

INSTRUCTION BOOKLET FOR

STRAIGHTENERS

**MODEL #SC, MSC, MD, HD, SD,
SS, MS, & FS**



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ATTENTION: PLANT MANAGER

Thank you for purchasing Durant equipment. Enclosed are very important safety instructions, operating instructions, and setup procedures.

Read all these materials completely and carefully. Please distribute copies to your SAFETY MANAGER, PRODUCTION MANAGER, and MACHINE OPERATORS.

If there is any help required in setup or operation, we will be readily available for your assistance.

Thank you again and we look forward to developing and maintaining a fine relationship with your company.

Sincerely,

DURANT TOOL COMPANY

SAFETY INSTRUCTIONS FOR ALL DURANT EQUIPMENT

The enclosed information and instructions must be forwarded and distributed to the Plant Safety Director, Plant Manager, Production Manager, and all Operators of Durant equipment.

Operators of Durant equipment must have a minimum of (3) three years operating experience with similar Durant press room equipment or a minimum of (3) three years experience with identical equipment manufactured by other press room equipment manufacturers.

WARNING

Never operate, install, or maintain this machine without understanding the complete and safe operation thereof.

It is the employer's responsibility to provide proper safety devices and equipment to safeguard the operator from harm and to safeguard this machine at all times to meet all current government safety codes and standards.

CAUTION

All Durant equipment must be securely fastened to the floor. This will prevent the machine from tipping. Failure to follow the above instructions could cause harm to the operator or machine.

ATTENTION

If any danger points are observed:

1. Immediately stop machine.
2. Do not run machine until danger point is eliminated.
3. Report danger point in writing to your employer.
4. Keep a copy of your report for your records.
5. Do not run machine again until danger point has been corrected.
6. It is your employer's responsibility to safeguard this machine to meet all government safety codes and standards.
7. There are U.S. companies that specifically specialize in safe guarding machines to plant requirements and government codes. The safe guarding companies are located throughout the United States, Canada, and foreign countries. Representatives will visit your site to advise and recommend safe guarding procedures for your company.

IMPORTANT

Before the first use and monthly thereafter, all nuts, screws, and bolts should be checked for tightness. Gears, sprockets, chains, and belts should also be checked for tightness.

Grease and oil fittings and reducers monthly.

STRAIGHTENER ADJUSTING THE STOCK STRAIGHTENER

1. Release all top rolls of the straightener including the entrance and exit rolls.
2. Insert a piece of material through the straightener. This material should pass through the straightener freely.
3. Tighten the top entrance and exit rolls on straighteners having both entrance and exit rolls so the material will pass through the straightener without slippage. Do not overtighten so the material will be “ironed”.
4. Adjust the first top straightening rolls (closest to the entrance rolls) so material is deflected slightly.
5. Adjust subsequent top straightening rolls with sufficient pressure to remove coil curvature. The correct pressure is determined by the thickness, type, and temper of material. As the curvature of material increases toward the center of the coil it may be necessary to readjust the top straightening rolls slightly to compensate for changes in curvature.
6. On motorized stock straighteners the material comes out of the straightener and goes under the loop control arm. As the material is used the loop control arm rises and actuates the micro switch on the straightener to start the flow of material. As the loop control arm drops to a given point the flow of material stops and feeding is done out of the loop.
7. On straighteners with a variable speed drive it is important to adjust the vari-speed so that the flow of material approximates the use requirement and the off and on of the motor is kept to a minimum.
8. On straighteners with single phase motorization no more than six starts and stops a minute can be made or the motor will burn out.

Note: A time delay control is provided on several models. This timer is located inside the control box. It can be adjusted to allow your material to continue to run after the loop control limit switch has been given a stop signal. The time delay is utilized to reduce the amount of start/stop signals or to increase the size of your loop.

Standard on #MD, HD, & SD models.

9. Start machine and check stock for curvature, if curvature still exists check direction of curve. If the curve is in the same direction as when stock entered the machine, apply more pressure to rolls (always declining from roll 1 to 3). If curve is in opposite direction turn screw back to reduce pressure slightly.
10. After setting straightener it should not be necessary to reset for each coil of the same stock.

