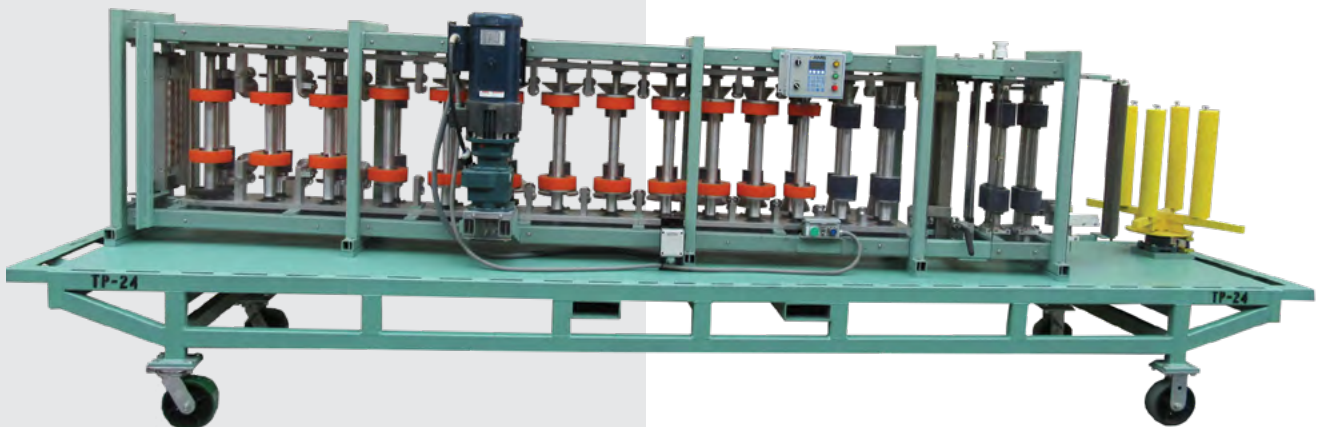
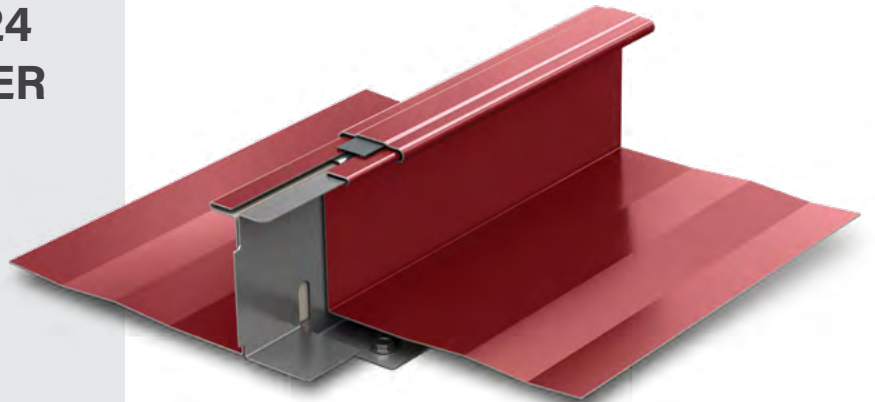


# OPERATIONS MANUAL

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**BERRIDGE MODEL TP-24  
TEE-Lock ROLL FORMER**



**BERRIDGE**  
MANUFACTURING COMPANY

(800) 669-0009 | [WWW.BERRIDGE.COM](http://WWW.BERRIDGE.COM)

FOR TECHNICAL ASSISTANCE CALL:  
(830) 401-5200

LEASED TO: \_\_\_\_\_

\_\_\_\_\_

DATE: \_\_\_\_\_

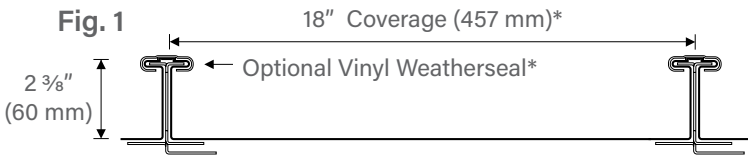
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# CONTENTS

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

## I. GENERAL DESCRIPTION

**THE BERRIDGE MODEL TP-24 PORTABLE ROLL FORMER** is a precision-manufactured machine designed to provide high quality "Job site" production capability for installers of the Berridge Tee-Lock standing seam roof (Fig. 1).



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

### CASTER BRAKES & LOCKING MECHANISM:

For safety reasons, it is recommended that the 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.

### MODEL TP-24 COIL USAGE:

Coil material used with the Berridge Model TP-24 Portable Roll Former must comply with the following parameters:

- Coil Width..... 23.875 inches (nom. 24")
- Max Weight..... 2000 Lbs.
- Max Outside Diameter ..... 32 Inches
- Min Inside Diameter..... 20 Inches

### Material

Prefinished galvanized or Galvalume: 24 GA and 22 GA  
 Aluminum: 0.032" and 0.040"

**NOTE:** Do not run unpainted coil on the TP-24 Portable Roll Former. Unpainted coil may cause flakes build-up on rolls. Because the TP-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 TP-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 TP-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.

### ELECTRICAL POWER REQUIREMENTS:

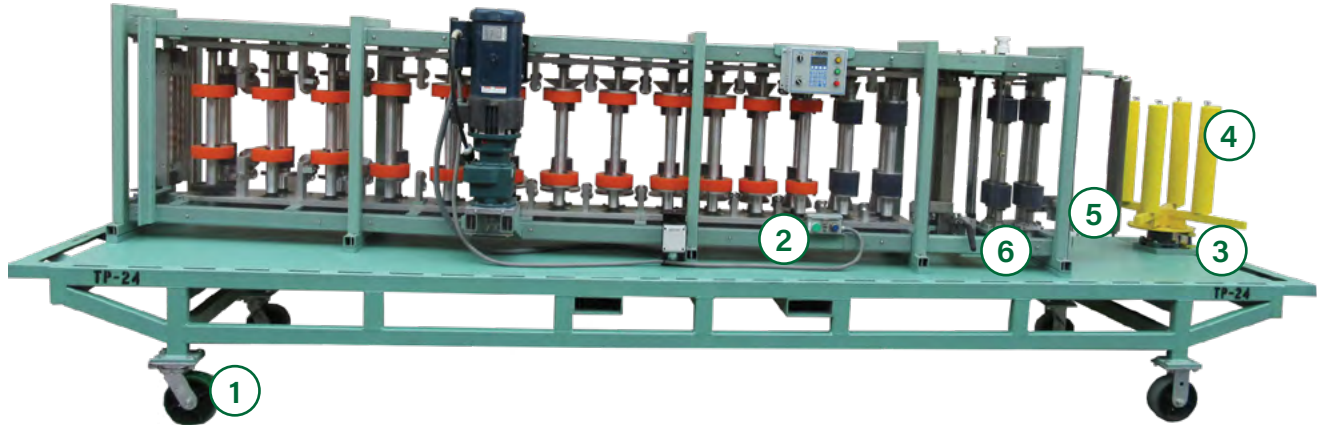
The Berridge Model TP-24 Portable Roll Former requires standard U.S. electrical current of 240 volt single phase power. Connect to a grounded supply receptacle with at least 30 amp current capacity. If extension cords are required, use the following recommend sizes:

Length	Wire GA
0-100FT .....	10
100+FT .....	8

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

## II. EQUIPMENT NOMENCLATURE

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### FEATURES:

1. Casters
2. Drum Switch
3. Brake Adjustment
4. Uncoiler
5. Counter
6. Shear Handle

### ROLL FORMER SPECIFICATIONS

<b>WIDTH:</b>	3'-8"
<b>LENGTH:</b>	18' - 3"
<b>HEIGHT:</b>	5'
<b>WEIGHT:</b>	5,000 LBS
<b>SPEED:</b>	45' PER MINUTE
<b>DRIVE UNIT:</b>	5 H.P. 240V. 30AMP SINGLE-PHASE ELECTRIC

### III. OPERATING INSTRUCTIONS

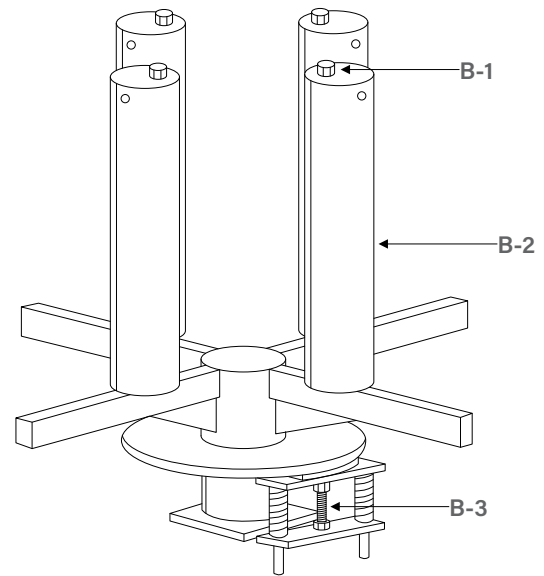
#### STEP ONE - LOADING COIL

1. Lock all four casters.
2. 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.
3. Load the coil with painted side facing toward operator side of roll former, with leading edge toward the machine.
4. 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.
5. 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.

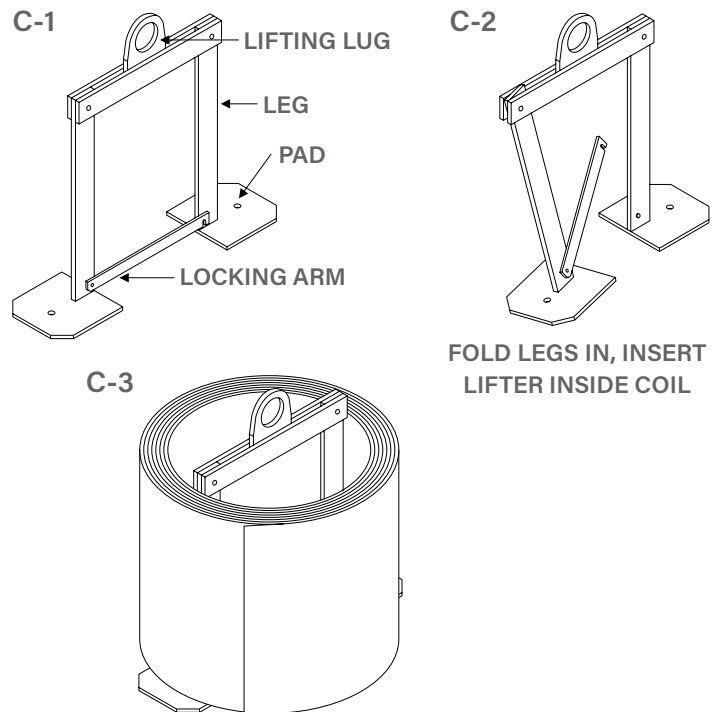
#### STEP TWO - FEEDING COIL INTO THE ROLL FORMER:

1. Prior to handling the metal, make sure gloves are used at all times.
2. Make sure slit shear is resting on bottom plate of machine.
3. The Drum Switch located on the side of the roll former 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. Turn Drum Switch to forward; motor will start but rollers will not turn. To feed the coil through machine, press green jog button located above shear station.
4. Clip the corners of the leading edge of the coil before feeding into the rolls.
5. Insert the leading end of the coil into the feed-in guides and let it slide on the lower support bar until the coil enters the first set of rolls.
6. 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

7. down on the support bar. Press green jog switch to jog coil into first set of rollers and past shear.
7. 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 NUT  
B-2 ECCENTRIC TUBES  
B-3 BRAKE ADJUSTMENT BOLT



### III. OPERATING INSTRUCTIONS

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#### STEP THREE - RUNNING PANELS

1. Allow one man for every 10 foot length of panel being run to support panel and carry without causing the panel to buckle.
2. The panel **MUST** be held in a horizontal plane, level with the position in which it leaves the rolls. If this procedure is not followed, it may result in unequal leg heights, buckling of panel or possible "oil-canning" of panel.
3. See computer operation instructions to program quantities and lengths.
4. When the panel stops at the programmed length, cut the panel to length using the shear on the roll former.

#### STEP FOUR - SEAMING OPERATION

1. After you have run the panels and installed the required accessories at gables and eave flashing (refer to Tee-Lock Typical Installation Details), place the first Tee-Lock panel at one gable end.
2. Remove strippable film from all panels surfaces including the edges of both seam legs BEFORE installing panels.
3. Install either the Continuous Tee-Rib or Tee-Clips along the leading leg of the first Tee-Lock panel.
4. Prepare the sidelap seam for machine seaming by crimping the starting end of the sidelap using the Hand Crimper Tool (Fig. 1). This creates a seamed area where the Tee-Lock Seamer Machine will be positioned to commence seaming the sidelap. Crimp the sidelap every 4'-0" prior to seaming.
5. The machine seaming of the Tee-Lock panel is done immediately after the installation of each panel.
6. Refer to the Tee-Lock Seamer Operations Manual for instructions on seaming the panel sidelaps.

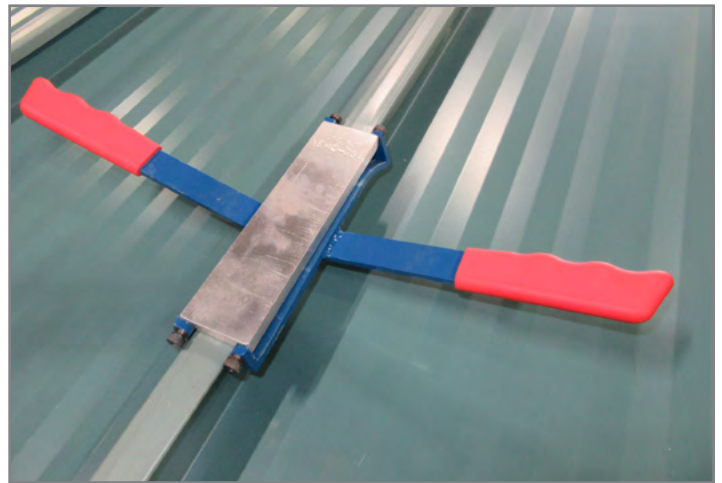


FIG. 1: HAND SEAMING TEE-LOCK SIDELAP TO PROVIDE A STARTING POINT FOR SEAMING MACHINE

## IV. MAINTENANCE INSTRUCTIONS

**THE BERRIDGE MODEL TP-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**.

1. Prior to performing any maintenance on the machine, and/or removing Lexan panels or guards, verify that machine is disconnected from all electrical power so as to prevent any accidents.
2. Remove Lexan panels from both sides. Clean the **STAINLESS STEEL ROLLS** with mineral spirits. Do not spray the lubricant on the Lexan panels.
3. 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.
4. The **UNCOILER** and **CASTER** may be lubricated with a grease gun with general-purpose 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.
5. The **DRIVE CHAINS** may be lubricated with a spray-on chain lubricant.
6. The **MAIN DRIVE GEAR BOX**: Rexnord and Dodge boxes need no lubrication. Use SPO-244 by Lubriplate or equal in Euro Drive Gear Boxes.
7. The **TABLE** can be cleaned with any liquid household cleaner. Touch-up as needed with Glidden "Bolt Green" paint.
8. Check tightness of all **MOUNTING BOLTS & SCREWS** regularly, especially after each time the machine has been in transit.

## V. SAFETY

It is important to abide by normal safety rules when operating the **BERRIDGE MODEL TP-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.

1. Make sure electrical outlet is grounded.
2. Do not operate machine in rain or stand in water while operating.
3. Make sure electrical cord is free of cuts and exposed wire.
4. Keep hands and clothing out of the rolls and the shear blade.
5. Keep wheels locked on the machine except when necessary to physically move it.
6. Do not stand under coil when loading or unloading machine.
7. Do not operate machine with plexiglass panels removed.

**PORTABLE ROLL FORMER RETURN INFORMATION**

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DATE RETURNED: \_\_\_\_\_

MODEL NUMBER: \_\_\_\_\_

SERIAL NUMBER: \_\_\_\_\_

COMPUTER NUMBER: \_\_\_\_\_

COIL HOOK  CRATE  TARP

MISCELLANEOUS (LIST) \_\_\_\_\_

COMMENTS \_\_\_\_\_

\_\_\_\_\_

REPAIRS: \_\_\_\_\_

\_\_\_\_\_

LABOR COST: \_\_\_\_\_

\_\_\_\_\_

PARTS COST: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

**FILL OUT & MAIL OR FAX TO:**

**BERRIDGE MANUFACTURING COMPANY  
ROLL FORMER OPERATIONS**  
2201 Rudeloff Road  
Seguin, TX 78155  
Fax: (830) 303-0530

***NOTE TO LESSEES:***

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The Berridge Model TP-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.

## **CORPORATE HEADQUARTERS**

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