



Call Account Managers at 1-800-826-6332
Check our website: www.conde.com

Accu Cutter

Operating Instructions

Model PR12W Precision Roller

Unpacking & Assembling the Precision Roller

The Precision Roller is shipped partially assembled. The handle assembly and adjustment screws have been removed to protect them from damage during shipping.

The handle is installed on the end of the front bottom roller. Position the handle so the set screws is aligned with the depression in the roller and tighten the set screw. The handle should extend away from the Precision Roller.

There are four adjustment screws. The shorter adjustment screws are installed in the front edge of the end plates and control the roller with the handle. The longer adjustment screws are installed in the back edge of the end plates and control the forming roller. They should operate freely and may be lubricated with a white grease.

Before any packing materials are discarded, examine the Precision Roller for shipping damage or missing parts. If there is any damage or parts missing, please call Accu Cutter *before* using the Precision Roller.

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Work Surface

Make sure the work surface is clean and free from debris. The Precision Roller should sit reasonable level. There should be sufficient room on all sides of the Precision Roller so nothing will interfere with its operation.

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Mounting to the Work Surface

It is not necessary to mount the Precision Roller to the work surface. However, many operators prefer to do so. Two holes are provided in the base for that purpose. Use two Number 12 flat head screws at least 3 inches in length or two 1/4" flat head bolts that are long enough to pass through the work surface and permit the use of lock washers and nuts.

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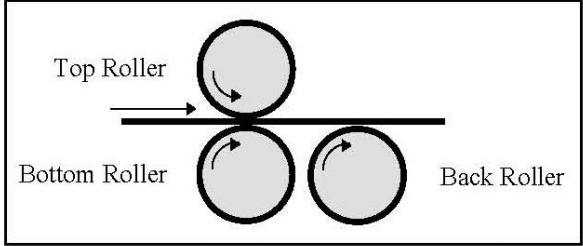
Operating the Precision Roller

The basic operation of the Precision Roller is straight forward. Once you are familiar with it, with practice, you will be able to form metal into a variety of shapes including circles. The minimum bend diameter is one (1) inch. There is no limit on the maximum bend diameter.

With the handle on your right, the important parts of the Precision Roller are as follows:

1. Top Roller. Upper roller located closet to you. It has a gear on the left end.
2. Roller Release. Located on the right side of the Precision Roller, it allows raising the right end or the complete removal of the Top Roller.
3. Bottom Roller. Lower roller located closet to you. It has a gear on the left end and the handle on the right end. It is adjustable with two thumb screws.
4. Back Roller. Located behind the two front rollers. It does not have a gear on either end but is adjustable with two thumb screws.

To operate the Precision Roller

1. With the Top Roller in place and the Roller Release closed, use the thumb screws to adjust the Bottom Roller to the thickness of the metal being formed. The fit should be as tight as is necessary to cause the metal to be pulled between the rollers as the handle is turned in a clock wise direction. No not make the adjustment so tight that the metal is marked or that a lot of pressure is needed to feed the metal between the Top and Bottom Rollers.
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- A schematic diagram of the Precision Roller mechanism. It shows three rollers: a Top Roller at the top, a Bottom Roller at the bottom, and a Back Roller to the right. A horizontal line representing a metal strip passes between the Top and Bottom rollers. Arrows indicate the rotation of each roller: the Top Roller rotates clockwise, the Bottom Roller rotates counter-clockwise, and the Back Roller rotates clockwise. An arrow on the left points to the right, indicating the direction of metal feed. Labels 'Top Roller', 'Bottom Roller', and 'Back Roller' are placed near their respective rollers.
2. While turning the handle in a clock wise direction, feed metal between the Top and Bottom Rollers so that it passes either over or under the Back Roller. (It is generally preferable for the metal to pass over the Back Roller.)
 3. Use the thumb screws to adjust the Back Roller. By raising and lowering it in relation to the two front rollers, the amount of the bend is increased or decreased. Generally, the best result is obtained by bending the metal a little at a time. If one end of the Back Roller is higher than the other, the metal will have a bend that is greater at one end than the other.
 4. **NOTE:** The Precision Roller in the three roller configuration only forms metal when it is passing through the Top and Bottom Rollers *and* over or under the Back Roller. Therefore, if an entire piece is passed through the Precision Roller, there will always be an area at the beginning and end of the piece that is still flat or not formed.



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5. **HINT:** If more than one piece is being formed and more than one pass through the Precision Roller is required, pass all of the pieces through the Precision Roller before making any adjustments and moving to the next step. This will insure that all of your pieces are the same.

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Maintenance

The Precision Roller will operate effectively and efficiently for a long time if it is properly maintained. It is important to inspect the Precision Roller periodically and to be aware of the normal operation so that any change in the operation of the Precision Roller can be detected immediately. Establish a regular maintenance routine which includes the following:

1. Clean the Precision Roller and surrounding work area. Do not use any harsh or strong chemicals or solvents that can damage the appearance or operation of the Precision Roller.
2. Check that the work area is reasonable level.
3. Lubricate with a light grease or oil.
4. Check for loose bolts or fittings.

Safety Instructions

1. Inspect the Precision Roller before use.
2. Do not operate the Precision Roller if any parts are missing or damaged.
3. Do not operate the Precision Roller if it is not functioning properly.
4. Do not operate the Precision Roller without reading the Operating Instructions.
5. Always wear safety glasses.
6. Keep fingers, clothing, and other foreign objects away from and out of the gears, rollers, and other operating parts of the Precision Roller.
7. Keep the Precision Roller and work area clean.



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Parts Information

Precision Roller

PR1201	Metal Handle Arm.....	\$ 20.00
PR1202	5/8" 1/4-20 Button Head screw	2.75
PR1204	3/8" Hex Set Screw	2.25
PR1205	Oilite Bushing.....	4.50
PR1206	2" Knurled Head Screw.....	9.75
PR1207	Lock Washers.....	0.50
PR1208	Metal Handle.....	19.50
PR1209	Roller Release.....	25.00
PR1210W	Top Roller with Gear.....	59.75
PR1211W	Bottom Roller with Gear.....	59.75
PR1212W	Rear Roller, without Gear.....	45.00
PR1213	Table Bottom	20.00
PR1214	Left End Frame	65.00
PR1215	Right End Frame.....	52.75
PR1216	Roller Gear.....	19.95
PR1217	2 1/2" Knurled Head Screw.....	9.75

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Conversion Parts for Column Making

CM100	Slotted Former, 1" Diameter	\$ 49.00
CM112	Slotted Former, 1 1/2" Diameter	65.00
CM114	Slotted Former, 1 1/4" Diameter	59.00
CM138	Slotted Former, HEX	65.00
CM340	Slotted Former, 3/4" Diameter	45.00
CM916	Slotted Former, 9/16" Diameter	39.00



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Installing the Thumb Screws

The four thumb screws have been removed to prevent damage to them during shipping. They must be installed for the PR12 to function properly. If you have received two different sizes, the shorter ones are installed on the side of the PR12 with the two rollers. The holes for the thumb screws are located in the end caps of the PR12 just below the rollers.

If you have any questions or problems, please call **Accu Cutter Company** before using the PR12. Our toll free number is 1-800-345-0062.