KAKA INDUSTRIAL W01-4914

KAKA INDUSTRIAL W01-4914 Slip Roll Machine User Manual

Model: W01-4914 | Brand: KAKA INDUSTRIAL

1. Introduction

This manual provides essential information for the safe and efficient operation, setup, and maintenance of your KAKA INDUSTRIAL W01-4914 Slip Roll Machine. Please read this manual thoroughly before operating the machine to ensure proper usage and to prevent injury or damage.



Figure 1: KAKA INDUSTRIAL W01-4914 Slip Roll Machine

2. Safety Information

Always prioritize safety when operating any industrial machinery. Failure to follow safety guidelines can result in serious injury or equipment damage.

- **Read the Manual:** Understand all operating procedures and safety warnings before use.
- **Wear Personal Protective Equipment (PPE):** Always wear safety glasses, gloves, and appropriate work attire. Avoid loose clothing or jewelry that could get caught in moving parts.
- **Secure the Machine:** Ensure the slip roll machine is securely bolted to a stable floor using 1/2" hardware (not included) to prevent movement during operation.
- **Clear Work Area:** Keep the work area clean, well-lit, and free from obstructions.
- **Authorized Personnel Only:** Only trained and authorized individuals should operate this machine.
- **Material Handling:** Be aware of the weight and size of sheet metal. Use proper lifting techniques or assistance when

handling large or heavy materials.

- **Freight Delivery:** Please note that someone must be present at the delivery address to receive the shipment and sign for it. For residential locations, a liftgate service is strongly recommended as the truck may not have a loading dock.

3. Product Overview

The KAKA INDUSTRIAL W01-4914 Slip Roll Machine is a robust manual sheet metal roller designed for forming cylindrical, conical, arc, and other curved shapes from various metal sheets. Its heavy-duty construction ensures stability and precision for industrial bending tasks.

Key Features:

- **49-Inch Width Capacity:** Processes 16-gauge mild steel and 18-gauge stainless steel sheets up to 49 inches (1245mm) wide.
- **Dual-Speed Gearbox:** Features a 3.5:1 power mode for thicker materials and a 1:1 fine-control mode for precise adjustments.
- **60mm Ground Rolls:** Equipped with wire-forming grooves for versatile bending applications.
- **Heavy-Duty Cast Iron Construction:** A 504-lb frame with pre-drilled mounting holes ensures stability and durability.
- **Quick-Release Top Roller:** Simplifies workpiece removal after forming.
- **Multi-Shape Forming:** Capable of creating precise cylinders, cones, arcs, and bends for sheet metal and structural components.

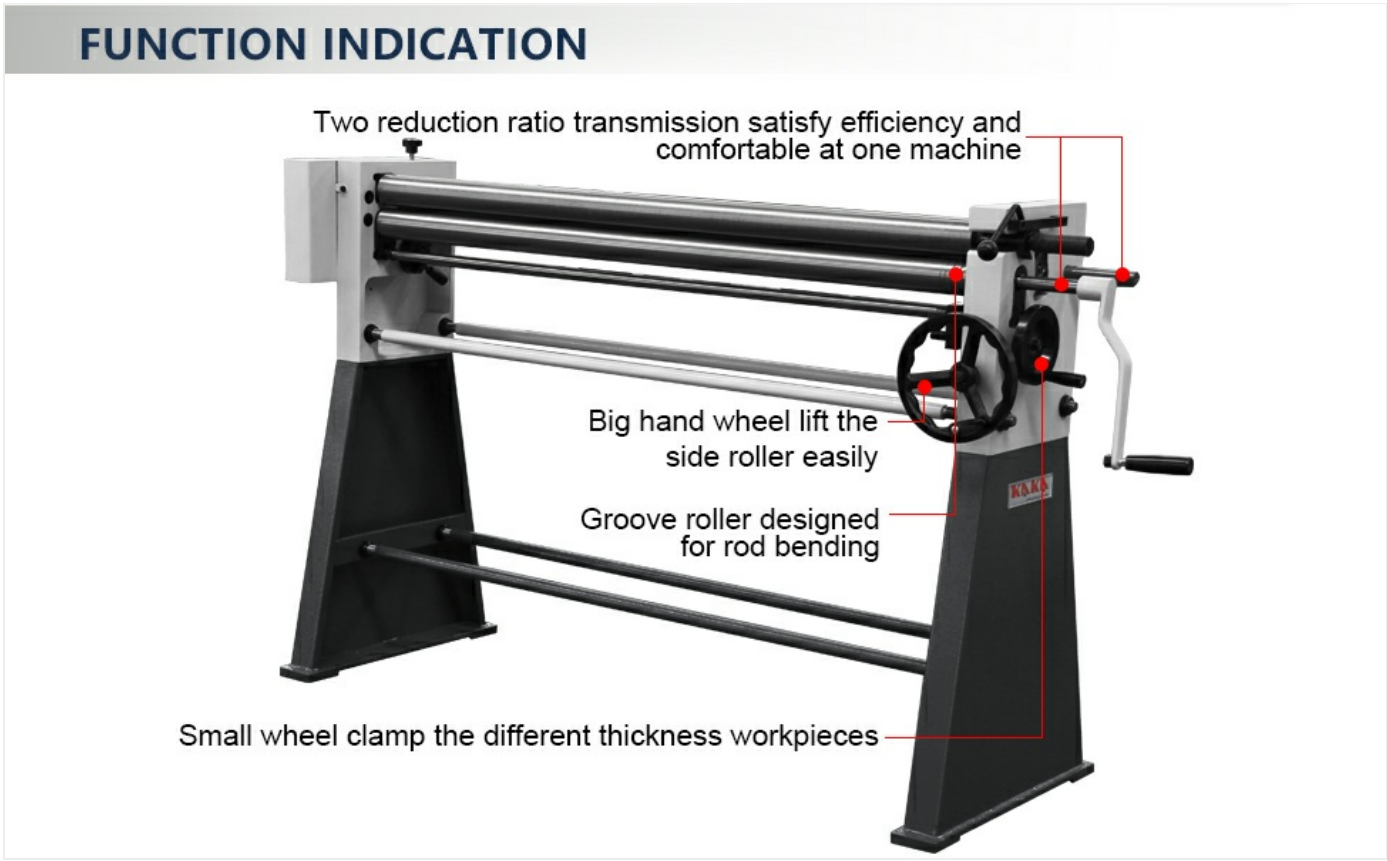


Figure 2: Function Indications of the Slip Roll Machine

4. Setup

Proper setup is crucial for the stability and safe operation of your slip roll machine.

1. **Unpacking:** Carefully unpack all components. Inspect for any shipping damage.

2. **Assembly:** Assemble the floor stand if it arrived disassembled. The machine's heavy-duty cast iron frame is designed for stability.
3. **Mounting:** Position the machine on a level, sturdy surface. Securely bolt the base to the floor using 1/2" hardware (not included) through the pre-drilled mounting holes. This prevents tipping or shifting during operation.
4. **Clearance:** Ensure adequate clearance around the machine for material handling and safe operation.



Figure 3: Machine with Stand Separated for Setup

5. Operating Instructions

Follow these steps for effective and safe operation of the slip roll machine.

5.1 Adjusting Rollers

- **Material Thickness:** Use the small hand wheel to adjust the gap between the rollers to match the thickness of your workpiece. Ensure the material can pass through smoothly but with slight resistance.
- **Curvature Adjustment:** The large hand wheel lifts the side roller, allowing you to control the desired curvature of the bend. Adjust incrementally to achieve the desired radius.
- **Wire-Forming Grooves:** The 60mm ground rolls include grooves for forming wires or rods. Align the material with the appropriate groove for specific applications.



Figure 4: Control Wheels for Roller Adjustment

5.2 Feeding Material

1. **Insert Material:** Carefully feed the leading edge of the sheet metal between the top and bottom rollers.
2. **Engage Rollers:** Turn the main hand crank to engage the rollers and begin feeding the material through.
3. **Dual-Speed Drive:** Utilize the dual-speed gearbox. The 3.5:1 power mode is suitable for initial passes or thicker materials, while the 1:1 fine-control mode offers greater precision for final shaping.
4. **Multiple Passes:** For tighter bends or thicker materials, multiple passes may be required, gradually increasing the roller pressure with each pass.

5.3 Removing Workpiece

- **Quick-Release:** Once the desired shape is achieved, use the quick-release mechanism on the top roller to disengage it.
- **Remove Material:** Carefully slide the formed workpiece off the rollers.



Figure 5: Quick-Release Mechanism

5.4 Instructional Video

Your browser does not support the video tag.

Video 1: KAKA Industrial Slip Roll Machine Operation (W01-4914). This video demonstrates the basic operation and features of the slip roll machine, including roller adjustments and material feeding.

6. Maintenance

Regular maintenance ensures the longevity and optimal performance of your KAKA INDUSTRIAL Slip Roll Machine.

- **Cleaning:** After each use, clean the rollers and machine body to remove metal shavings, dust, and debris.
- **Lubrication:** Periodically lubricate all moving parts, gears, and adjustment screws according to manufacturer recommendations to ensure smooth operation and prevent wear.
- **Inspection:** Regularly inspect rollers for any signs of wear, damage, or misalignment. Check all fasteners for tightness.
- **Removable Rollers:** The hardened rollers are designed to be removable, simplifying maintenance and replacement if

necessary.

- **Storage:** Store the machine in a dry, clean environment to prevent rust and corrosion.

7. Troubleshooting

This section addresses common issues you might encounter. For problems not listed here, contact customer support.

- **Difficulty Rolling Material:**
  - Ensure rollers are adjusted correctly for material thickness.
  - Verify material is within the machine's capacity (49-inch width, 16-gauge mild steel, 18-gauge stainless steel).
  - Check for any obstructions or debris on the rollers.
- **Uneven Bends:**
  - Ensure even pressure across the rollers. Adjust the side roller uniformly.
  - Verify the material is fed straight and consistently.
- **Stiff Operation:**
  - Check for adequate lubrication on all moving parts.
  - Inspect for any binding or foreign objects in the gears or roller mechanisms.

8. Specifications

Attribute	Value
Manufacturer	KAKA INDUSTRIAL LLC
Part Number	W01
Item Weight	504 pounds
Product Dimensions	71 x 20 x 28 inches
Item Model Number	W01-4914
Size	49 in x 16 Ga.
Color	Grey
Material	Metal
Power Source	Hand-powered
Item Package Quantity	1
Included Components	Floor Stand

9. Warranty and Support

KAKA INDUSTRIAL is committed to providing quality products and customer satisfaction.

- **Returns:** This product is eligible for 30-day easy returns. Please refer to the retailer's return policy for details.
- **Customer Support:** For any questions, technical assistance, or support needs, please contact KAKA INDUSTRIAL LLC

directly.

- **Brand Store:** Explore other products and resources from KAKA INDUSTRIAL at their official store:KAKA INDUSTRIAL Store.

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Ask a question about this manual

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the question and use this page's manual context to help answer it.

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Anonymous

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Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question