



**BERRIDGE  
MANUFACTURING  
COMPANY**

2201 Rudeloff Road  
Seguin, TX 78155  
Sales: (800) 669-0009  
Roll Former Dept: (830) 303-0811  
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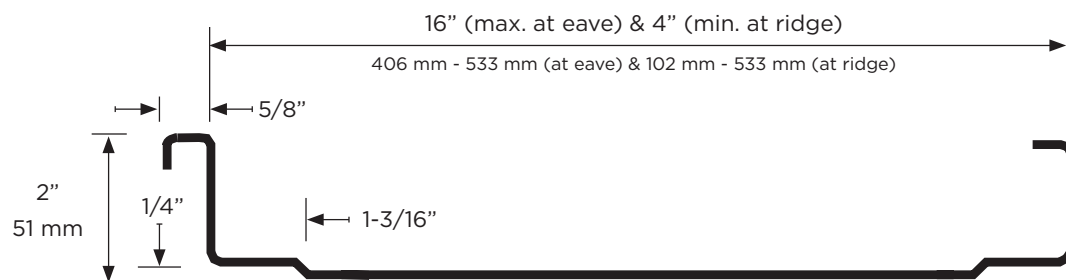
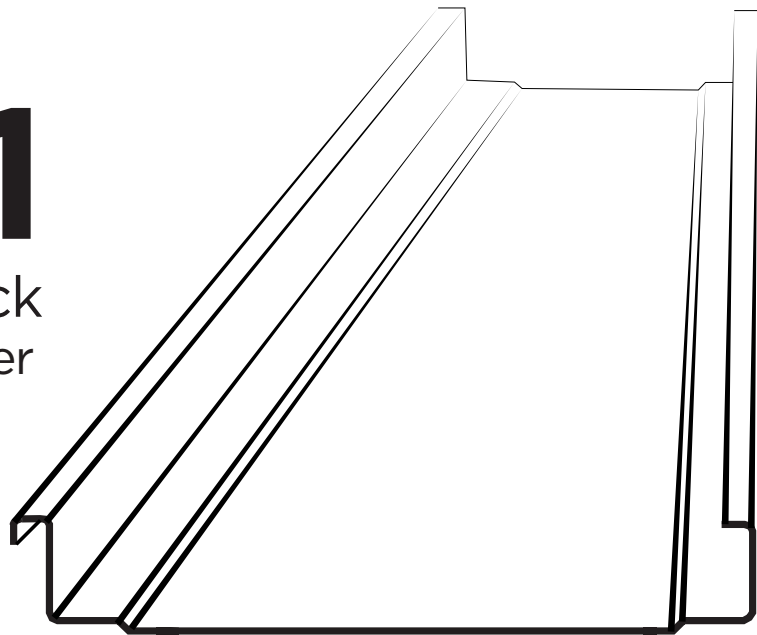
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# Operations Manual

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## TZ-21

Tapered Zee-Lock  
Portable Roll Former



Zee-Lock Panel Cross-Section

# Manual Contents

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## Overview

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The Berridge TZ-21 Portable Roll Former produces tapered Berridge Zee-Lock panels in a two-stage operation. The female leg is run first from a coil loaded onto the uncoiler on the roll Former table. After the panel with the female leg is formed to the desired length, the strip edge opposite the formed leg is cut to the desired taper. The strip is then fed through the male leg machine to complete the panel. See the “Operating Instructions” section for more details.



# General Description

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## Roll Former Dimensions & Weight

Length .....	12'-2"
Width .....	4'-6"
Height .....	5'-4"
Weight.....	4,600 lbs

## Coil Usage

Material .....	Prefinished galvanized or Galvalume
Gauge .....	22 GA or 24 GA
Maximum Coil Weight .....	2000 lbs
Maximum Coil Width .....	20-7/8"
Minimum Coil Width .....	See Figure 2

## Electrical Power Requirements

The Berridge Model TZ-21 Portable Roll Former requires standard U.S. electrical current of 220 volt single phase power with a 20 amp capacity. A 4 wire service, including a neutral and a ground, must be used to ensure proper grounding of the equipment.

Electrical Receptacle .....	NEMA L1420 R
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## Cord Size

0-200 ft .....	10 Gauge
200-300 ft.....	8 Gauge

# Operating Instructions

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## Two-Stage Forming Process

Forming panels with the Berridge TZ-21 is a two-stage operation. There are two roll formers mounted on the table for producing tapered panels. One roll former forms the female leg on the coil strip (stage 1); the other roll former forms the male leg on the coil strip (stage 2).

Panels must be produced using the following sequence of operations:

1. Load a 20-7/8" wide coil on the uncoiler using the same procedure as other Berridge Roll formers and thread the coil into the female leg roll former.
2. Run panels with the female leg to the desired length.
3. Layout the taper along the unformed strip edge; cut the taper and square up both ends.
4. Run the tapered strips through the male leg roll former, completing the tapered panels for your project.

**NOTE:** Do not attempt to run both roll formers at the same time. This will cause the electrical service to overload and trip the circuit breaker.

## Operating Instructions (Cont.)

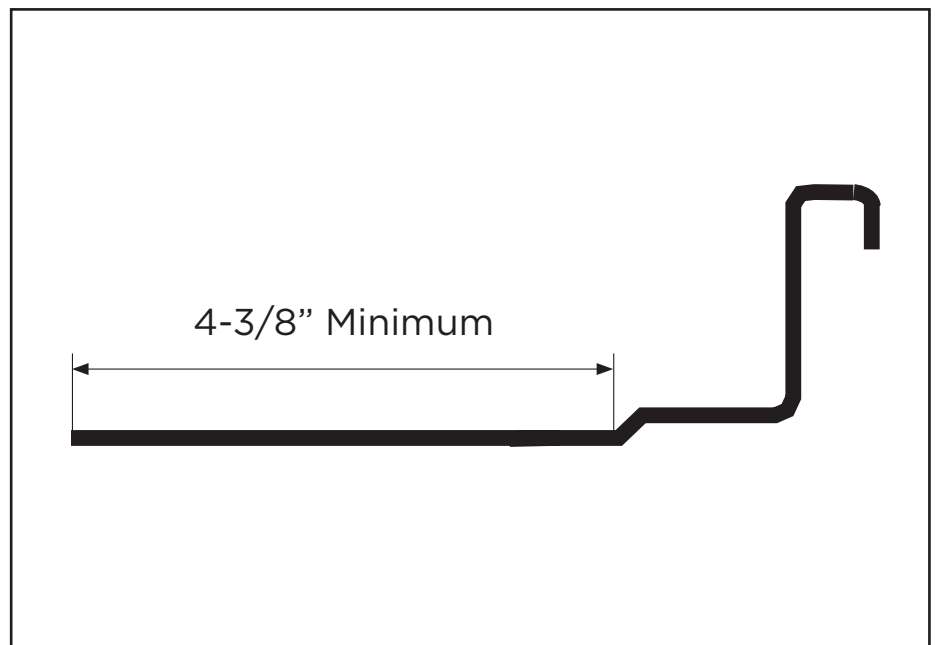
**FIGURE 1:**

Running the female leg from a 20-7/8" wide coil.



**FIGURE 2:**

Cut the taper along the unformed edge. Do not cut it narrower than 4-3/8" from the panel shoulder to prevent jamming in the male leg roll former.



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## Operating Instructions (Cont.)

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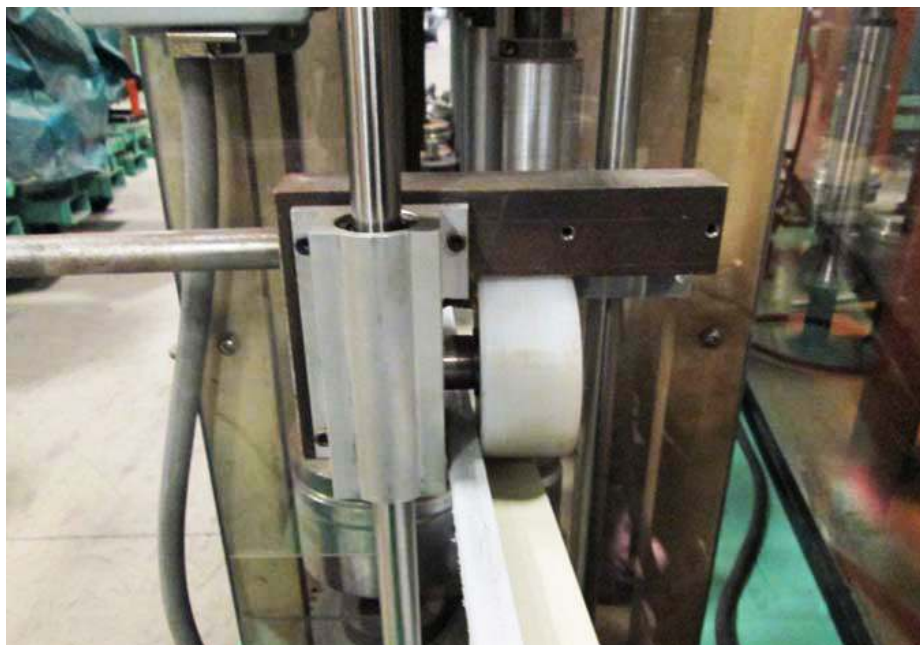
**FIGURE 3:**

Panel inserted into 1st and 2nd feed-in guide. First sliding hold-down roller resting on top edge of panel to hold panel in place while forming.



**FIGURE 4:**

Close-up of first sliding hold-down roller resting on top edge of panel.



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## Operating Instructions (Cont.)

**FIGURE 5:**

Panel fed into 2nd sliding hold-down roller. Make sure 2nd hold-down roller is raised above panel, feed panel forward until leading edge is slightly past 2nd hold-down roller, then lower roller to rest on panel edge as shown in Fig. 4.



**FIGURE 6:**

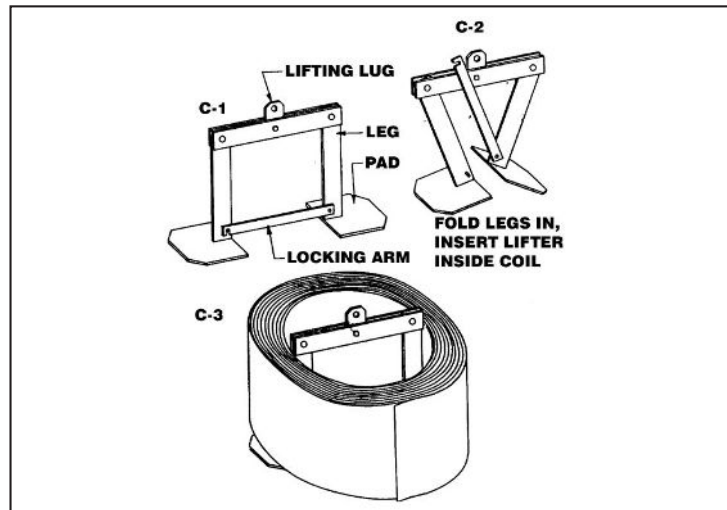
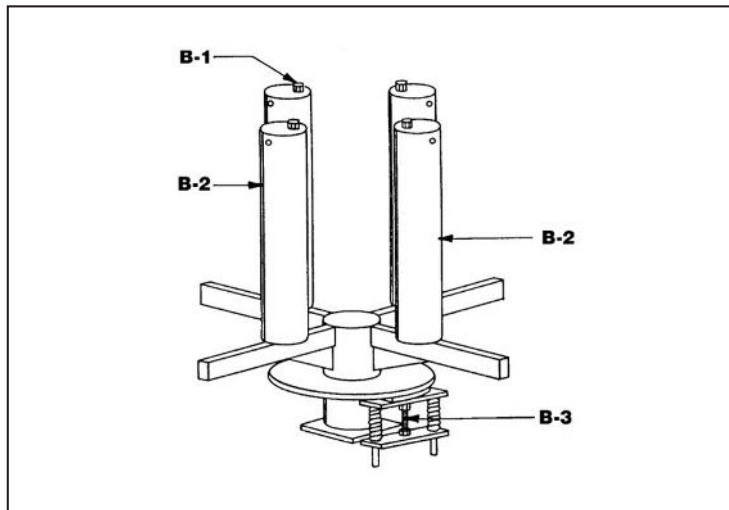
Panel passing through machine with sliding hold down rollers rising as panel passes through roll former. Allow rollers to simply fall back down after panel passes through.



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## Operating Instructions (Cont.)



### How to Load Coils:

1. Lock all four casters.
2. Rotate the eccentric tubes (B-2) on the uncoiler by loosening the nuts on top of tubes (B-1). Then rotate tubes inward to accept the coil.
3. Load the coil with the painted side facing toward operator side of roll former, with leading edge toward the machine.
4. Unlock arm of the coil lifter apparatus (C-1), fold legs inward (C-2) and place inside the coil (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 lbs, 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 coil 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.



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# Safety

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## Minimum Safety Practices:

It is important to abide by normal safety rules when operating Berridge portable roll formers. 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 standing water.
3. Make sure electrical cord is free of cuts and/or 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 Plexiglas panels removed.

# Maintenance

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Berridge roll formers require minimum maintenance. To insure the highest quality product and maximum machine life, the following routine preventive maintenance is required. Keep the machine DRY, CLEAN, AND DIRT-FREE. This is a precision piece of equipment. Keep a Maintenance Log.

1. Remove lexan (plexiglass) panels from both sides. Clean the stainless steel rolls with mineral spirits. Do not spray lubricant on the lexan panels.
2. Clean the lexan side panels with glass cleaner (Windex or equivalent) and the aluminum frame with liquid household cleaner. This will remove lubricant and dirt from the frame.
3. The uncoiler and casters 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.
4. The drive chain may be lubricated with any good quality spray-on chain lubricant.
5. Main drive gear box:  
Grove Right Angle: Uses a 90 weight gear oil  
Eurodrive Vertical Inline: Uses SPO-244 by Lubriplate or equal  
Rexnord Vertical or Dodge Quantis Vertical: Does not require lubricant
6. The table can be cleaned with any liquid household cleaner. Touch-up as needed with Glidden "Bolt Green" paint.
7. Check tightness of all mounting bolts and screws regularly, especially after each time the machine has been in transit.



# Portable Roll Former Return Information Form

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Date Returned \_\_\_\_\_

Model No. \_\_\_\_\_

Serial No. \_\_\_\_\_

Coil Hook ☐

Crate ☐

Tarp ☐

Miscellaneous \_\_\_\_\_

Comments \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Repairs \_\_\_\_\_

Labor Cost \_\_\_\_\_

Parts Cost \_\_\_\_\_

**Fill out and mail or fax to:**  
Berridge Manufacturing Co.  
Roll Former Operations  
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Seguin, TX 78155  
Fax: (830) 303-0530