

# *Grizzly* *Industrial, Inc.*®

**MODEL T26471**

**51" SLIP ROLL**

**OWNER'S MANUAL**

*(For models manufactured since 02/14)*



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#DM16204 PRINTED IN CHINA

V1.04.14



## **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.**

**Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.**

**The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.**

**The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.**



## **WARNING!**

**Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:**

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

**Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.**

# Table of Contents

<b>INTRODUCTION</b> .....	<b>2</b>	<b>SECTION 4: ACCESSORIES</b> .....	<b>21</b>
Machine Description .....	2	<b>SECTION 5: MAINTENANCE</b> .....	<b>23</b>
Contact Info .....	2	Schedule .....	23
Manual Accuracy .....	2	Lubrication .....	23
Identification .....	3	Cleaning .....	23
Machine Data Sheet .....	4	<b>SECTION 6: SERVICE</b> .....	<b>24</b>
<b>SECTION 1: SAFETY</b> .....	<b>5</b>	Troubleshooting .....	24
Safety Instructions for Machinery .....	5	<b>SECTION 7: PARTS</b> .....	<b>25</b>
Additional Safety for Slip Rolls .....	7	Main .....	25
<b>SECTION 2: SETUP</b> .....	<b>8</b>	<b>WARRANTY &amp; RETURNS</b> .....	<b>29</b>
Unpacking .....	8		
Needed for Setup .....	8		
Inventory .....	8		
Cleanup .....	9		
Site Considerations .....	10		
Lifting & Placing .....	11		
Anchoring to Floor .....	12		
Assembly .....	12		
<b>SECTION 3: OPERATIONS</b> .....	<b>13</b>		
Basic Controls .....	13		
Preparation .....	14		
Flat Rolling .....	14		
Creating Bends .....	15		
Creating Cylinders .....	17		
Bending Wire .....	19		
Removing Workpiece .....	20		

# INTRODUCTION

## Machine Description

The Model T26471 can quickly adjust to create cone, spiral or continuous cylindrical shapes with sheet metal up to 15 gauge. It can also be used to straighten sheet metal in some instances, and bend wire using the  $\frac{5}{16}$ ",  $\frac{3}{8}$ ", and  $\frac{1}{2}$ " grooves.

The Model T26471 features a quick-release upper roller for the easy release of cylindrical workpieces from the machine.

## Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: manuals@grizzly.com


## Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs contained inside. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive will be slightly different than what is shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused about a procedure, check our website for an updated version. We post current manuals and manual updates for free on our website at [www.grizzly.com](http://www.grizzly.com).

Alternatively, you can call our Technical Support for help. Before calling, please write down the **Manufacture Date** and **Serial Number** stamped into the machine ID label (see below). This information helps us determine if updated documentation is available for your machine.

		<b>MODEL GXXXX</b> <b>MACHINE NAME</b>	
<b>SPECIFICATIONS</b>		<b>▲ WARNING!</b>	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		Read manual before operation.	
Specification:		Wear safety glasses and respirator.	
Specification:		Ensure safety devices are correctly adjusted/setup and	
Specification:		power is connected to grounded circuit before starting.	
Weight:		4. Make sure the motor has stopped and disconnect	
		power before adjustments, maintenance, or service.	
		5. DO NOT expose to rain or dampness.	
		6. DO NOT modify this machine in any way.	
		7.	
		8.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
Manufactured for Grizzly in Taiwan			

Manufacture Date

Serial Number



# Identification

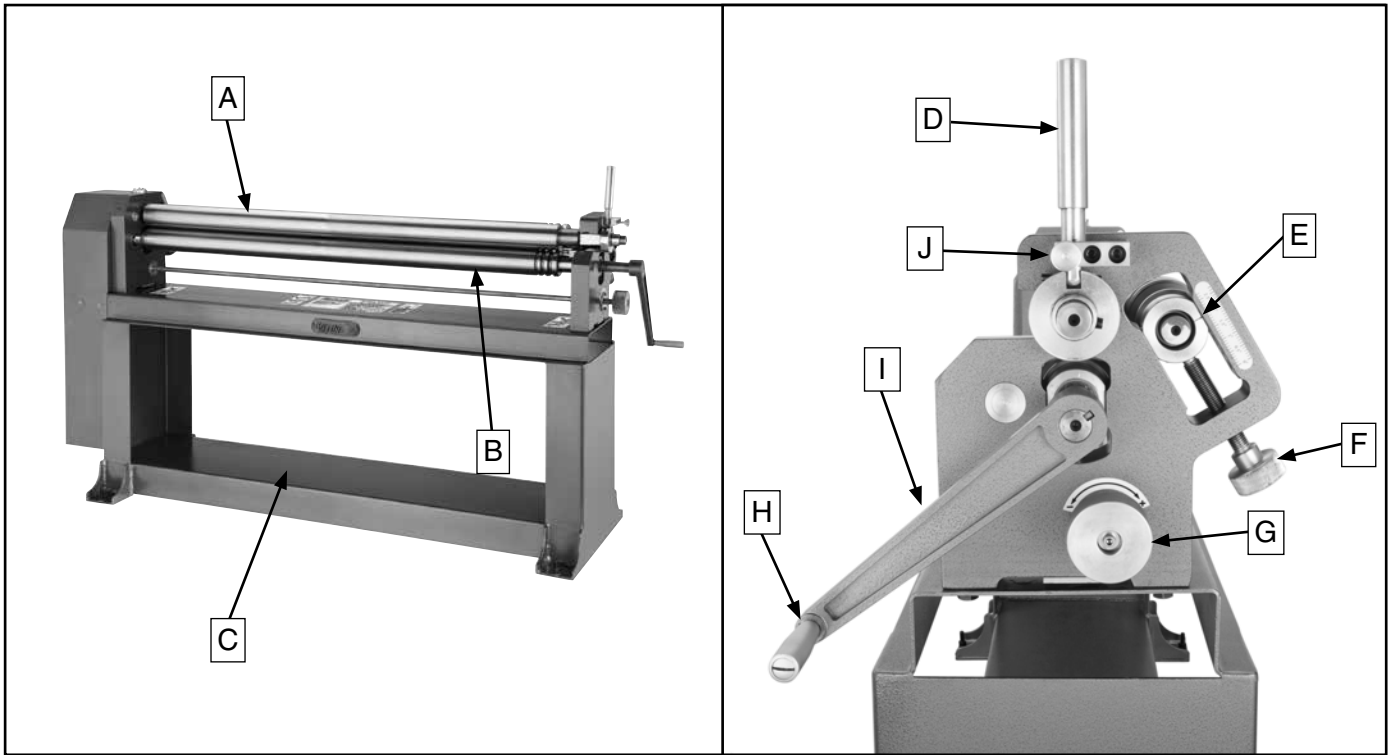


Figure 1. T26471 front and side machine identification.

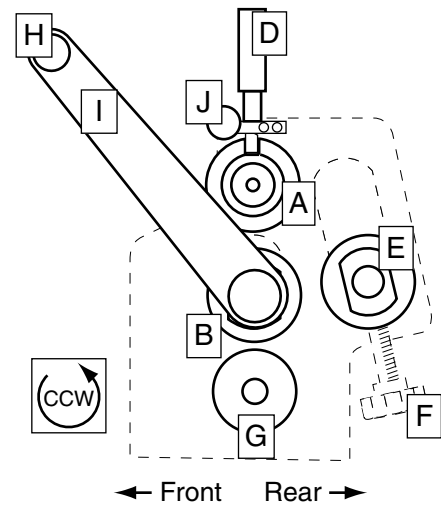
## Identification List

- A. Top Roller
- B. Bottom Roller
- C. Machine Base
- D. Easy Release Handle
- E. Rear Roller
- F. Radius Adjustment Knob
- G. Thickness Adjustment Knob
- H. Crank Handle
- I. Crank
- J. Locking Knurled Thumb Screw

## Sample Illustration

Throughout this manual, diagrams are used to illustrate how the components of the machine are used during the various steps of operation.

Familiarize yourself with the following illustration, its relationship to the machine, and the symbols used in it before proceeding through this manual.



Bold, solid lines indicate that this component is used in this step.



Light, dashed lines indicate that this component is not used in this step.



Arrows indicate the direction of movement of a component.



Rotational arrows indicate the direction a component must be turned.  
CW=Clockwise



CCW=Counterclockwise





# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

## MODEL T26471 51" SLIP ROLL

### Product Dimensions:

Weight..... 462 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height..... 72 x 20-1/2 x 42-1/2 in.  
 Footprint (Length x Width)..... 58 x 20-1/2 in.

### Shipping Dimensions:

Type..... Wood Crate  
 Content..... Machine  
 Weight..... 510 lbs.  
 Length x Width x Height..... 73 x 23 x 45 in.

### Main Specifications:

#### Capacities

Maximum Width..... 51 in.  
 Maximum Thickness Mild Steel..... 15 Gauge  
 Slip Roll Minimum Cylinder Diameter..... 3 in.  
 Slip Roll Roller Diameter..... 3 in.  
 Slip Roll Wire Sizes..... 5/16, 3/8, 1/2 in.

#### Construction

Frame..... Steel  
 Head and Tail Supports..... Steel  
 Rollers..... Hardened Steel

### Other Specifications:

Country Of Origin ..... China  
 Warranty ..... 1 Year  
 Approximate Assembly & Setup Time ..... 15 Minutes  
 Serial Number Location ..... Machine ID Label

### Features:

- Quick release top roller
- Easily adjustable rollers
- Hardened steel gearing and rollers




# SECTION 1: SAFETY

## For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

 **DANGER** Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

 **WARNING** Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

**NOTICE** This symbol is used to alert the user to useful information about proper operation of the machine.

## Safety Instructions for Machinery

### **WARNING**

**OWNER'S MANUAL.** Read and understand this owner's manual **BEFORE** using machine.

**TRAINED OPERATORS ONLY.** Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

**DANGEROUS ENVIRONMENTS.** Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

**MENTAL ALERTNESS REQUIRED.** Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

**ELECTRICAL EQUIPMENT INJURY RISKS.** You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

**DISCONNECT POWER FIRST.** Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

**EYE PROTECTION.** Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are **NOT** approved safety glasses.



# WARNING

**WEARING PROPER APPAREL.** Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control.

**HAZARDOUS DUST.** Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

**HEARING PROTECTION.** Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

**REMOVE ADJUSTING TOOLS.** Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

**USE CORRECT TOOL FOR THE JOB.** Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

**AWKWARD POSITIONS.** Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

**CHILDREN & BYSTANDERS.** Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

**GUARDS & COVERS.** Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

**FORCING MACHINERY.** Do not force machine. It will do the job safer and better at the rate for which it was designed.

**NEVER STAND ON MACHINE.** Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

**STABLE MACHINE.** Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

**USE RECOMMENDED ACCESSORIES.** Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

**UNATTENDED OPERATION.** To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

**MAINTAIN WITH CARE.** Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

**CHECK DAMAGED PARTS.** Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

**MAINTAIN POWER CORDS.** When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

**EXPERIENCING DIFFICULTIES.** If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.





# Additional Safety for Slip Rolls

## **WARNING**

**METAL EDGES.** Sharp edges on sheet metal can result in severe cuts. Always wear leather gloves and buttoned long-sleeves when working with sheet metal. Always chamfer and debur metal edges.

**BACK INJURIES.** The cranking motion required to operate this slip roll is potentially harmful if proper technique is not used. To avoid back injuries, keep your back vertical and never over-exert yourself or operate the slip roll in awkward positions.

**CRUSHING & PINCHING INJURIES.** Slip rolls can quickly crush or pinch fingers or hands. Never place fingers or hands between or near the rollers during operation.

**SECURING SLIP ROLL.** Before using, secure the slip roll to the floor so it can withstand the dynamic forces involved with forming sheet metal. Otherwise, it may move or tip during operation, causing serious injury or property damage.

**TOOLS IN POOR CONDITION.** Using the slip roll with loose or damaged hardware could result in sudden, uncontrolled movements during use. Inspect the slip roll for any cracked linkage, controls, or loose fasteners. Correct any problems before use.

## **WARNING**

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## **CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



# SECTION 2: SETUP

## Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



## Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

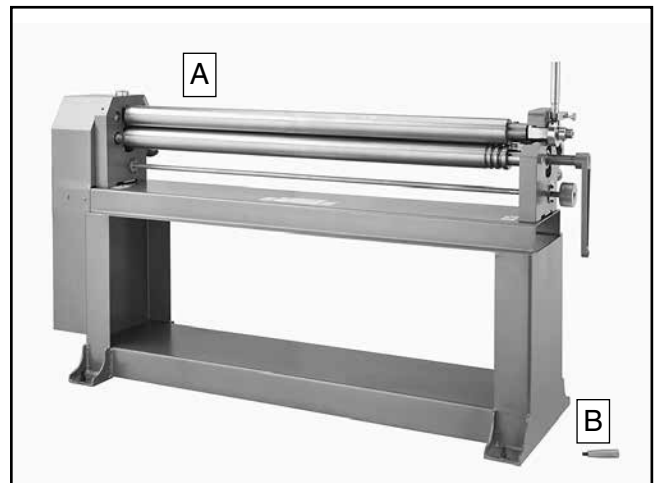
Description	Qty
• Additional People .....	1
• Safety Glasses (for each person).....	1
• Cleaner/Degreaser ( <b>Page 9</b> ) .....	As Needed
• Disposable Shop Rags.....	As Needed
• Mounting Hardware ( <b>Page 12</b> ) ...	As Needed
• Forklift.....	1
• Lifting Straps (rated for 1000 lbs.) .....	2
• Screwdriver Flat Head #2.....	1

## Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Box 1 (Figure 2)	Qty
A. 51" Slip Roll .....	1
B. Crank Handle .....	1



**Figure 2.** T26471 inventory.

## NOTICE

**If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.**



# Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

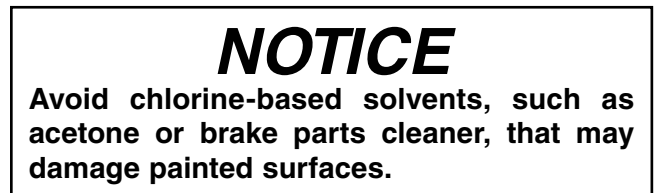
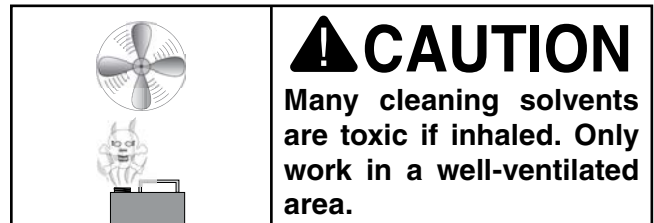
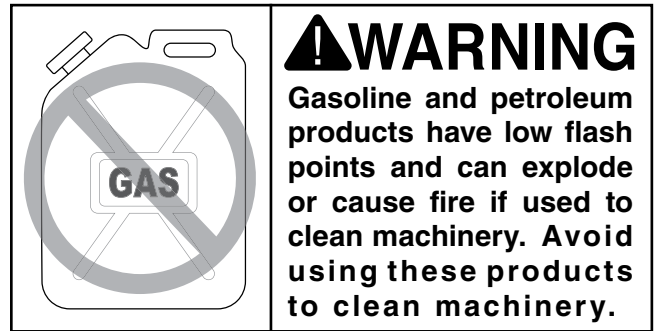
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

## Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

## Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



## T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.



Figure 3. T23692 Orange Power Degreaser.



# Site Considerations

## Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

## Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**

## Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

## Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

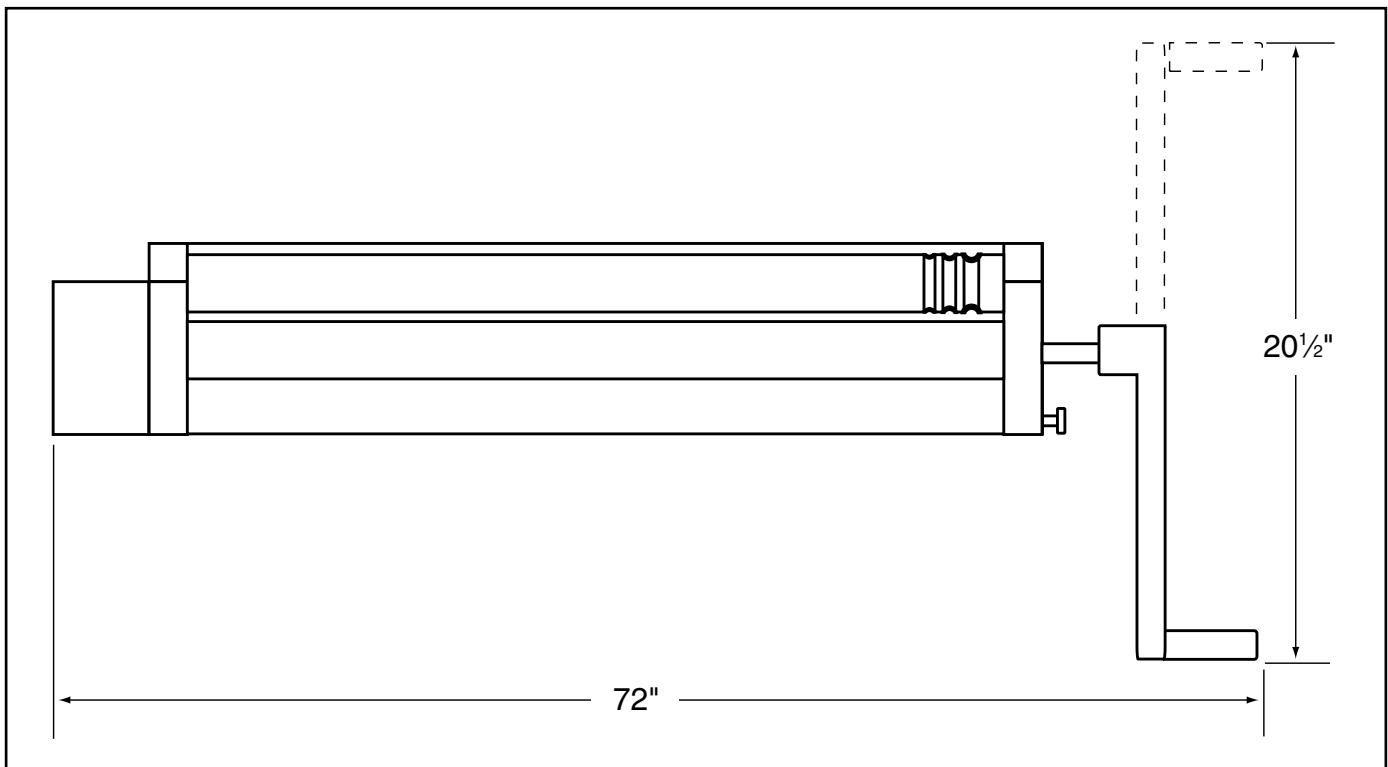
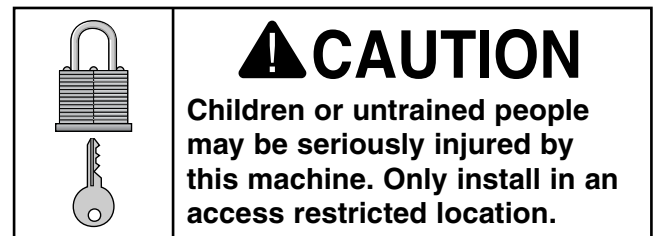
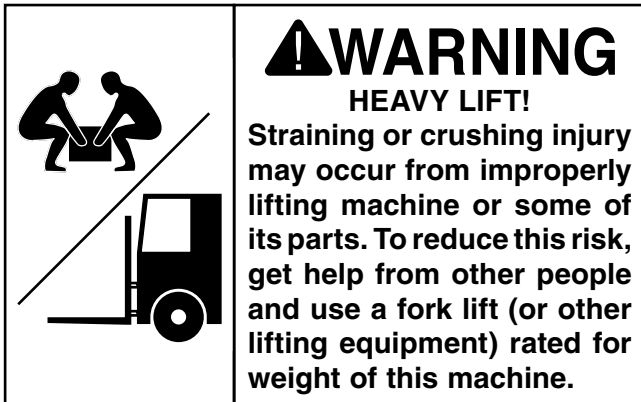


Figure 4. T26471 working clearances.



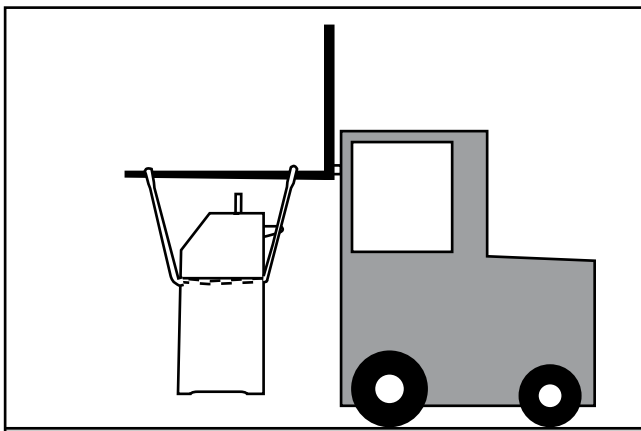
# Lifting & Placing



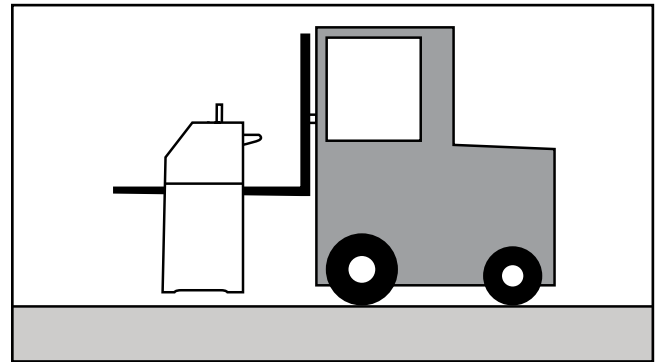
There are two recommended ways to lift this slip roll: 1) Use the forklift forks, or 2) rig the slip roll with lifting straps attached to the forks of a forklift. If you choose to use lifting straps, make sure each strap is rated for at least 1000 lbs.

## To lift and place the slip roll:

1. Move slip roll (while it is still on shipping pallet) to installation location.
2. Unbolt slip roll from shipping pallet.
3. Place lifting straps or forks of forklift under machine where it attaches to stand, as illustrated in **Figure 5** or **Figure 6**.



**Figure 5.** Lifting slip roll with lifting straps.



**Figure 6.** Lifting slip roll with forklift forks.

4. With help of another person to steady load, use forklift to raise slip roll just enough to clear shipping pallet, then remove shipping pallet.
5. Lower slip roll into place, and mount it to floor as recommended in next subsection.



# Anchoring to Floor

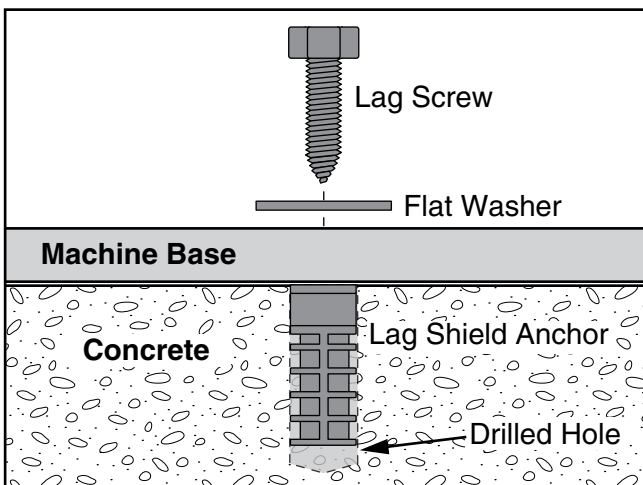
**Number of Mounting Holes** ..... 8  
**Diameter of Mounting Hardware**..... 3/8"

The Model T26471 is top heavy and may tip as a result of the dynamic forces necessary for operation. This machine must be anchored to the floor to prevent tipping or shifting. Because floor materials may vary, floor mounting hardware is not included.

**⚠ WARNING**  
Severe injury may occur from slip roll tipping over. Anchor slip roll to floor to prevent tipping as a result of lateral force needed to operate this machine.

## Anchoring to Concrete Floors

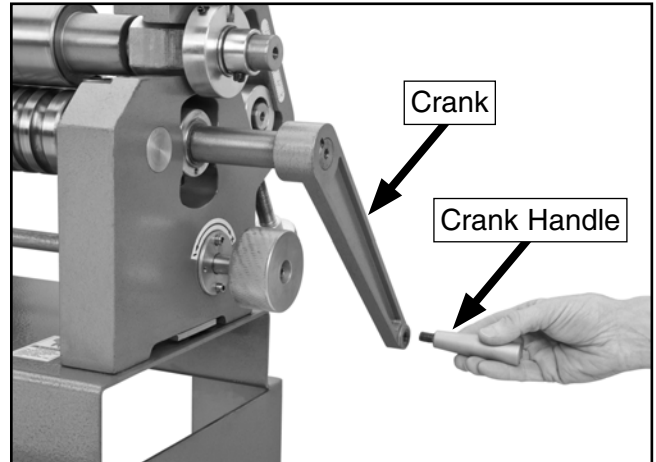
Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you MUST follow the anchoring methodology specified by the code.



**Figure 7.** Popular method for anchoring machinery to a concrete floor.

# Assembly

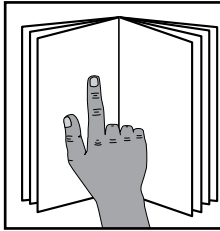
With the exception of the crank handle, the slip roll is fully assembled when shipped. Thread the crank handle into the small end of the crank and tighten, as shown in **Figure 8**.



**Figure 8.** Threading crank handle onto crank.



# SECTION 3: OPERATIONS



## **!WARNING**

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.



## **!WARNING**

Damage to your eyes and hands could result from using this machine without proper protective gear. Always wear leather gloves and safety glasses, when operating this machine.



## **NOTICE**

If you are not experienced with this type of machine, **WE STRONGLY RECOMMEND** that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

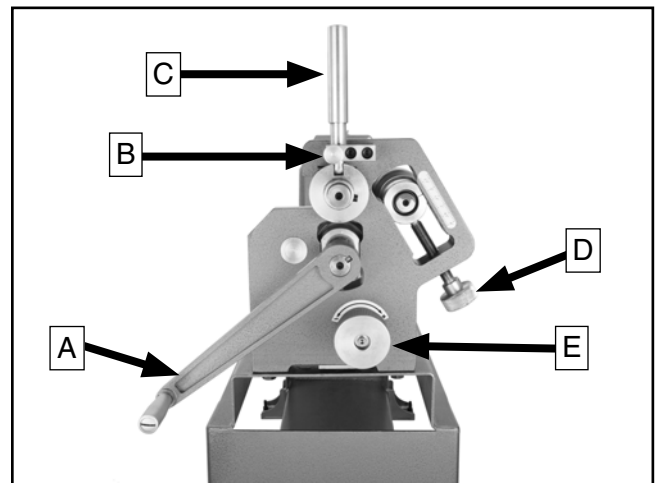
## **NOTICE**

This machine is designed for cold rolling only. Using a torch or other means for hot rolling will permanently damage and deform the rollers and frame of this machine.

## Basic Controls

Use **Figure 9** and the descriptions below to become familiar with the basic controls of the slip roll.

- A. **Crank:** Turns the rollers, feeding the workpiece through the machine.
- B. **Locking Knurled Thumb Screw:** Enables easy release handle.
- C. **Easy Release Handle:** Releases top roller from frame for workpiece removal.
- D. **Radius Adjustment Knob (1 of 2):** Raises and lowers the rear roller to create different sized radius bends.
- E. **Thickness Adjustment Knob:** Raises and lowers the bottom roller to adjust for different workpiece thicknesses.



**Figure 9.** T26471 controls.

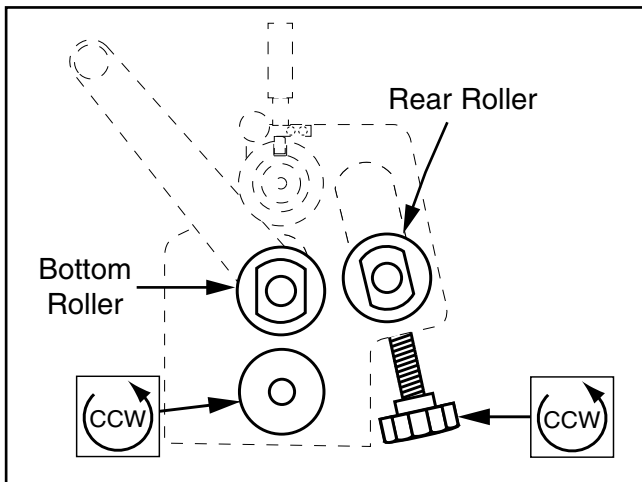


# Preparation

Before every use, follow these procedures to set up the slip roll for safe, accurate, and efficient use.

## To prepare the slip roll for use:

1. Turn thickness adjustment knob to lower bottom roller to approximately  $\frac{1}{4}$ " below top roller (see **Figure 10**).



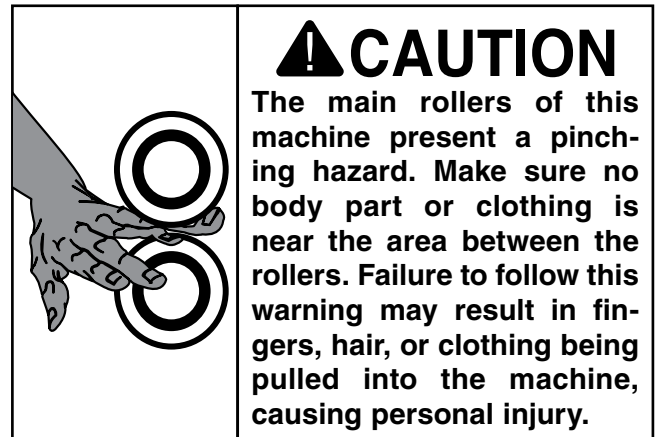
**Figure 10.** Slip roll preparation.

2. Lower rear roller to lowest position (see **Figure 10**).

# Flat Rolling

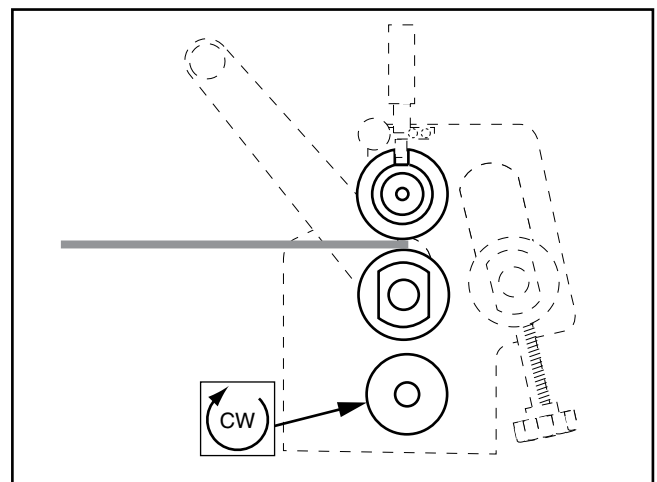
This slip roll can be used to flat roll sheet metal up to 15 gauge. This can be done to straighten sheet metal that is slightly out of form.

**Note:** *Plastic deformation is permanent. Once a workpiece has been sharply creased or bent, it cannot be straightened using this slip roll.*



## To flat roll a workpiece:

1. Place workpiece between top and bottom rollers, as shown in **Figure 11**. Turn thickness adjustment knob to lift bottom roller until workpiece is held snug between top and bottom rollers.

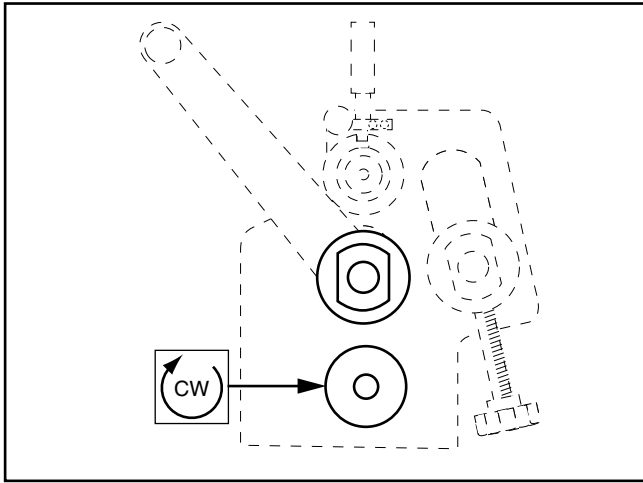


**Figure 11.** Raising bottom roller for flat rolling.



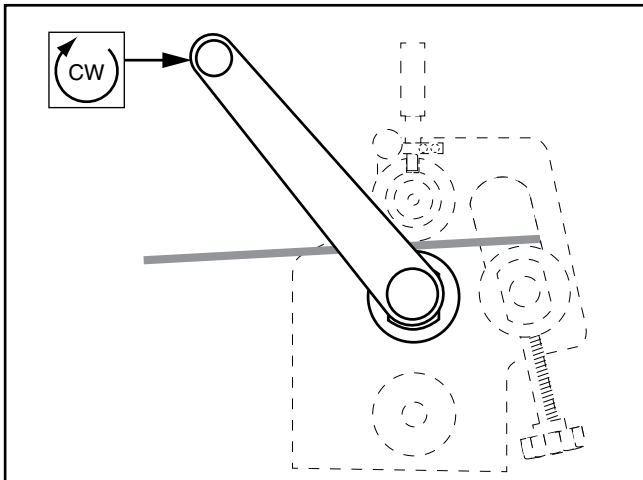


- Remove workpiece from between rollers, then raise bottom roller slightly by rotating thickness adjustment knob approximately  $\frac{1}{4}$  turn. Also, make sure rear roller is lowered completely (see **Figure 12**).



**Figure 12.** Raising bottom roller  $\frac{1}{4}$  turn.

- With help of an assistant, feed workpiece into rollers while turning crank (see **Figure 13**).

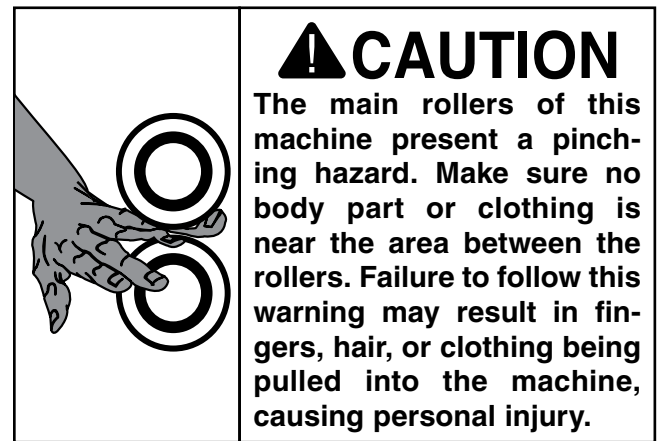


**Figure 13.** Flat rolling the workpiece.

## Creating Bends

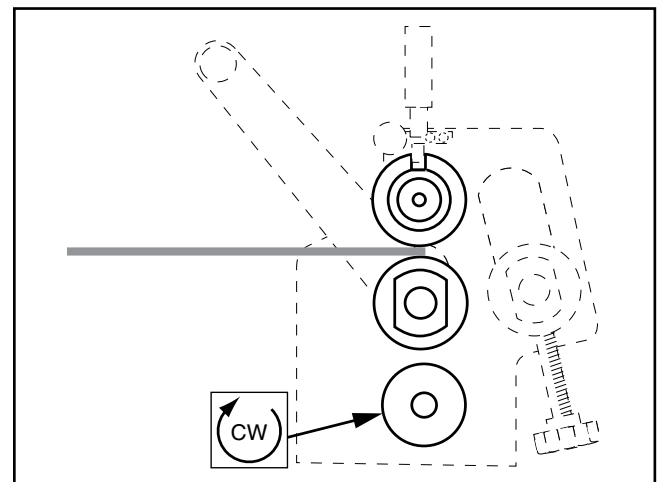
This slip roll can create constant-radius bends in sheet metal up to 15 gauge.

**Note:** The method for creating a specific radius is a trial-and-error process. Due to the many variations among metal workpieces, no single positioning will create the same curve on all materials. We recommend using scrap pieces the same dimensions and material as the final workpiece until the desired curve is achieved.



**To create a bend in a workpiece:**

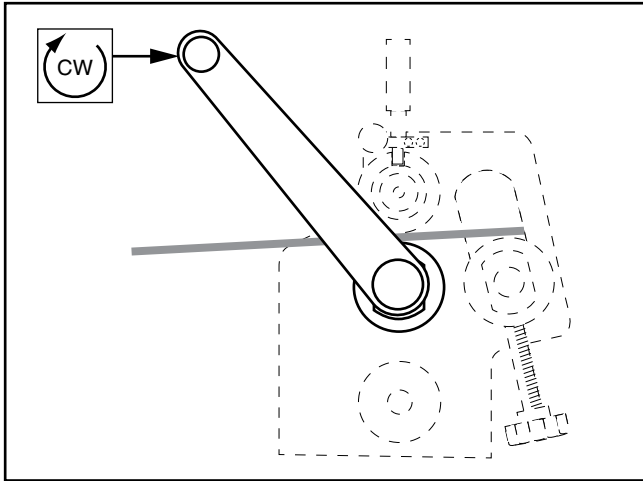
- Place workpiece between top and bottom rollers, as shown in **Figure 14**. Turn thickness adjustment knob to raise bottom roller until workpiece is held snug between top and bottom rollers.



**Figure 14.** Raising bottom roller.

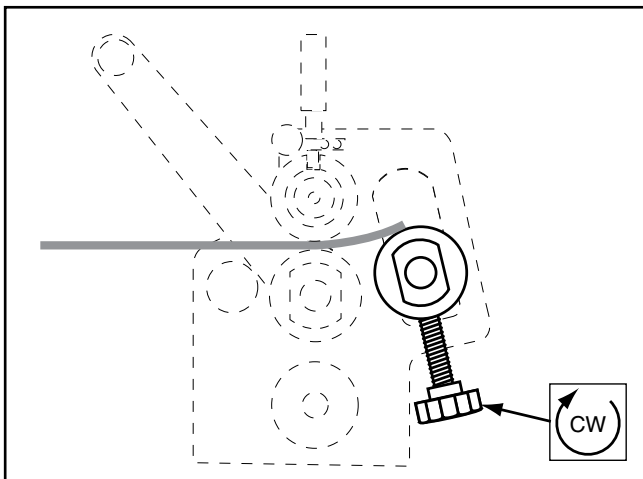


- Turn crank clockwise to feed workpiece until its leading edge is directly above rear roller, as shown in **Figure 15**.



**Figure 15.** Feeding the workpiece.

- Turn radius adjustment knobs to lift rear roller until desired radius bend is reached (see **Figure 16**). Make sure to turn knobs equal amounts so rear roller is always parallel with other rollers. Failure to do so will create a larger radius on one end than the other, resulting in a cone or spiral shape.

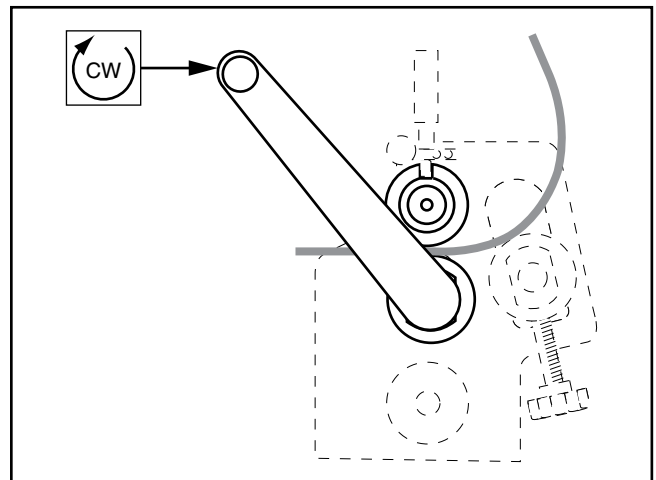


**Figure 16.** Setting the radius.

	<p><b>! WARNING</b> This machine poses a cutting hazard if workpieces are not properly handled. If necessary, get assistance to support workpiece. Make sure all helpers are wearing leather gloves and safety glasses when assisting in use of this machine.</p>

<p><b>! CAUTION</b> Depending on size and shape of workpiece, you may need assistance to support workpiece as it exits machine. Failure to adequately support workpiece may result in workpiece falling, causing injuries.</p>
--

- Turn crank to process material through slip roll. Continue turning until workpiece is completely through top and bottom rollers (see **Figure 17**).



**Figure 17.** Processing the workpiece.



# Creating Cylinders

This slip roll can be used to easily and accurately create cylinders.

If you know the diameter of the cylinder you want to create, use the formula below to calculate the length of material needed.

$$C = \pi D$$

C=Circumference  
(Length of Material Needed)

$\pi$ =Pi (Approximately 3.14)

D=Diameter

**Example:** Suppose you want to create a 6" diameter cylinder. You would use the above formula as follows:

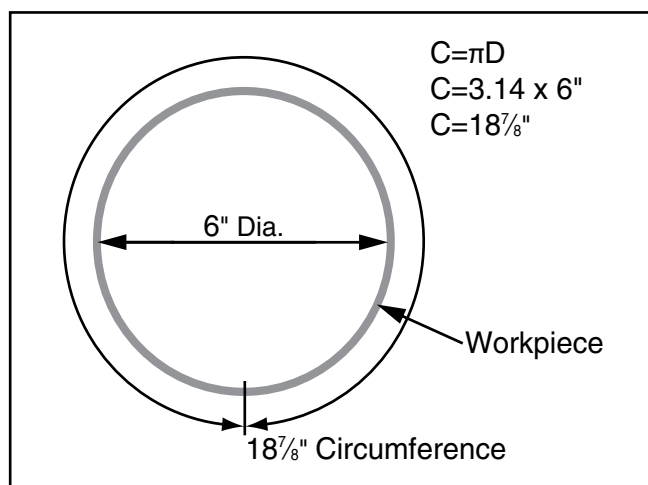
$$C = \pi D$$

$$C = 3.14 \times 6"$$

$$C = 18\frac{7}{8}"$$

The result of 18<sup>7</sup>/<sub>8</sub>" indicates that you need to start with a piece of sheet metal that is approximately 18<sup>7</sup>/<sub>8</sub>" in length to create a 6" diameter cylinder.

You can use the slip roll to create a bend with the correct radius so that the two ends meet, forming a 6" diameter cylinder (see **Figure 18**).



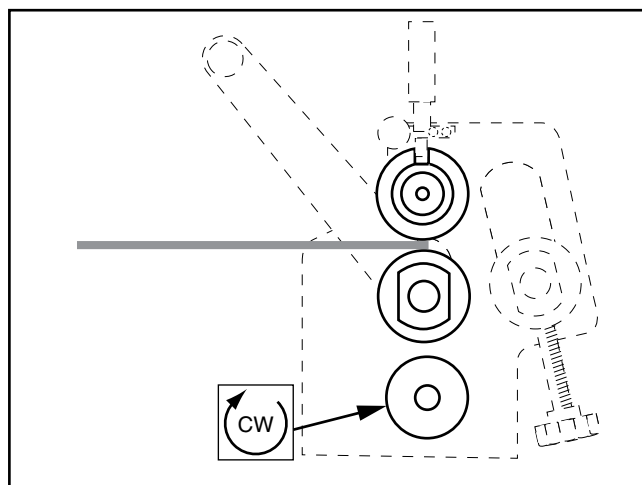
**Figure 18.** Calculating circumference example.

Once you have the necessary length workpiece, follow the steps below to create the cylinder.

**Note:** The method for creating a specific radius is a trial-and-error process. Due to the many variations among metal workpieces, no single positioning will create the same curve on all materials.

## To create a cylinder:

1. Place workpiece between top and bottom rollers, as shown in **Figure 19**. Turn thickness adjustment knob to lift the bottom roller until workpiece is held snug between top and bottom rollers.



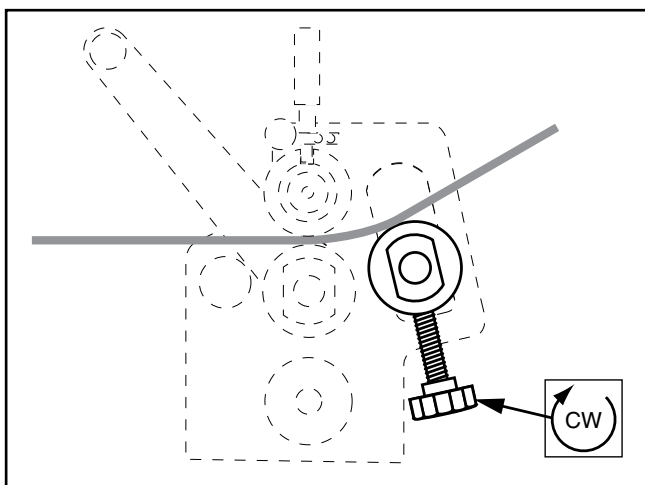
**Figure 19.** Raising bottom roller.

Continued on next page



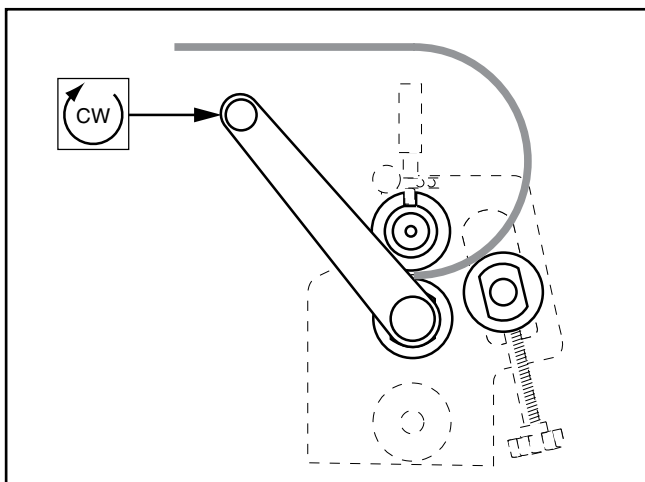
2. Turn crank clockwise to feed workpiece until it is approximately halfway through rollers.
3. Turn radius adjustment knobs to lift rear roller until desired radius bend is reached (see **Figure 20**). Make sure to turn knobs equal amounts so rear roller is always parallel with other rollers. Failure to do so will create a larger radius on one end than the other, resulting in a cone shape.

**Note:** Always err on the side of making the radius too large rather than too small. It is easy to decrease the radius but very difficult to increase the radius later.



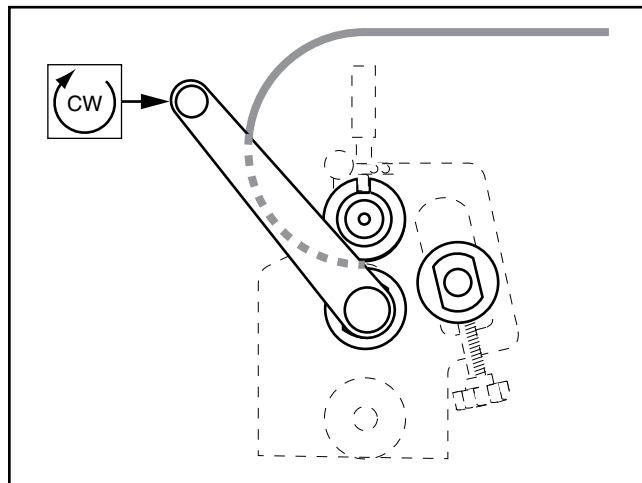
**Figure 20.** Setting the radius.

4. Turn crank to process material through slip roll. Continue turning until workpiece is completely through top and bottom rollers (see **Figure 21**).

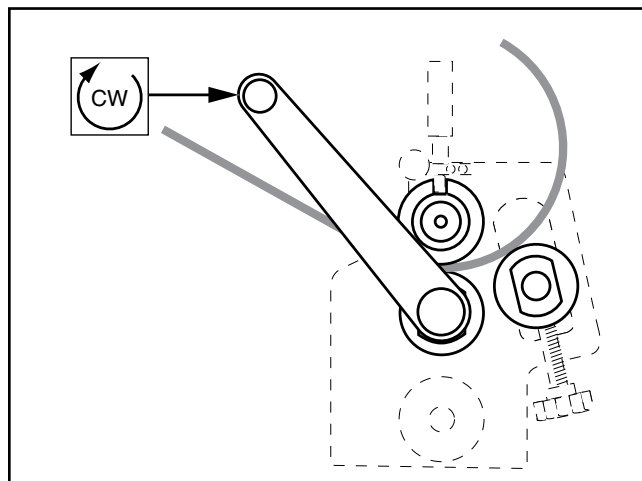


**Figure 21.** Processing the workpiece.

5. Rotate workpiece 180°, insert curved end into slip roll, then process workpiece through machine, as shown in **Figures 22–23**.



**Figure 22.** Re-inserting the workpiece.



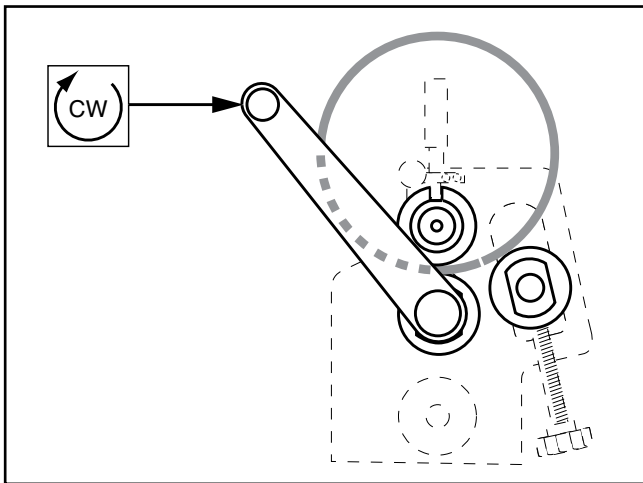
**Figure 23.** Creating the cylinder.



6. Continue to process workpiece until cylinder is formed, as shown in **Figure 24**.

—If ends of cylinder do not meet, lift rear roller equally at both ends, then process entire cylinder through slip roll again. Repeat as necessary.

—If ends of cylinder overlap, remove cylinder as described in **Removing Workpiece** on **Page 20**. Then, either attempt to increase radius by manually bending it, or scrap workpiece and start at **Step 1** with a new workpiece.



**Figure 24.** Finishing the cylinder.

7. Remove cylinder as described in **Removing Workpiece** on **Page 20**.

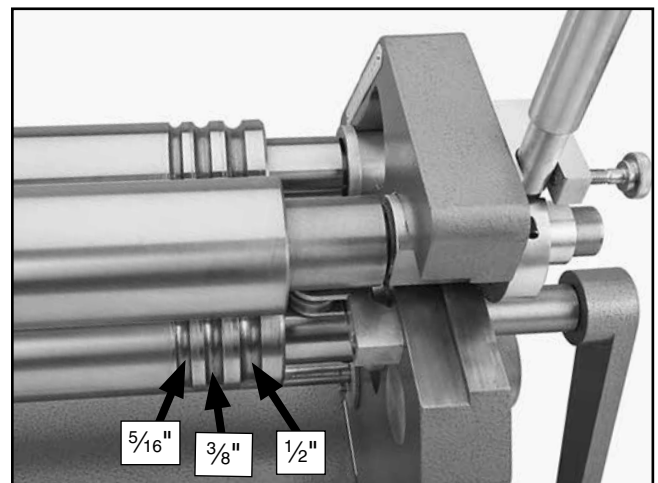
## Bending Wire

This slip roll can be used to shape wires, rods, and small-diameter tubing. The wire grooves can also be used when rolling sheet metal that has a wire bead at one end.

### To use the wire grooves:

1. Place workpiece into smallest possible groove on wheel. The three sizes are  $\frac{5}{16}$ " ,  $\frac{3}{8}$ " , and  $\frac{1}{2}$ " (see **Figure 25**).

**Example:** Suppose you want to bend a piece of  $\frac{1}{4}$ " rod. Though it would fit in any of the three grooves, you would use the  $\frac{5}{16}$ " groove since it is the smallest possible groove that the rod will fit into.



**Figure 25.** Wire grooves.

2. Process material through machine as described in **Creating Bends** on **Page 15**.

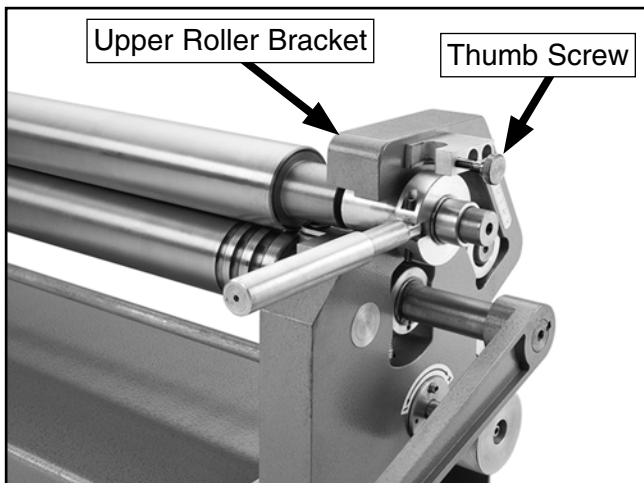
—If you want to make a loop of wire, follow instructions in **Creating Cylinders** on **Page 17**.



# Removing Workpiece

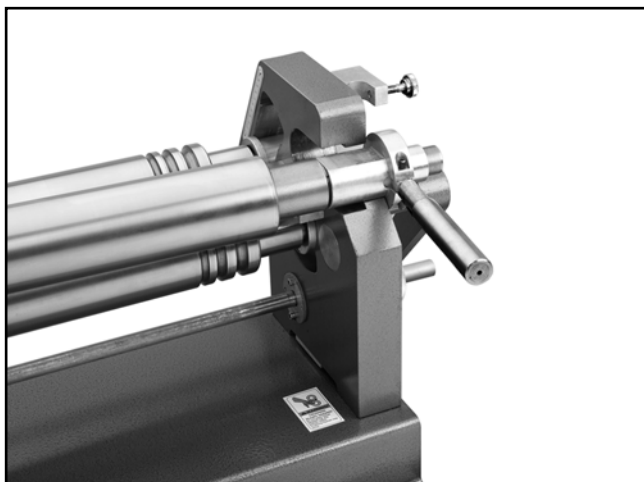
To remove cylindrical workpieces:

1. Rotate thumb screw shown in **Figure 26** counterclockwise until roller handle can be pulled down and flat edges of upper roller bracket are parallel with slots in frame.



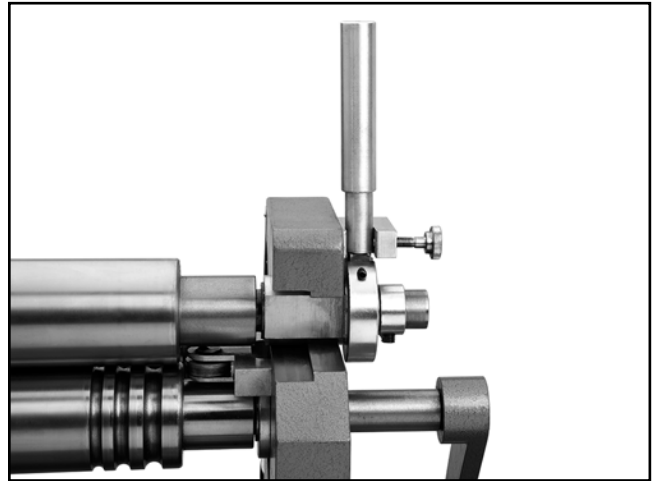
**Figure 26.** Thumb screw loosened and handle pulled down.

2. Slide top roller out from frame (see **Figure 27**). Remove workpiece from top roller, then slide top roller back into frame.



**Figure 27.** Roller released (workpiece already removed from roller for photo clarity).

3. Rotate handle upward to its vertical position and tighten thumb screw to secure top roller (see **Figure 28**).



**Figure 28.** Top roller secured.



# SECTION 4: ACCESSORIES

## **⚠️ WARNING**

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

## **NOTICE**

Refer to our website or latest catalog for additional recommended accessories.

### **G5618—Deburring Tool with Two Blades**

The quickest tool for smoothing freshly sheared metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.



**Figure 29.** G5618 Deburring Tool.

### **T23094—Pneumatic Sheet Metal Shear**

This heavy-duty pneumatic sheet metal shear provides long life and reliable cutting with an ergonomic grip for comfort and stability. Shears most types of plastics and all types of aluminum, tin, and steel.



**Figure 30.** T23094 Pneumatic Sheet Metal Shear.

### **H5503—Electric Sheet Metal Shear**

This electric sheet metal shear features a ½ HP, 110V, 2500 RPM, 3.8 amp motor with a 360 degree adjustable swivel head and variable speed range from 0 to 2500 SPM. Cuts up to 14 gauge in mild steel and 18 gauge in stainless, at up to 150 inches per minute.



**Figure 31.** H5503 Electric Sheet Metal Shear.

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- G5562—SLIPIT® 1 Qt. Gel
- G5563—SLIPIT® 12 Oz. Spray
- G2871—Boeshield® T-9 12 Oz. Spray
- G2870—Boeshield® T-9 4 Oz. Spray
- H3788—G96® Gun Treatment 12 Oz. Spray
- H3789—G96® Gun Treatment 4.5 Oz. Spray



**Figure 32.** Recommended products for protecting unpainted cast iron/steel part on machinery.

**G8781—4 1/2" Suction Cup**

Handle plate glass, glass mirrors and sheet metal with safety and security. Simple hand lever action provides tremendous gripping power on any flat, smooth material. Buy two Suction Cups for two-handed control!



**Figure 33.** G8781 Suction Cup.

- T20501—Face Shield Crown Protector 4"
- T20502—Face Shield Crown Protector 7"
- T20503—Face Shield Window
- T20451—"Kirova" Clear Safety Glasses
- T20452—"Kirova" Anti-Reflective S. Glasses
- H7194—Bifocal Safety Glasses 1.5
- H7195—Bifocal Safety Glasses 2.0
- H7196—Bifocal Safety Glasses 2.5



**Figure 34.** Safety glasses.

**H6136—Air Riveter**

If you do a lot of riveting, you can't beat the speed and convenience of a pneumatic riveter. Simply connect to an air compressor and squeeze the trigger for all day riveting. Includes 5 tips, quick connect air fitting and rivet mandrel container.



**Figure 35.** H6136 Air Riveter.

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# SECTION 5: MAINTENANCE

## Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

### Daily Check

- Loose mounting bolts.
- Damaged rollers
- Any other unsafe condition.

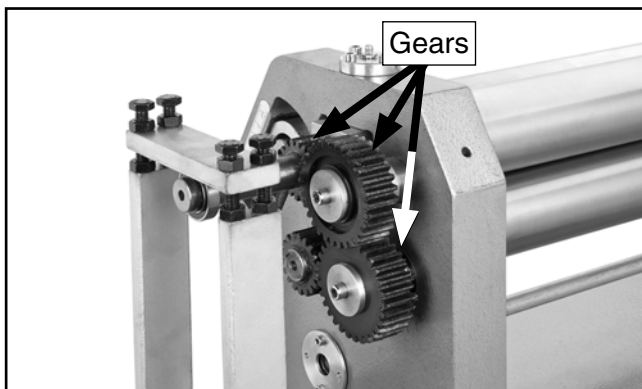
### Weekly Maintenance:

- Clean machine.
- Lubricate gears.
- Lubricate roller bushings.

## Lubrication

### Gears

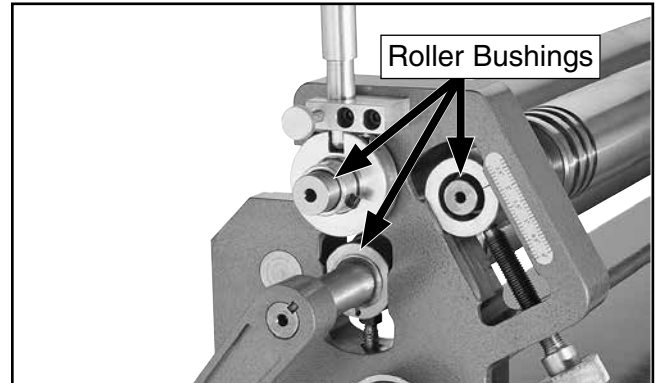
Remove the 5mm cap screws on the gear guard cover, remove it, and apply a dab of NLGI#2 or equivalent grease to the upper roller gears (see **Figure 36**). Rotate the hand crank several times in both directions to distribute the grease to all gears, then wipe away any excess and re-attach the cover.



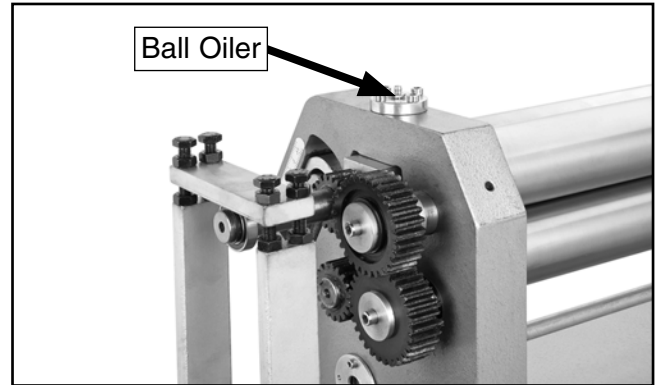
**Figure 36.** Slip roll gears.

### Roller Bushings

Use an oil can to apply a few drops of ISO 32 or equivalent oil to the brass bushings of the three rollers on the right side and into the ball oiler on the top of the left side (see **Figures 37–38**). Rotate the hand crank several times in both directions to distribute the oil, then wipe away any excess.



**Figure 37.** Roller bushings and adjustment knobs.



**Figure 38.** Ball oiler.

## Cleaning

Cleaning the Model T26471 is relatively easy. Periodically wipe down the rollers to remove dust and debris—this ensures rust-promoting material does not remain on the bare metal surfaces.

Treat all unpainted metal surfaces with quality metal protectants like SLIPIT®, or Boeshield® T-9 (see previous page for offerings from Grizzly).



# SECTION 6: SERVICE

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Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

**Note:** *Please gather the serial number and manufacture date of your machine before calling.*

## Troubleshooting

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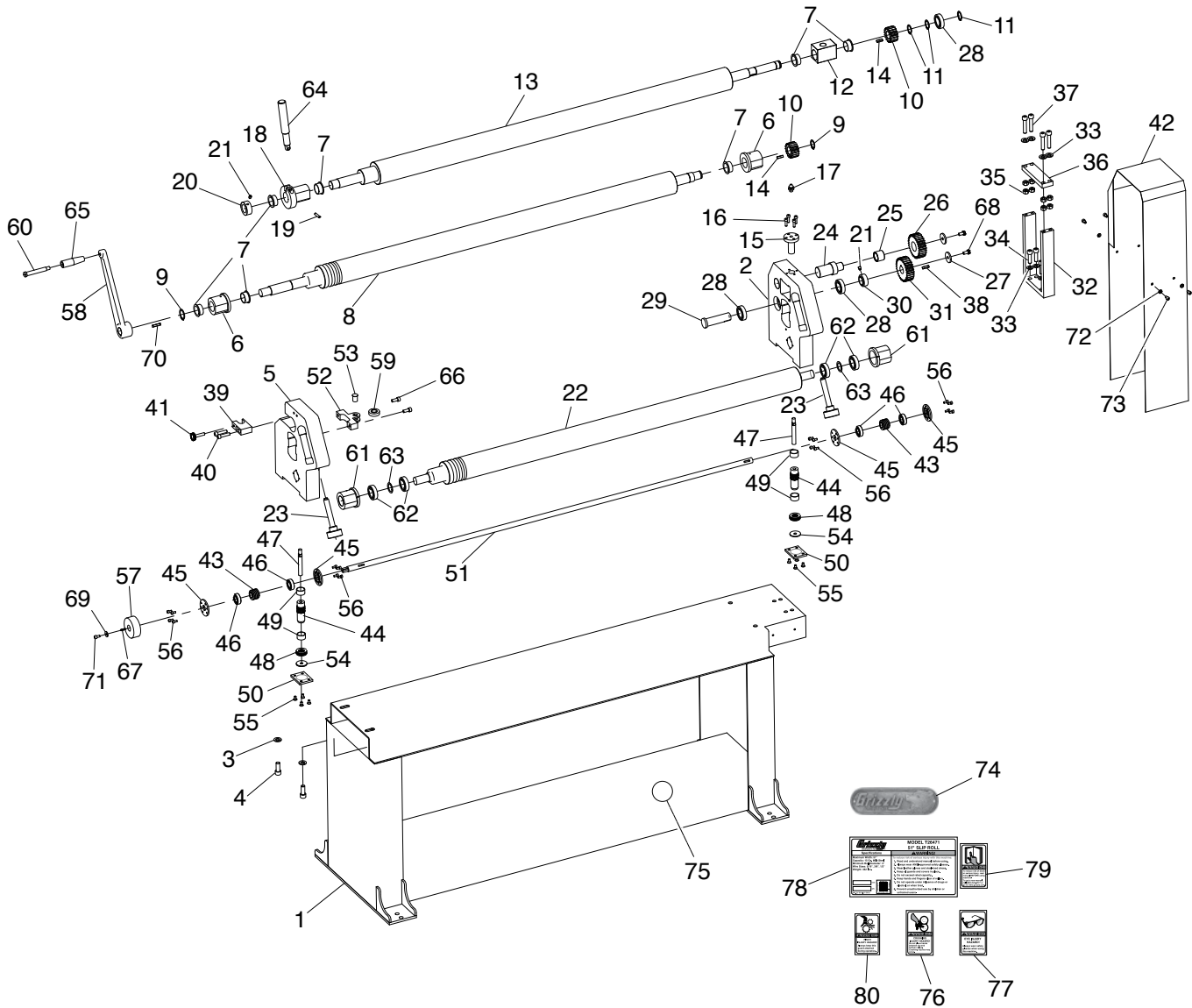
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Symptom	Possible Cause	Possible Solution
Slip roll creates cones when trying to create cylinders.	1. Rollers are not parallel.	1. Adjust rear roller adjustment knobs as necessary to be sure the rear roller is parallel with the top/bottom rollers.
A noticeable crease is formed in the workpiece.	1. Excessive pressure applied in one spot.	1. Reduce the radius and perform the bend in several passes.
Crank does not turn top and bottom rollers.	1. Gears are damaged.	1. Check/replace gears.
Slip roll does not bend material.	1. Machine capacities are exceeded. 2. Rear roller not engaged.	1. Use materials within the capacity of the slip roll. 2. Check/adjust rear roller.



# SECTION 7: PARTS

## Main



**Please Note:** We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at [www.grizzly.com](http://www.grizzly.com) to check for availability.



# Parts List

REF	PART #	DESCRIPTION
1	PT26471001	BASE
2	PT26471002	ROLLER SUPPORT (LEFT)
3	PT26471003	FLAT WASHER 12MM
4	PT26471004	CAP SCREW M12-1.75 X 30
5	PT26471005	ROLLER SUPPORT (RIGHT)
6	PT26471006	LOWER ROLLER BUSHING
7	PT26471007	ROLLER BUSHING (COPPER)
8	PT26471008	ROLLER (LOWER)
9	PT26471009	EXT RETAINING RING 30MM
10	PT26471010	GEAR 18T
11	PT26471011	EXT RETAINING RING 25MM
12	PT26471012	UPPER ROLLER BRACKET
13	PT26471013	ROLLER (UPPER)
14	PT26471014	KEY 6 X 6 X 22
15	PT26471015	LOWER ROLLER HEIGHT SHAFT
16	PT26471016	CAP SCREW M6-1 X 20
17	PT26471017	GREASE FITTING M10 X 1 STRAIGHT
18	PT26471018	UPPER ROLLER QUILL
19	PT26471019	ROLL PIN 6 X 30
20	PT26471020	LOCK COLLAR
21	PT26471021	SET SCREW M8-1.25 X 10
22	PT26471022	ROLLER (REAR)
23	PT26471023	KNOB BOLT M16-2 X 90, 130L
24	PT26471024	SHAFT
25	PT26471025	NEEDLE BEARING 7943/25
26	PT26471026	GEAR 30T
27	PT26471027	GEAR FLAT WASHER 8MM
28	PT26471028	BALL BEARING 6205ZZ
29	PT26471029	DRIVE SHAFT
30	PT26471030	LOCK COLLAR
31	PT26471031	GEAR 30T W/KEYWAY
32	PT26471032	GEAR COVER BRACKET
33	PT26471033	FLAT WASHER 10MM
34	PT26471034	CAP SCREW M10-1.5 X 35
35	PT26471035	HEX NUT M10-1.5
36	PT26471036	BRACKET TOP PLATE
37	PT26471037	CAP SCREW M10-1.5 X 50
38	PT26471038	KEY 6 X 6 X 63
39	PT26471039	LEVER BRACKET
40	PT26471040	CAP SCREW M8-1.25 X 35

REF	PART #	DESCRIPTION
41	PT26471041	KNOB BOLT M8-1.25 X 30, 45L
42	PT26471042	GEAR COVER
43	PT26471043	WORM
44	PT26471044	WORM GEAR
45	PT26471045	SHAFT END BRACKET
46	PT26471046	BALL BEARING 6003ZZ
47	PT26471047	SHAFT
48	PT26471048	THRUST BEARING 8104
49	PT26471049	SPACER
50	PT26471050	WORM GEAR PLATE
51	PT26471051	CONNECTING ROTATING SHAFT
52	PT26471052	TAPER BRACKET
53	PT26471053	TAPER BRACKET PIN
54	PT26471054	SPACER
55	PT26471055	FLAT HD CAP SCR M6-1 X 12
56	PT26471056	CAP SCREW M5-.8 X 10
57	PT26471057	KNURLED HANDWHEEL
58	PT26471058	CRANK
59	PT26471059	TAPER ROLLER
60	PT26471060	SHOULDER BOLT M10-1.5 X 15, 96L
61	PT26471061	REAR ROLLER BUSHING
62	PT26471062	BALL BEARING 6005ZZ
63	PT26471063	FLAT WASHER 25MM
64	PT26471064	LEVER
65	PT26471065	CRANK HANDLE
66	PT26471066	CAP SCREW M8-1.25 X 20
67	PT26471067	KEY 4 X 4 X 18
68	PT26471068	HEX BOLT M8-1.25 X 16
69	PT26471069	FLAT WASHER 6MM
70	PT26471070	KEY 4 X 4 X 20
71	PT26471071	CAP SCREW M6-1 X 30
72	PT26471072	FLAT WASHER 6MM
73	PT26471073	CAP SCREW M6-1 X 12
74	PT26471074	GRIZZLY LOGO PLATE
75	PT26471075	GRIZZLY GREEN TOUCH-UP PAINT
76	PT26471076	CRUSHING INJURY WARNING LABEL
77	PT26471077	EYE INJURY WARNING LABEL
78	PT26471078	ID LABEL
79	PT26471079	READ MANUAL LABEL
80	PT26471080	PINCH INJURY WARNING LABEL





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The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

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Advertisement                       Friend                       Catalog  
 Card Deck                               Website                       Other:

2. Which of the following magazines do you subscribe to?

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<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	

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 \$50,000-\$59,000                       \$60,000-\$69,000                       \$70,000+

4. What is your age group?

20-29                                       30-39                                       40-49  
 50-59                                       60-69                                       70+

5. How long have you been a woodworker/metalworker?

0-2 Years                       2-8 Years                       8-20 Years                       20+ Years

6. How many of your machines or tools are Grizzly?

0-2                       3-5                       6-9                       10+

7. Do you think your machine represents a good value?       Yes                       No

8. Would you recommend Grizzly Industrial to a friend?       Yes                       No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?  
**Note: We never use names more than 3 times.**       Yes                       No

10. Comments: \_\_\_\_\_  
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# WARRANTY & RETURNS

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Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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