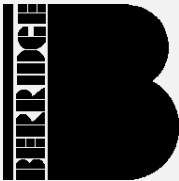
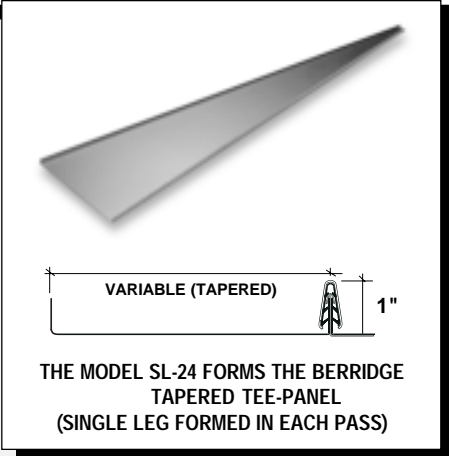
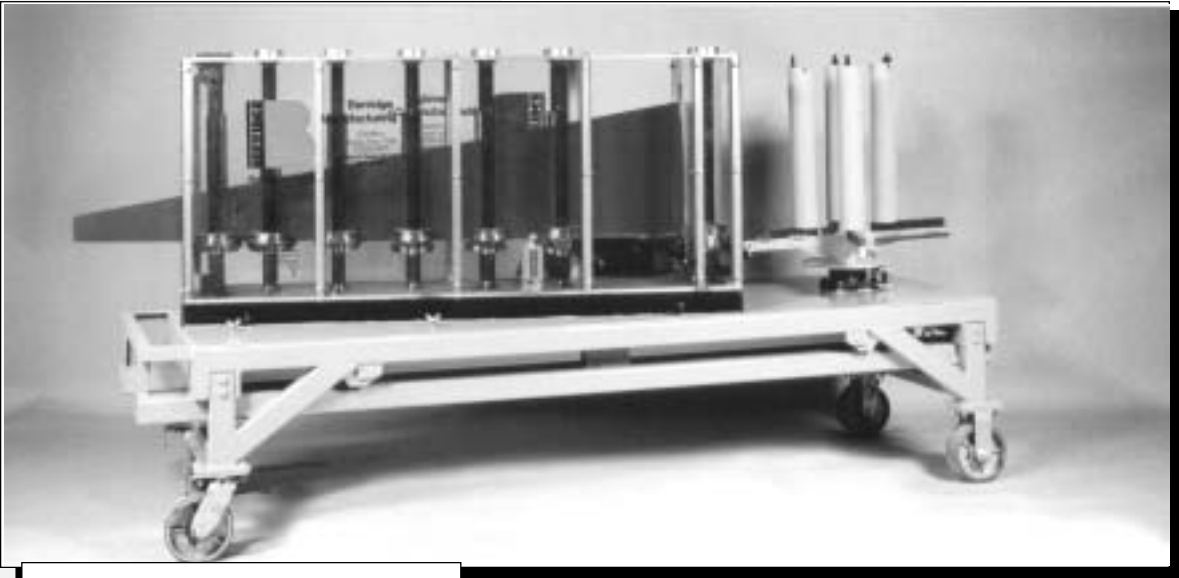


OPERATIONS MANUAL

BERRIDGE MODEL SL-24 PORTABLE ROLL FORMER



*Berridge
Manufacturing
Company*

LEASED TO: _____

DATE: _____ SER. NO.: _____

CONTENTS

I. GENERAL DESCRIPTION	2
II. EQUIPMENT NOMENCLATURE	3
III. OPERATING INSTRUCTIONS	4
IV. MAINTENANCE INSTRUCTIONS	5
V. SAFETY	6
VI. ROLL FORMER RETURN INFORMATION FORM	7

I. GENERAL DESCRIPTION

THE BERRIDGE MODEL SL-24 PORTABLE ROLL FORMER is a precision-manufactured machine designed to provide high quality "Jobsite" production capability for installers of the BERRIDGE TAPERED TEE-PANEL standing seam roof panel (Fig. 1) for use on conical or round-cornered roofs (Fig. 2).

Fig. 1



FIG. 2: TAPERED TEE-PANELS FORMED ON THE SL-24 ARE USED ON CONICAL OR ROUNDED CORNER ROOFS

THE BERRIDGE MODEL SL-24 PORTABLE ROLL FORMER is mounted on a heavy-duty four wheel cart and is completely self-contained, including uncoiler, mechanical shear and counter gauge for measuring panel length.

CASTER BRAKES & LOCKING MECHANISM:

For safety reasons, it is recommended that the foot brakes on each caster be placed in the locked position whenever the roll former is not being moved. Also, note the two front casters have a locking mechanism to keep them from swiveling. This is useful when pulling the cart onto the Berridge Trailer.

MODEL SL-24 MATERIAL USAGE:

Material used with the Berridge Model SL-24 Portable Roll Former must comply with the following parameters:

- Maximum Strip Width 24" (pre-cut strip)
- Maximum Material Thickness 24 Ga. (.024 In.)

Material: Prefinished galvanized or Galvalume,
16 oz. ¼-½ hard Copper

NOTE: Do not run unpainted coil on the SL-24 Portable Roll Former; Unpainted coil may cause flake build-up on rolls. Because the SL-24 is a precision machine, designed to fabricate only Berridge-developed products, only Berridge Coil may be used in these roll-formers. Other coil material may vary in thickness, hardness, and surface treatment which could damage the components of the SL-24 Roll-Former. Also, defective coil material will result in a defective product which could damage the reputation of the high quality Berridge products. Therefore, only Berridge coil is allowed to be used in any Berridge Portable Roll-Former. If it is discovered that any other material has been used in a Berridge Portable Roll-Former, Berridge Manufacturing Company has the right to recall the machine and completely disassemble and inspect it. A service charge will be assessed.

TRANSPORTING THE SL-24:

Never transport the machine without a piece of coil remaining in contact with all rolls. This keeps the rolls from moving while in transit and becoming scarred or damaged. Do not transport the roll former with a coil loaded on the uncoiler unless the uncoiler is blocked to support the weight of the coil.

ELECTRICAL POWER REQUIREMENTS:

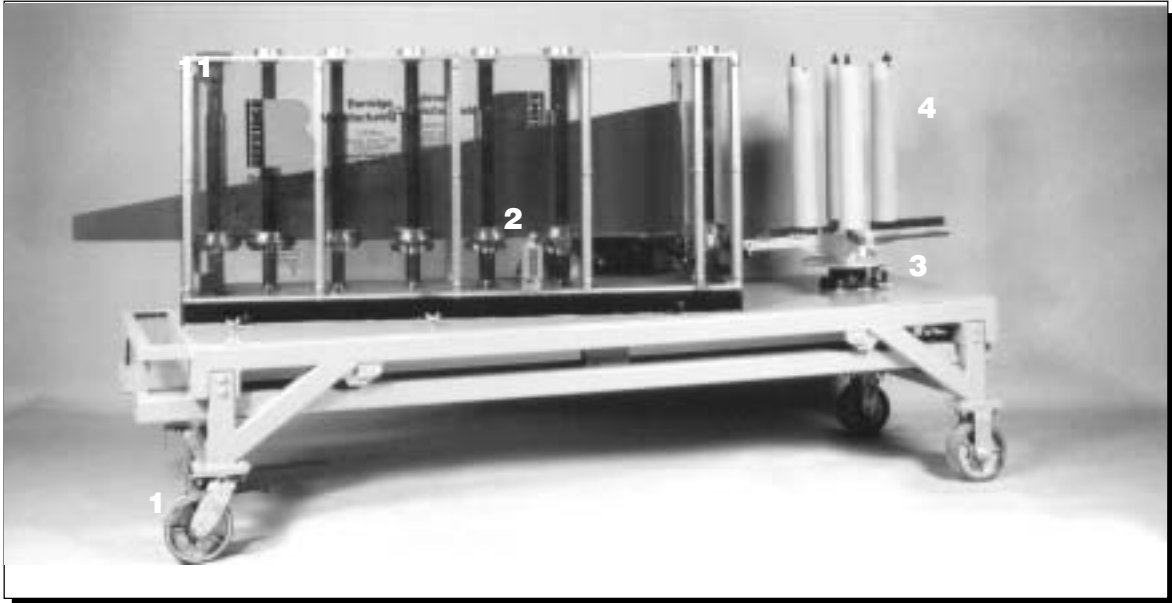
The Berridge Model SL-24 Portable Roll Former requires standard U.S. electrical current of 110 to 120 volts AC 60 cycles. Connect to a grounded supply receptacle with at least 20 amp current capacity. If extension cords are required, use the following recommended sizes:

Length	Wire Gauge
0-50 FT	10
50-100 FT	8
100+ FT	6

NOTE: The use of portable electric generators to power the Model SL-24 is not recommended, as this practice will lead to damage to the electric motor.

II. EQUIPMENT NOMENCLATURE

MODEL SL-24 PORTABLE ROLL-FORMER



FEATURES:

1. CASTERS
2. DRUM SWITCH
3. BRAKE ADJUSTMENT
4. UNCOILER

ROLL FORMER SPECIFICATIONS

WIDTH: 2'-10"
LENGTH: 9' - 7"
HEIGHT: 5' - 1"
WEIGHT: 2100 LBS W/ COVER
SPEED: 45' PER MINUTE
MOTOR: 1 H.P. 110V. SINGLE-PHASE
ELECTRIC

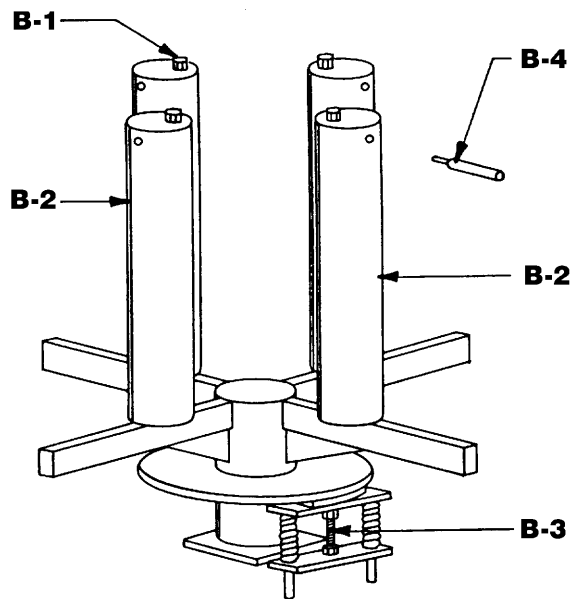
III. OPERATING INSTRUCTIONS

STEP ONE - LOADING COIL

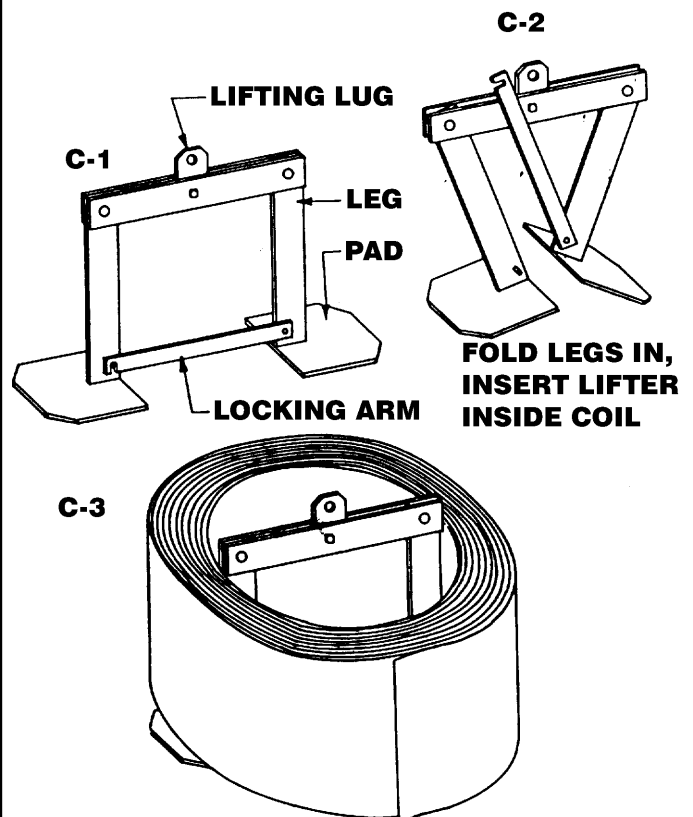
- A. Lock all four casters.
- B. Rotate the eccentric tubes (Detail B-2) on the uncoiler by loosening the nuts on top of tubes (Detail B-1). Then rotate tubes inward to accept the coil.
- C. Load the coil with painted side facing toward operator side of rollformer, with leading edge toward the machine.
- D. Unlock arm of the coil lifter apparatus (Detail C-1), fold legs inward (Detail C-2) and place inside the coil (Detail C-3). The coil lifter legs should now be locked in place and the coil should be fully seated on the pads of the coil lifter legs.
- E. Using a forklift or other suitable hoist with a minimum load capacity of 2000 pounds, pick up the coil by means of a chain (sized to accommodate load) attached to the top of the coil lifter. Keep to one side of coil and avoid standing underneath it during the loading operation. Next, lower the coil onto the uncoiler, and keep it centered on the uncoiler with the leading end positioned clockwise, ready to feed into the machine.

STEP TWO - FEEDING COIL INTO THE ROLLFORMER:

- A. The SL-24 is not equipped with a shear; instead, pre-cut blanks are fed into the machine. Apply constant downward pressure on the material strip between stations 1 and 2 where the shear would normally be located.
- B. The Drum Switch located on the side of the rollformer controls the direction of the coil through the rolls. With the switch in the forward mode, the coil will proceed through the various forming stages. At this time, run any metal left in the rolls through the machine to make way for the new coil.
- C. Clip the corners of the leading edge of the coil before feeding into the rolls.
- D. By hand (*DO NOT TOUCH DRUM SWITCH DURING THIS SEQUENCE*) insert the leading end of the coil through the slot in the plastic guard and let it slide on the lower support bar until the coil enters the first set of rolls.
- E. Turn the Drum Switch to the forward mode, apply some hand pressure on the coil (*KEEP HANDS CLEAR OF INSIDE THE PLEXIGLAS*) to force it into the rolls and down on the support bar until it feeds by itself.
- F. If the uncoiler moves too freely or if the material slips in the roll, it may be necessary to adjust the uncoiler brake by loosening or tightening the adjustment bolt (Detail B-3). *NOTE:* Loosen locknut and rotate bolt clockwise for increased brake pressure or counter-clockwise to decrease brake pressure.



B-1 LOCKING NUTS
B-2 ECCENTRIC TUBES
B-3 BRAKE ADJUSTMENT BOLT
B-4 ECCENTRIC TUBE ADJUSTMENT TOOL



III. OPERATING INSTRUCTIONS

STEP THREE - RUNNING PANELS

I. PREPARING MATERIAL FOR FORMING TAPERED PANELS:

Using measurements taken directly from the curved corner or conical area of the roof substrate, pre-cut strips of coil material to the radius of the roof area (from eave to ridge or center apex of cone). The SL-24 will accommodate up to 24" wide pre-cut strips.

II. RUNNING TAPERED PANELS:

A. Form a single leg along the bottom edge of the pre-cut blank strip by feeding the material through the SL-24 (Figure 1).



FIG. 1: FEED PRE-CUT STRIP THROUGH SL-24 TO FORM FIRST LEG

B. Use a chalked string line to mark for the diagonal cut on the single-leg panel. (Fig. 2) Use a pattern to verify correct length and taper before cutting the metal. Be sure to allow adequate material width for the second leg to be formed.



FIG. 2: MARK A CHALK LINE FOR THE DIAGONAL TAPER CUT....

C. Make the diagonal cut (Fig. 3)



FIG. 3: MAKE THE DIAGONAL CUT IN THE SINGLE-LEG PANEL

D. Form the second leg in the Tapered Tee-Panel by feeding the strip through the SL-24 with the first leg on top (Fig. 4)



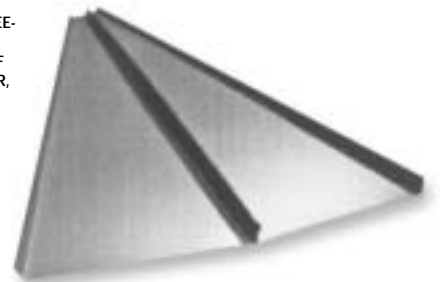
FIG. 4: FORM THE SECOND LEG TO COMPLETE THE TAPERED TEE-PANEL

E. Allow one man for every 10 foot length of panel being run to support panel and carry without causing the panels to buckle.



FIG. 5: EXERCISE CARE IN HANDLING LONG TAPERED PANELS

FIG. 6: RESULTING TAPERED TEE-PANELS ARE USED ON EITHER ROUNDED ROOF CORNERS OR CIRCULAR, CONICAL ROOFS.



IV. MAINTENANCE INSTRUCTIONS

THE BERRIDGE MODEL SL-24 PORTABLE ROLL FORMER requires very little maintenance. To insure the highest quality product and maximum machine life, the following routine preventative maintenance is required. Keep the machine DRY, CLEAN & DIRT-FREE; this is a precision piece of equipment. Keep a MAINTENANCE LOG.

- A. Remove Lexan panels from both sides. Clean the CHROME ROLLS with any penetrating type lubricant with Teflon. Berridge recommends *ZEP #45, TRI-FLOW* with Teflon. Do not spray the lubricant on the Lexan panels.
- B. Clean the LEXAN SIDE PANELS with glass cleaner (Windex or equiv.) and the ALUMINUM FRAME with liquid household cleaner. This will remove lubricant and dirt from the aluminum frame.
- C. The SHEAR, UNCOILER and CASTER may be lubricated with a good grease. Lubricate the upper and lower bearing on the Uncoiler. Do not apply grease to the drive gears on No. 1 Station as any dirt, paper etc. on the coil will collect on the grease.
- D. The DRIVE CHAINS may be lubricated with the same type Teflon lubricant.
- E. The MAIN DRIVE GEAR BOX uses a 90 weight gear oil designed for worm type gear boxes.
- F. The TABLE can be cleaned with any liquid household cleaner. Touch-up as needed with Glidden "Bolt Green" paint.
- G. Lubricate the SLIDES & SHEAR once every 3 months.
- H. Check tightness of all MOUNTING BOLTS & SCREWS regularly, especially after each time the machine has been in transit.

NOTE TO LESSEES:

The Berridge Model SL-24 Roll Former Machine is shipped in good working condition and must be returned in the same condition. The cost of any required repairs for damage or deterioration caused by misuse or negligence will be charged to lessee.

V. SAFETY

It is important to abide by normal safety rules when operating the BERRIDGE MODEL SL-24 PORTABLE ROLL FORMER. While Berridge recommends the following minimum safety practices, the company accepts no responsibility for personal injury or property damage incurred while operating the machine.

- A. Make sure electrical outlet is grounded.
- B. Do not operate machine in rain or stand in water while operating .
- C. Make sure electrical cord is free of cuts and exposed wire.
- D. Keep hands and clothing out of the rolls and the shear blade.
- E. Keep wheels locked on the machine except when necessary to physically move it.
- F. Do not stand under coil when loading or unloading machine.
- G. Do not operate machine with plexiglass panels removed.



**PORTABLE ROLLFORMER
RETURN INFORMATION**

DATE RETURNED _____

MODEL # _____

SERIAL # _____

COIL HOOK CRATE TARP

MISCELLANEOUS (LIST) _____

COMMENTS _____

REPAIRS: _____

LABOR COST: _____

PARTS COST: _____

FILL OUT & MAIL OR FAX TO:

**BERRIDGE MANUFACTURING COMPANY
ROLL FORMER OPERATIONS**
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Seguin, Texas 78155
Fax: 830-303-0530



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