

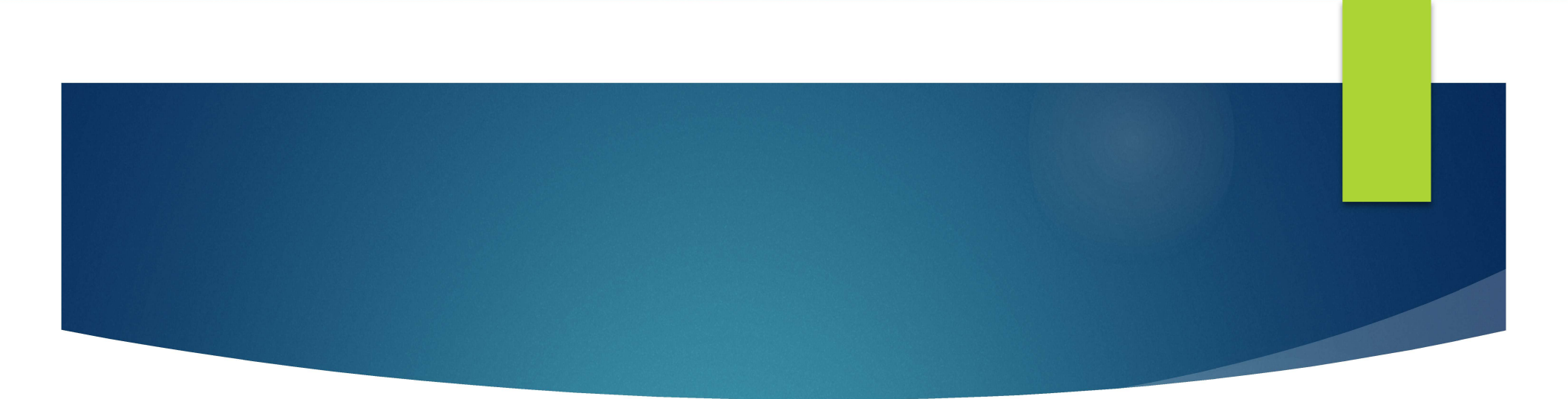
# Slip Roll

- ▶ The slip roll capacity is 16 gauge mild steel.
- ▶ Minimum diameter is 3"
- ▶ Capacity claims to be 40" wide in the user manual, even though its 52" wide.
- ▶ You can roll steel rod into rings from 5/16", 3/8" & 1/2" rod.
- ▶ **Watch your fingers pinch points into the rollers.**
- ▶ Please Keep the slip roll covered & the hand wheel reversed when not in use.





Adjustment for diameter & cone  
dimensions

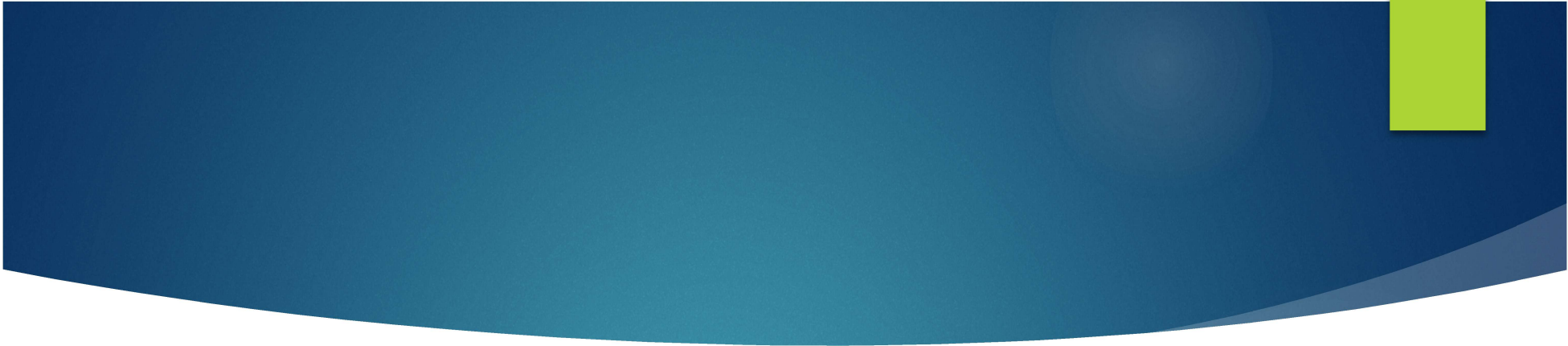


With the sheet metal chosen, set the tension on the roller (green ovals) to where it is snug on both sides.

Lower the rear roller (circled in black) all the way, Begin the cranking on the hand crank. The amount that you will need to crank at a time will depend on the thickness of the material. Once you begin turning a partial circle, turn your sheet 180 degrees & feed back through the rollers. This will get rid of the flat spot between the first roller to the rear roller.

If you look in the light at an angle you will see the small flat spot/crease.

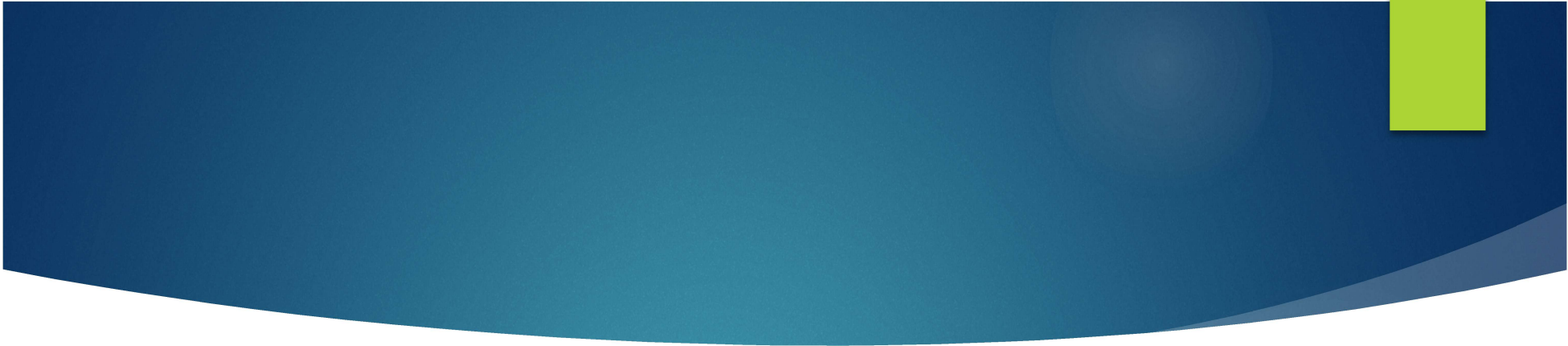
Continue cranking & adjusting the rear roller until you get the dimensions you want. Near the end of a tighter circle, you may need to take less turns. Be sure that you turn each one the same amount.



Additionally, when you get to a closer closed circle, you will have to release the upper roller. Remove the work, then turn it 180 degrees.

Keep with the same procedure until you get the results you want. This will be time consuming.





To make a cone you will need to have your stock cut differently. There are cone calculators out there to use to lay the cut out.

When making a cone, be sure to mark/notate all of your dimensions. Making a proper cone will take quite a bit of time to do it right. By notating the various dimensions, Where you feed it in on the roller as well as the rear roller position will need to be mirrored to get a good cone.

Here is an example say 6"



Measure the same distance from each point,  
This is shown on both of these pictures.

Reverse the work & measure 6"

Read the next page on more setup





Adjust one to desired then measure both. When you reverse your work, then make them swap. For instance if you have 2" on the left & 1" on the right, the reversed would be 1" on the left & 2" on the right. Be sure you use the same reference points, i.e if you measure from the top, then Measure from the top when you reverse it. Also measure like the slide before on the rollers for your position of your work.

