or grit from yourself or the machine. Remove debris and grit from machine with a rake or brush – not your hands.
2. 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 as well as the warnings and instructions mounted on the machine.
3. Use safety glasses and required protective tools.
4. Do not place speed above safety.
5. Never use a machine or tool for anything other than its intended purpose. Use the proper tool and equipment for the task.

WARRANTY

All new TAAG Machinery Co. 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: This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Readjustment can easily be done by following the procedures described within. 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.

Note: The flanging rolls are a consumable and not subject to warranty.



OPERATING INSTRUCTIONS

Turn crank screw (A) all the way down, then reverse approximately $\frac{1}{4}$ of a turn. Place the edge of material (D), in groove (C). Turn handle (B) and push material into the rolls. Then, adjust crank screw (A) just tight enough to draw material and produce a right angle. On exceptionally small curves, the edge might wrinkle. When this occurs, run through a second time.

CAUTION – The edge of the material must seat against groove (C) in the lower forming roll, to obtain satisfactory height and formed flange. Irregular height or heavy wrinkle flange can be caused by improper pressure.

SPECIFICATIONS

GENERAL: Puts $\frac{7}{32}$ " flange on elbows and other radius fittings.

Bench mounted, there is no gauge to set, and requires

No special tools. Available with stand only.

CAPACITY; 20 Ga. X $\frac{7}{32}$ "

DIMENSIONS: Approx. 10"L x 5"W x 24" H (25 lbs.)

MIN. RADIUS: 1 $\frac{3}{4}$

TO ADJUST TK MANUAL FLANGER:

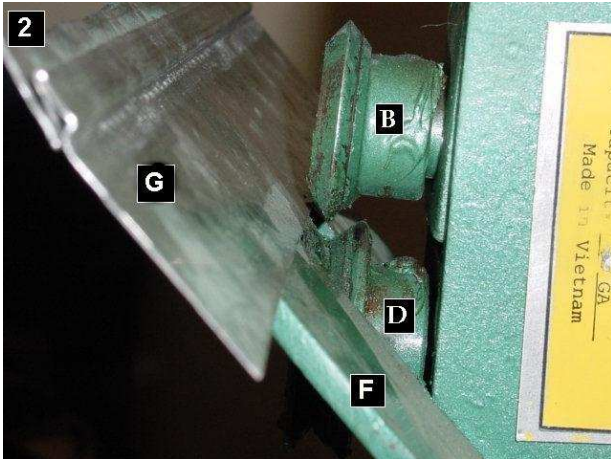


PHOTO No. 2

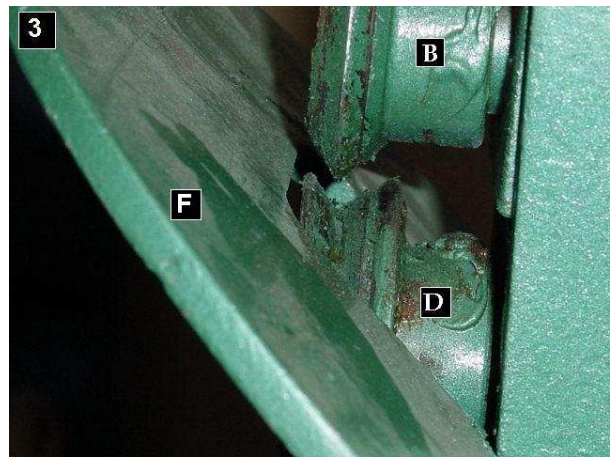


PHOTO No. 3

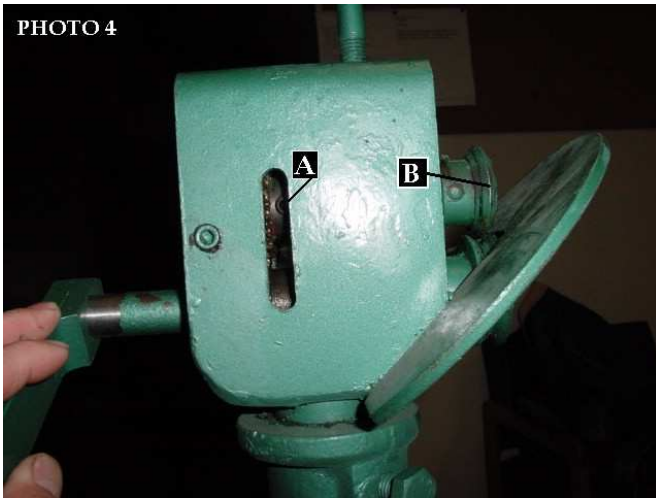


PHOTO No. 4

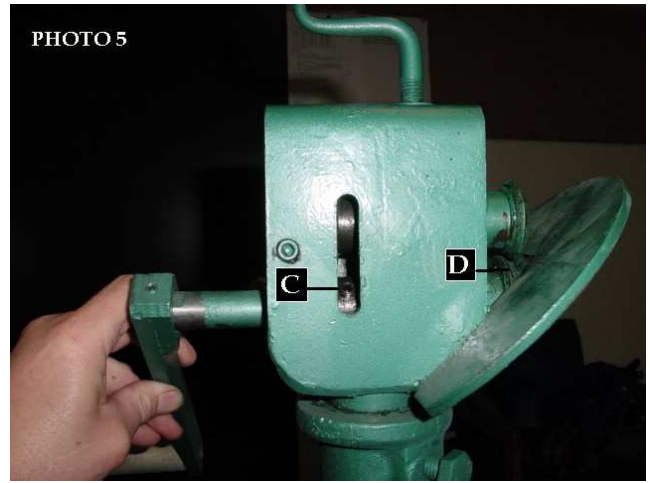


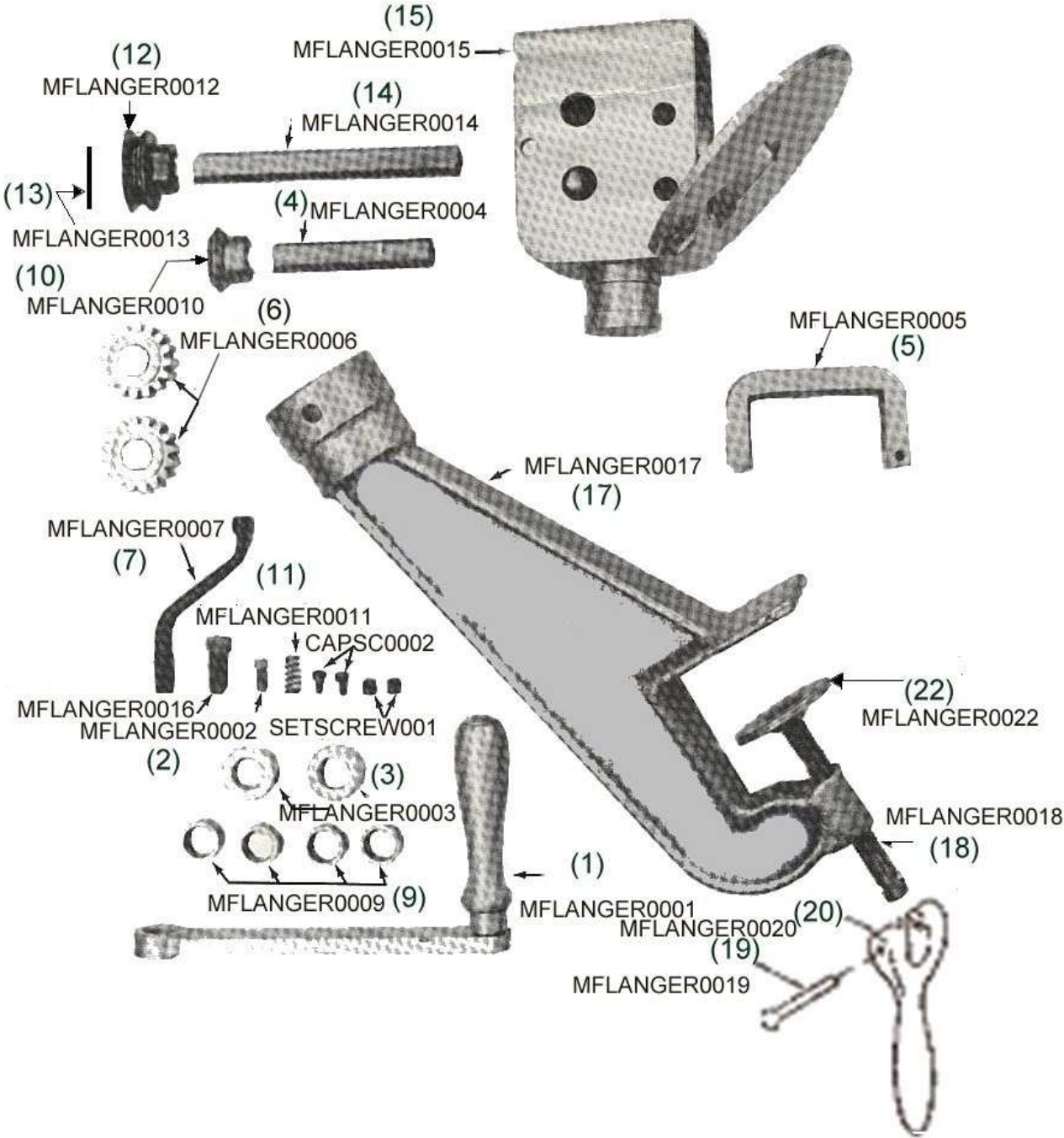
PHOTO No. 5

1. (A) SET SCREW (4mm HEXAGON) TO ADJUST LOCATION OF (B) TOP FLANGER HEAD. See photo 4
2. (C) SET SCREW (4mm HEXAGON) TO ADJUST LOCATION OF (D) BOTTOM FLANGER HEAD. See photo 5

TO ADJUST TK MANUAL FLANGER:

1. LOCATE SET SCREW (C). LOOSEN TO ALLOW REPOSITIONING OF BOTTOM FLANGER HEAD (D), SO MATERIAL WILL SMOOTHLY SLIDE DOWN FLANGER MATERIAL REST PLATE (F), WITHOUT INTERFERENCE OF THE BOTTOM FLANGER HEAD (D). See photo No. 2
2. ONCE PROPER ALIGNMENT IS ACHIEVED, RETIGHTEN SET SCREW (C). See photo No. 5
3. LOCATE SET SCREW (A) LOOSEN TO ALLOW REPOSITIONING OF TOP FLANGER HEAD (B), TO ALIGN / MATE WITH BOTTOM FLANGER HEAD (D). See photo No. 4
4. ONCE PROPER ALIGNMENT IS ACHIEVED. (See Photo No. 3) RETIGHTEN SET SCREW (A). See photo No. 4

FLANGER DRAWING



Parts For Manual Flanger

Fine No.	Part No.	Description	No. REQ"D.
1	FLANGER0001	CRANK ARM ASSEMBLY	1
2	FLANGER0002	SQUARE HEAD CAP SCREW	1
3	FLANGER0003	COLLAR (SHAFT)	2
4	FLANGER0004	TOP ROLL SHAFT	1
5	FLANGER0005	TOP BEARING BRACKET	1
6	FLANGER0006	16 TOOTH GEAR	2
7	FLANGER0007	ADJUSTING HANDLE	1
9	FLANGER0009	BUSHING (BRONZE)	4
10	FLANGER0010	TOP ROLL	1
11	FLANGER0011	COMPRESSION SPRING	1
12	FLANGER0012	Lower ROLL	1
13	FLANGER0013	ROLL PINS	2
14	FLANGER0014	Lower ROLL SHAFT	1
15	FLANGER0015	HOUSING COVER ASSEMBLY	1
16	FLANGER0016	SQUARE HEAD SET SCREW	1
17	FLANGER0017	STAND ASSEMBLY	1
18	FLANGER0018	MOUNTING SCREW ASSEMBLY	1
19	FLANGER0019	MOUNTING SCREW ROLL PIN	1
20	FLANGER0020	MOUNTING SCREW HANDLE	1
21	FLANGER0021	STAND ASSEMBLY W/PUCK/HANDLE	1
22	FLANGER0022	PUCK WITH/SET SCREW	1
23	FLANGERSETSC001	SET SCREWS	2
24	FLANGECAPSC0002	SOCKET HEAD CAP SCREW	2