



## Select Seam<sup>®</sup> Curving Machine

### Operating Instructions



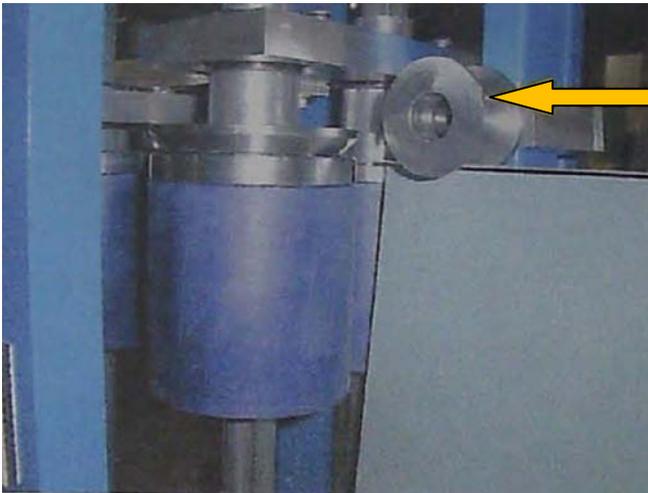
The AEP Span Select Seam<sup>®</sup> Curving Machine is designed to curve both the roof panels and the narrow batten caps. The amount of radius possible will vary with the material type and material thickness. The user will not be able to obtain the same minimum radius with different materials. The best results will be obtained by using the referenced scale on the machine to develop a "log book" of radius sizes depending on the type of material type and material thickness.

## **PANEL CURVING**

1. Set the bottom guide rolls at the upper (of two) scribe lines. This sets the bottom guides level to the forming rolls in the machine. It is of the utmost importance that the panels enter the machine straight and level to the forming rolls. Feed problems may occur if the panel does not enter level with the curving rolls. It is also helpful to cut a slight angle on the leading edge of the Select Seam<sup>®</sup> panels with a pair of snips.

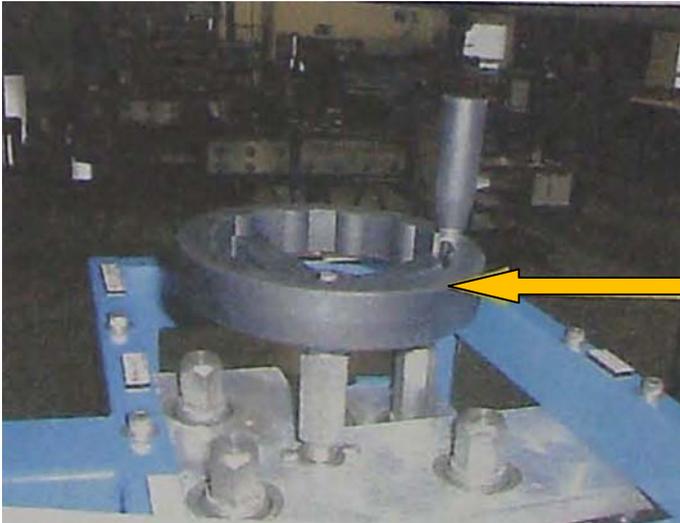


2. Lower the top guide rolls to hold the material in place.



**Top guide rolls**

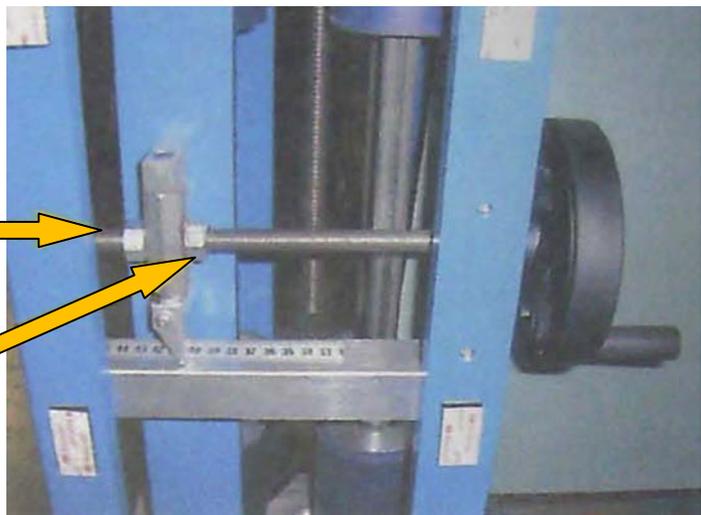
3. Slide the panel up to the forming rolls. Then raise or lower the top rolls by turning the crank on the top of the unit until the corners of the panels match the slots in the forming rolls. It is very important that the width between the forming rolls matches the panel exactly. If it does not the panel may be crushed by the machine.



**Top crank handle  
adjustment for panel  
width**

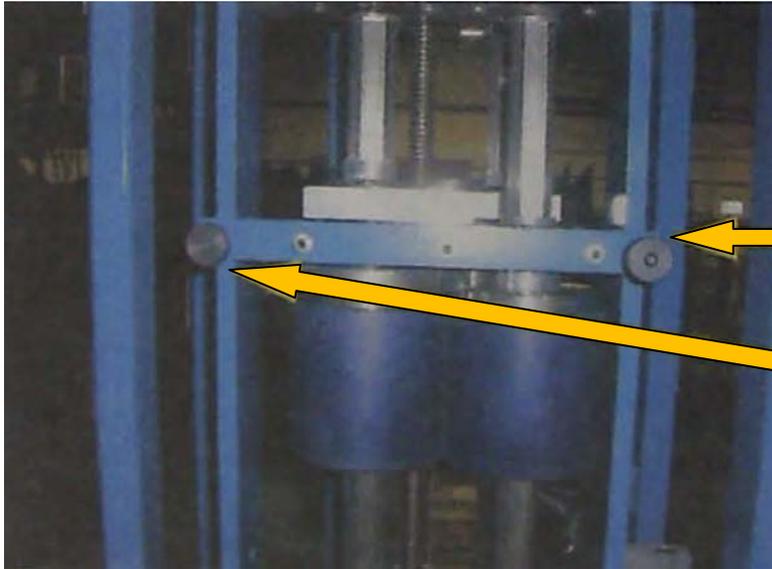
4. Since all materials will form differently, the user may have to test the panel and make adjustments until the desired radius is achieved. The panel may have to be stopped in the machine and the amount of radius adjusted with material in the machine.

5. To keep the radius setting, lock the jam nuts on the pinion of the crank handle adjustment.



**Radius setting  
jam nuts**

6. To control the curving of the top portion of the Select Seam<sup>®</sup> panel, lock the two knob screws into the rail. This setting helps to support the "floating rail" adjustment side of the Select Seam<sup>®</sup> panels. Note: Remember to loosen the knob screws when adjusting the floating rail for different panel widths.



**Floating rail knob  
screws**

7. To avoid any warping, be sure that the panel is supported as it exits the machine.

## **BATTEN CAP CURVING**

1. Set both the entrance rolls to the bottom set of scribe lines for the batten cap. Check to see the direction that the cap curving rolls are facing. Lay the cap on the side that matches the form of the curving rolls, and feed into the machine. Note: The jeweler saw blade should be on the inside of the batten caps.
2. The batten cap curving setting will be a different setting than was used to produce the matching panel. It is an opposite adjustment with the curving rails than with the Select Seam panel. Remember to note your settings on the caps based on the type of material and thickness.



3. The cap must also be supported as it exits the machine.

## **GENERAL MACHINE SPECIFICATIONS**

### **Product limitations (AEP Span):**

22ga to 24ga steel (painted or bare)  
.032 aluminum  
16 oz. copper  
Select Seam<sup>®</sup> Pan widths: 12" to 21-1/4"

Electric Gear Box Drive: 3/4 HP 110 volt, 1 Phase, 11.4 AMPS.

## **GENERAL MAINTENANCE**

**Hexagonal shafts** must be kept clean. DO NOT use oil or grease on these shafts. This will attract dust and grit which will stick and cause wear. Simply wipe the shafts clean and apply a silicone spray lubricant.

**Steel forming roll cleaning:** Galvanized steel may leave a deposit on the stainless steel forming rolls. If this is a problem, it may be prevented by applying a light coating of Galv-Off<sup>®</sup> on the steel portion of the forming rolls only. Should a deposit build up on the rolls, it can be removed using a fine abrasive cloth, such as Scotch-Brite<sup>™</sup>.

**Rubber roll cleaning:** To clean the rubber rolls use a degreasing solvent and a clean cloth. Do not attempt to clean rolls while the machine is plugged in. The material chosen to roll form is very important to the quality of the finished panel.

### **!! VERY IMPORTANT !!**

- **Disconnect all power before removing any covers on the machine.**
- **Disconnect all power before servicing and adjusting the machinery.**
- **Do not operate the machine at any time with the covers removed.**