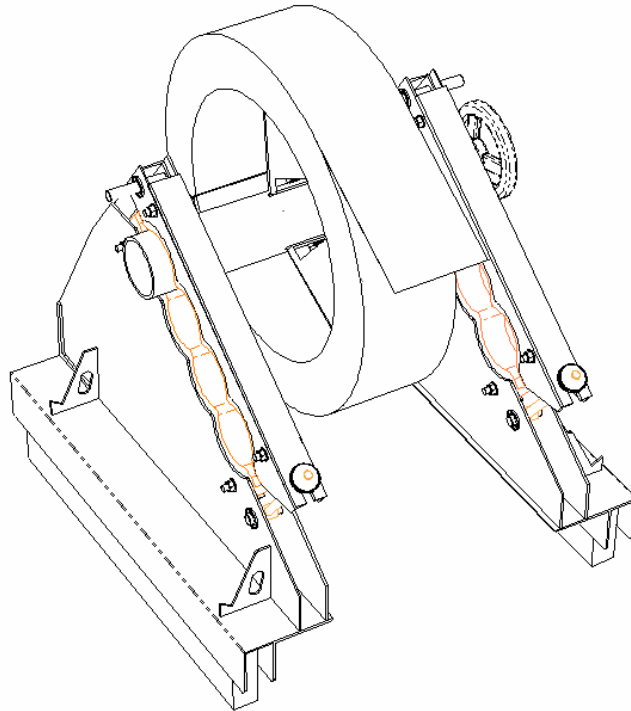


HOW TO LOAD COIL INTO THE FRAME MACHINE

NOTE : At all times use extreme caution when handling coils due to their large weight.

- 1/ Lift coil off pallet & stand vertically on floor
- 2/ Lift decoiler mandrel off decoiler base and slide into center of coil
- 3/ Wind handle on mandrel until shoes lock firmly onto coil



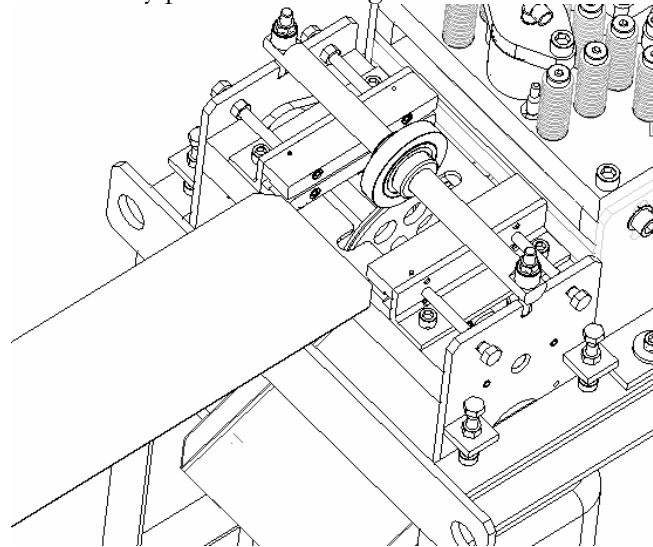
4/ Roll coil and mandrel onto decoiler base so that the coil will feed off the top off the decoiler. Lock top arms over mandrel shaft and tighten up hand nuts.

5/ Using the pallet trolley lift the decoiler off the floor and position in front of the Frame Machine so the coil is in line with the slot in the end of the machine covers and at least 8 feet away.

6/ Place the wooden blocks in the slots under the decoiler and lower the decoiler onto the blocks.

7/ Cut the strapping that may be holding the coil bound up being careful to avoid any backlash when the tension is released. Make sure you remove all packing tape off the coil as this catches in the machine.

8/ Trim the end of the coil according to the coil loading template and flatten any dents or damage in the coil that may prevent it loading.



9/ Feed the end of the coil into the guide unit and through the pre-punch unit into the rollers. With the machine in manual mode use the switch on the side to inch the strip forward and through all the roller stages being careful it does not catch anywhere as it feeds through.

10/ When the strip has fed through the whole machine and out through the cut-off, the machine is ready to operate.

Note : It is Important before using the machine to make sure that lubricant is in the bath located before the first set of rollers. This can be done by hand priming using the handle on the pump operating rod.

