

# FORM ROLLS

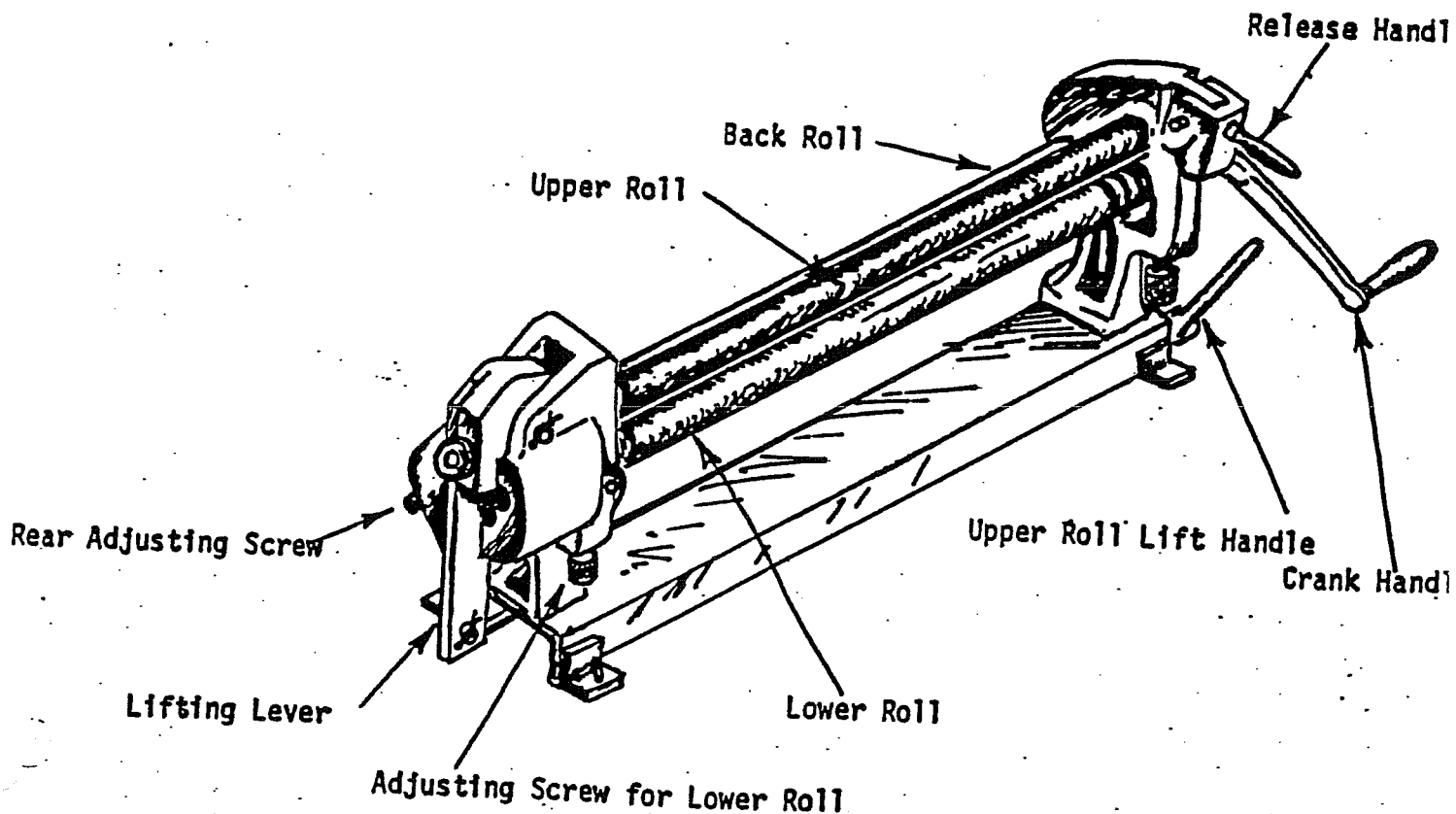
To certify on the form rolls you will need to know:

1. The safety rules.
2. Learn the parts of the form rolls.
3. Demonstrate your ability to roll sheet metal.

## Form rolls safety rules

1. Wear eye protection.
2. Remove sharp burrs and edges from sheet metal before attempting to work in the form rolls.
3. Never attempt to roll metal which is heavier than the capacity of the form rolls. ( Maximum thickness 22 gauge steel. )
4. Keep hands and fingers away of moving parts.
5. Never work more than one thickness of sheet metal.
6. Avoid slamming or dropping the handles.
7. Be careful that moving parts or metal do not strike others.
8. One person at a time is to operate form rolls

## Parts of the form rolls



## Operation of the form rolls.

1. Lock the upper roll in position, and adjust the lower roll so you can slip the metal between the two rolls.
2. While turning the handle, raise the metal slightly and then lower it to catch the rear roller.
3. Adjust the back roll to obtain correct diameter of work.
4. Unlock upper roll to take out material.
5. If you have a wire edge, put wire edge into grooves at edge of rolls.