



ROLL FORMER CORP.

**Manufacturers of quality roll forming equipment –
leading the industry with over twenty years of
innovation and service.**

**RTR 16/15
WITH C48CS003 CONTROLLER**

**ROLL FORMER CORP.
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140 Independence Lane
Chalfont, Pa. 18914

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


Jesse Scott –	Ext.-25
Glenn Householder—Tech Service	Ext. 25
John Dumke – Sales	Ext.-13

RTR 16/15 RECOILER OPERATING MANUAL

- 1) Align the master coil so that it is in line with the left guide plate.
- 2) Lift the red cam handle to raise the top pinch rolls.
- 3) Insert the metal up to the face of the shear, and lower the cam handle. The metal will stay in position.
- 4) Important safety requirement, turn the speed control knob to zero.**
- 5) Turn the recoiler on using the red toggle switch.
- 6) Make sure that the drum is fully expanded to the 16" diameter.
- 7) Program the controller using the simple instructions listed on a separate sheet.
- 8) Once the unit is programmed and reset to zero, engage crank handle and advance the metal to the drum. Disengage crank handle.
- 9) Fold approximately ½ to 1 inch of material over the edge of the drum leaf.
- 10) You are now ready to recoil the customer coil.**
- 11) Slowly turn the speed control knob in a clockwise direction until at least 1&1/2 turns are completed and then increase the speed to a comfortable speed.
- 12) The re-coiler will stop automatically at the preset length.
- 13) Important safety requirement; immediately return the speed control knob to zero.**
- 14) Pull the shear handle down with a firm quick action.
- 15) PUSH THE RESET BUTTON.
- 16) Lay the film on the coil and using the speed control knob slowly wrap the number of turns as needed.
- 17) When finished, return the speed control knob to zero.**
- 18) Reduce the drum diameter by turning the drum handle 6 to 8 turns in a counter clockwise direction.
- 19) Remove the coil. The process is now complete.
- 20) Return to item #7 to repeat the process.

RTR 16/15 PROGRAMMING MANUAL

The C48C controller is designed to control the length of the coil you wish to recoil accurately, quickly and safely.

- 1) Important safety requirement, turn the speed control knob to zero.
- 2) Turn the system on by pressing the red toggle switch on the DC power unit.
- 3) The LCD display will turn on and you are ready to program the desired length.
- 4) Press and hold the  button for two seconds or until program entry flashes on the LCD Display.
- 5) Using the  button scroll through the preset parameters until reaching the preset option.
- 6) To change the length value press the  button for increasing the value or the  button to decrease value.
- 7) Continue to press either button until value is reached.
- 8) Once value is reached press and hold the  button until programs save appears on the read out.
- 9) **IMPORTANT SAFETY REQUIREMENT.** Make sure the speed control button is turned to zero.
- 10) Press the reset button and you are ready to spin a new coil.
- 11) Return to (4) above the program a different coil length.

PRESCALER


The prescaler calibrates the encoder to insure the accurate measuring of the coil length. Once this factor is determined, it is generally not necessary to change it. Write this number down after it has been determined in case it is accidentally erased from the controller. This will save you the trouble of refiguring the factor.

To determine the prescaler:






- 1) Turn the machine on using the red toggle switch. Important safety requirement turn speed control knob to zero.
- 2) Set panel length to a long length of (20.0 foot or greater)
- 3) Insert metal into machine and past shear approximately $\frac{1}{2}$ ".
- 4) Make cut and reopen shear.
- 5) Push the F1/RST button to reset.
- 6) Manually crank material through machine until length is achieved.
- 7) Cut material and measure. If you get $\pm\frac{1}{4}$ " of your counter setting do nothing more.
- 8) If you get a reading of say $22\frac{3}{4}$ " instead of 120", then do the following:

Convert the $22\frac{3}{4}$ " to 22.7 and make the following calculation.

$$\frac{(\text{measured coil})}{(\text{programmed coil})} \times \frac{(22.7)}{(20.0)} \times (1.00) = 1.135$$

- 9) To program new prescaler push and hold the  button for 2 seconds until program entry flashes on LCD display.

PRESCALER (CONTINUED)

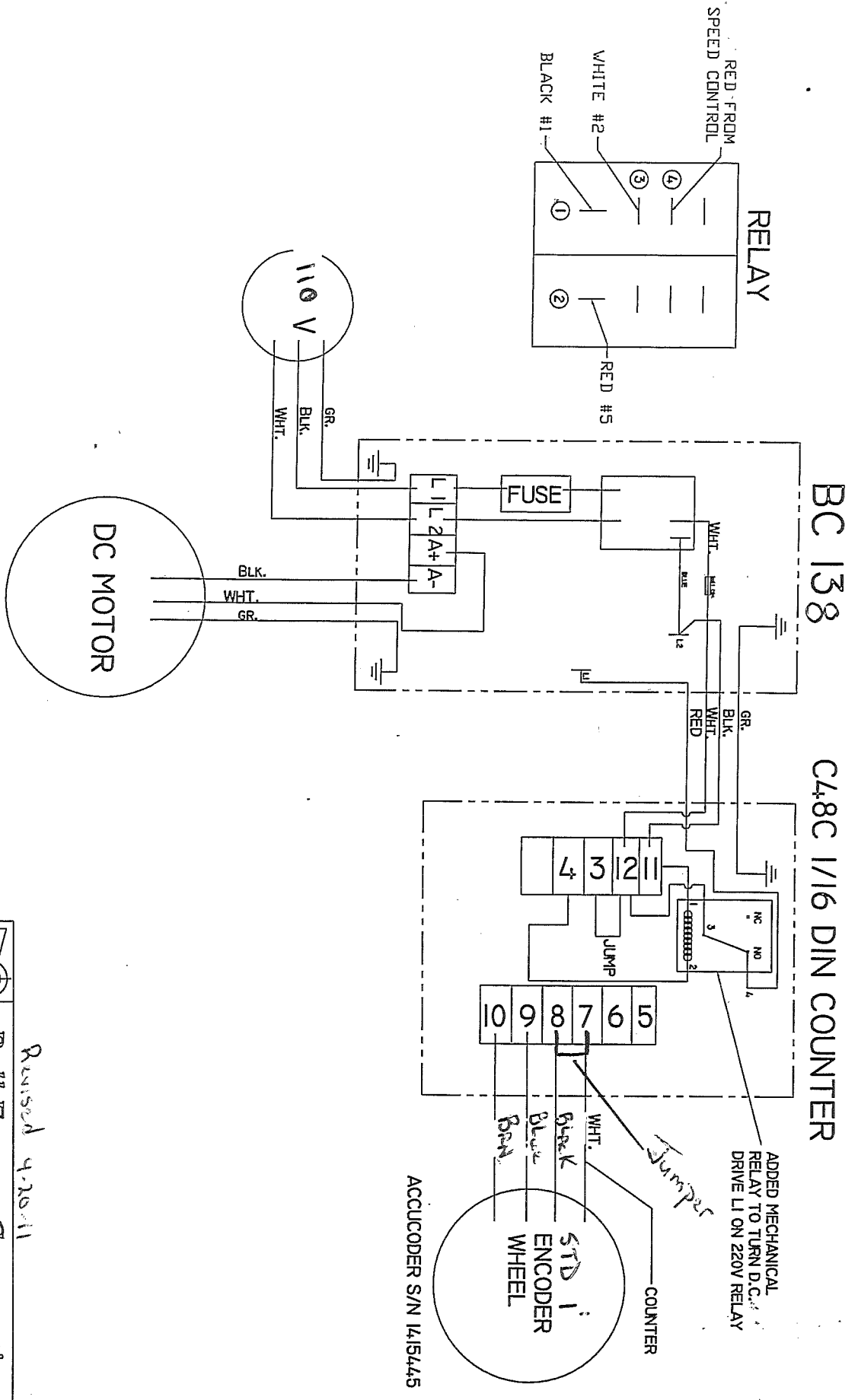
- 10) Using the  button scroll through the preset parameters until reaching the prescale option.
- 11) To change the value press the  button for increasing the value or the  button to decrease the value and enter 1.0225 then press  and hold the  button to save the new prescaler.
- 12) Repeat steps 3,4,5,6,7 and 8.
- 13) If length is still greater than $\pm 1/4$ " then repeat step 9, but this time use existing prescaler (1.0225).
- 14) You should now be quite accurate.

Your prescaler is: _____

MODEL C48C PROGRAM

ENTRY	AUTOSCROLL		CODE O	
AcPsc	L		SCROLL	NO
PSCALR	1.00000		FAC SET	NO
Dec. Pt.	_____.			
CNT IN	QUAD 1			
OPER	1			
Ac Prs	Y			
Preset	50.0		1 foot = 1.0	
AC OUT	L			
OUT Res	.01 sec.			
OUTPUT	T			
rEVOUT	Y			
REV ANU -	Y			
OUTPUP	F			
USR IN 1	Rst - L			
USR IN 2	Rst - L			
URS F1	Rst - L			
RECOILER CONTROLLER				

Programming info And Preset Parameters Attached



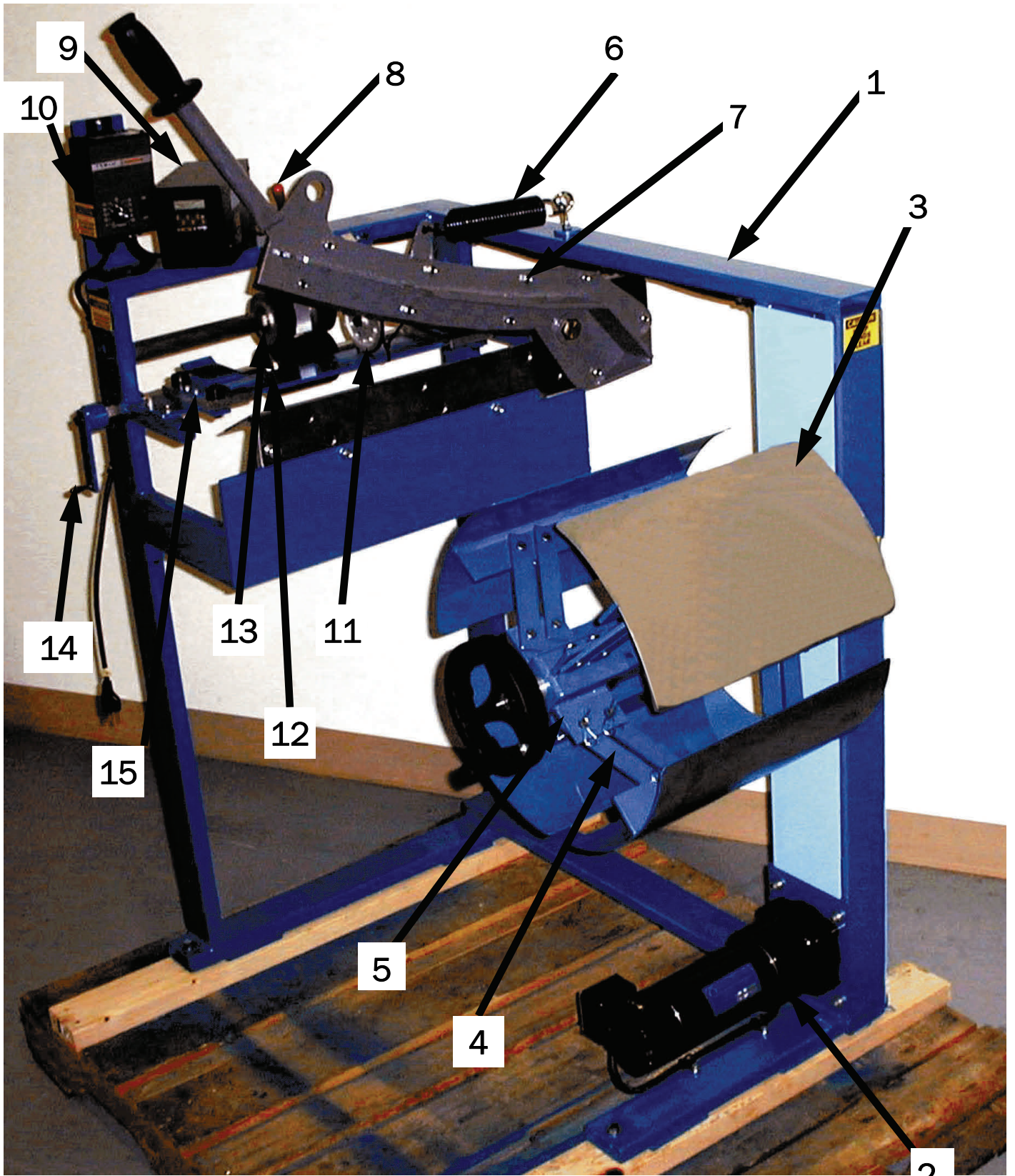
MOTOR WIRE-----14-3-----120.0"
 4 WIRE CONTROLLER---16-4---38.0"
 ENCODER WIRE-----22-4-----24.0"

		Roll Former Corporation 2425 MARYLAND ROAD, WILLOW GROVE, PA 19090	
DIMENSIONS AND FINISHES DIM IN INCHES DATE: NOVEMBER 16, 02 APPROVAL: _____ MATERIAL: N/A	GH TOLERANCES UNLESS OTHERWISE SPECIFIED: .XX = +- .03 .XXX = +- .003 .XXXX = +- .0003 ANG = +- 0.5°	PART NAME: ELECTRICAL DIAGRAM PART NUMBER:	MACHINE: RTR-16-15 SIZE: A SCALE: NONE SHEET: 1 OF 1

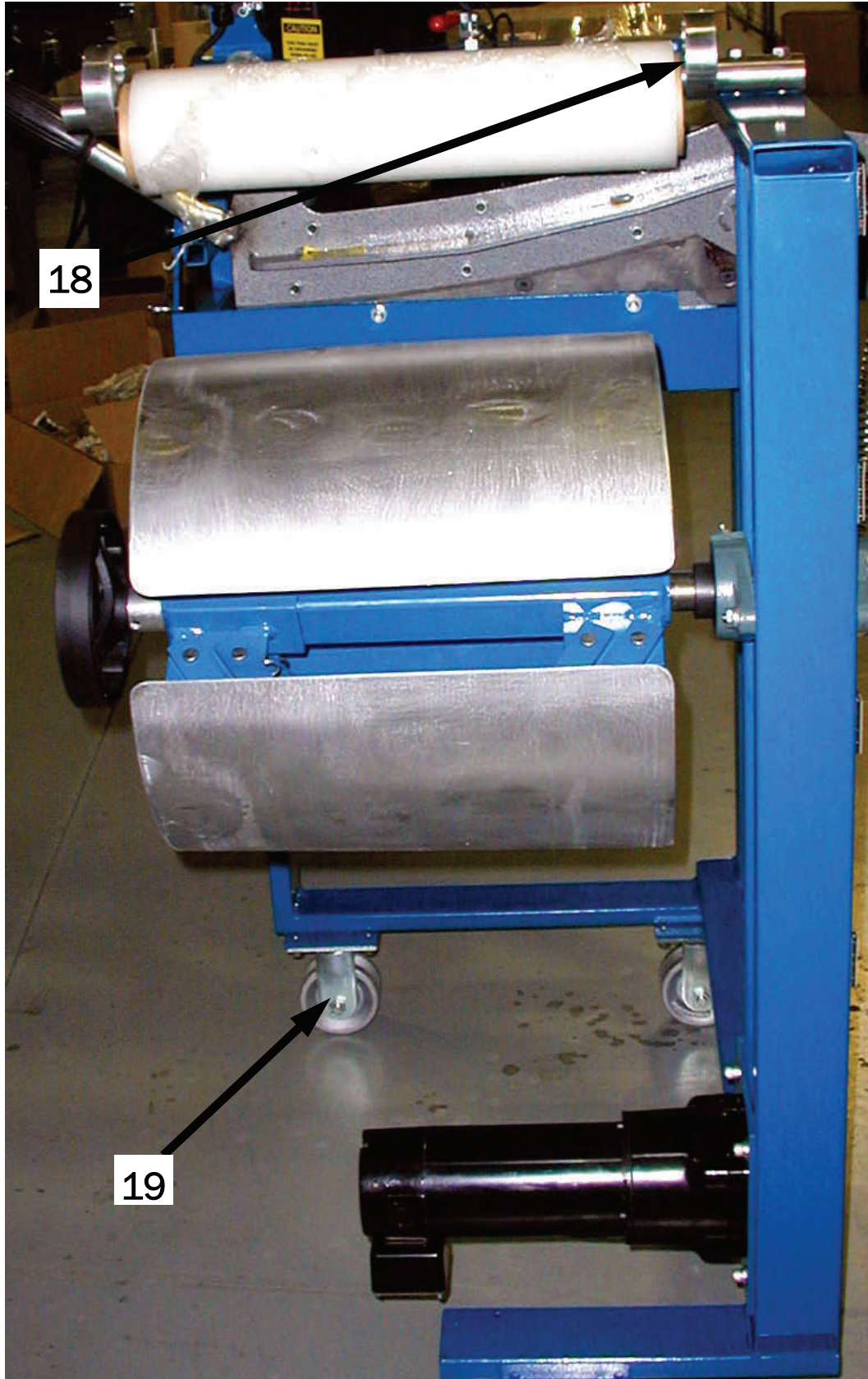
Revised 4-20-11

ACCUCODER S/N 1415445

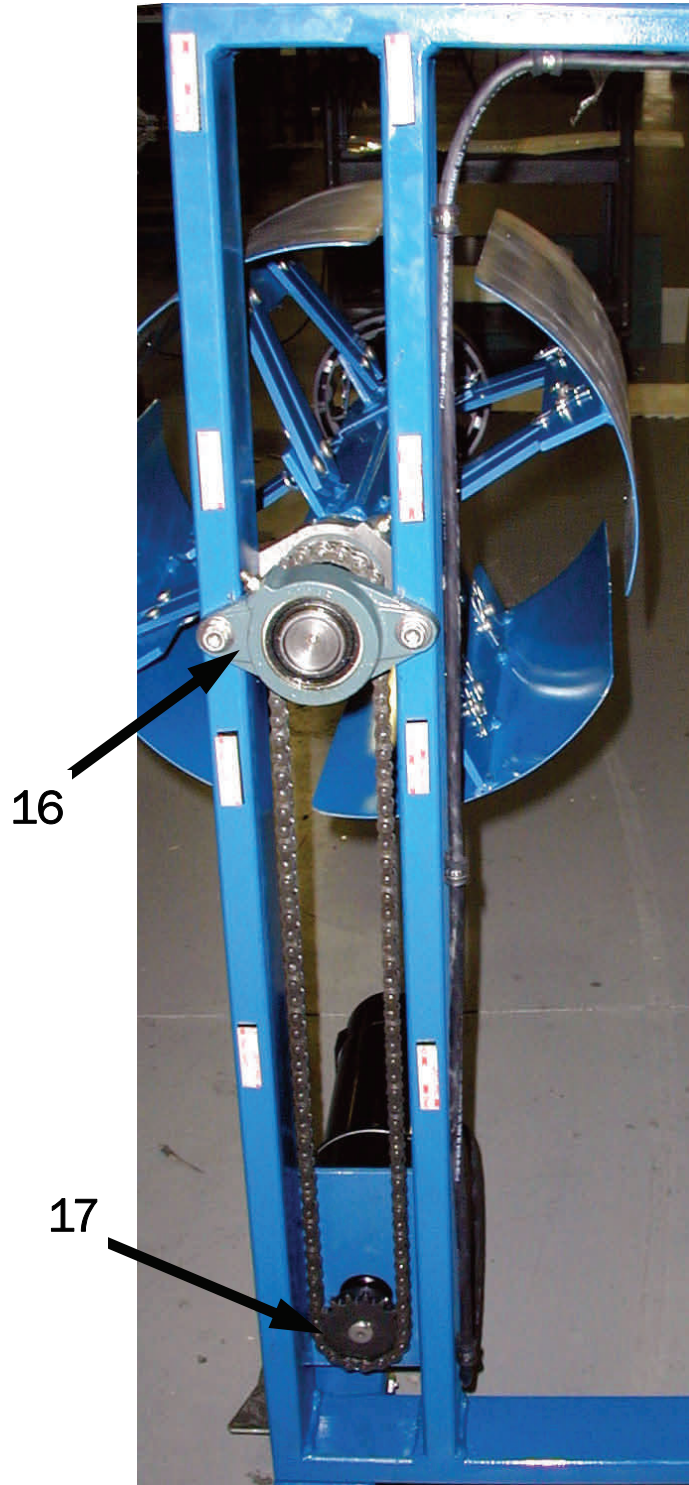
RECOILER ASSEMBLY



RECOILER ASSEMBLY



RECOILER ASSEMBLY



ITEM NO.	QTY.	DESCRIPTION	NOTES
1	1	FRAME ASSEMBLY	
2	1	PARALLEL GEAR MOTOR ASSEMBLY	
3	4	MANDREL, DRUM	
4	16	SPINDLE SPOKE	
5	1	SLIDING MANDREL ASSEMBLY	
6	1	SPRING, SHEAR	
7	1	18" SHEAR ASSEMBLY	
8	1	PINCH ROLL CAM HANDLE	
9	1	ELECTRONIC ENCODER	
10	1	VARIABLE SPEED DRIVE, MOTOR	
11	1	ENCODER ASSEMBLY	
12	1	LOWER PINCH ROLL ASSEMBLY	
13	1	UPPER PINCH ROLL ASSEMBLY	
14	1	CRANK HANDLE ASSEMBLY	
15		ENTRANCE GUIDE ASSEMBLY	
15A	1	ENTRANCE GUIDE PLATE	
15B	1	ENTRANCE GUIDE	RIGHT SIDE
15C	1	ENTRANCE GUIDE	LEFT SIDE
16	2	SPINDLE BEARINGS	1-1/4" FLANGED
17		DRIVE ASSEMBLY	
17A	1	DRIVE CHAIN	
17B	1	UPPER DRIVE SPROCKET	1.25 BORE
17C	1	LOWER DRIVE SPROCKET	0.75 BORE
18		FILM ASSEMBLY	(OPTIONAL)
18A	1	FILM SHAFT	
18B	2	FILM SHAFT STOPS	
19	3	CASTER ASSEMBLY	(OPTIONAL)

STANDARD EQUIPMENT WARRANTY

Roll Former Corporation warrants to the original purchaser that the equipment is free from defects in material and workmanship in normal use and service. Normal use and service does not extend to defects from mis-handling, tampering or modifying the equipment.

The term of this warranty is for a period of ***ninety (90) days for the Seamer and three hundred and sixty five (365) days/one year (1) for all other Roll Forming Equipment from the date of the receipt of the equipment to the original purchaser.*** Roll Former Corporation shall repair or replace the defective parts at their place of business without charge to the original purchaser of the equipment.

The equipment subject to this warranty must first be returned to Roll Former Corporation with freight charges prepaid, which after examination by Roll Former Corporation shall disclose to its satisfaction to have been defective. Roll Former Corporation shall correct the defect and ship the prepaid equipment to the location of the purchaser's facility within the continental United States.

The foregoing warranties are in lieu of all other warranties expressed or implied, and of all obligation or liabilities on the part of Roll Former Corporation for breach of warranty.

Roll Former Corporation's sole liability for any breach of warranty shall be limited to the repair or replacement of any defective parts in the accordance with the above.

Roll Former Corporation's warranty does not extend to equipment that has been used under a lease or rental agreement from the original purchaser.

CUSTOM EQUIPMENT - WARRANTY AND LIABILITY

Roll Former Corporation's liability for custom equipment prior to acceptance, is the amount of deposit from the customer. Roll Former warrants, after acceptance, all custom equipment for a period of three hundred and sixty five (365) days/one year (1) from the date of the receipt of the equipment to the original purchaser that the equipment is free from defects in material and workmanship in normal use and service.

The equipment subject to this warranty must first be returned to Roll Former Corporation with freight charges prepaid, which after examination by Roll Former Corporation shall disclose to its satisfaction to have been defective. Roll Former Corporation shall correct the defect and ship the prepaid equipment to the location of the purchaser's facility within the continental United States.

The foregoing warranties are in lieu of all other warranties expressed or implied, and of all obligation or liabilities on the part of Roll Former Corporation for breach of warranty.

Roll Former Corporation's sole liability for any breach of warranty shall be limited to the repair or replacement of any defective parts in the accordance with the above.