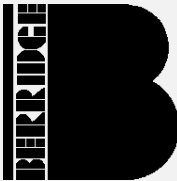
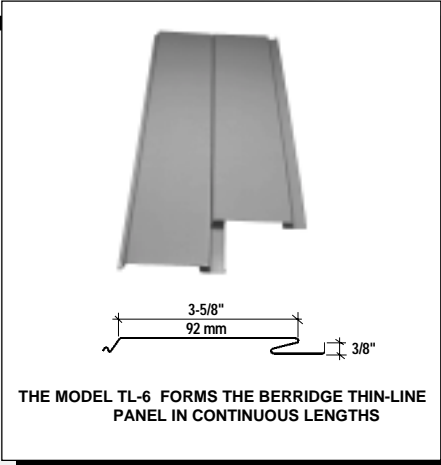


OPERATIONS MANUAL

BERRIDGE MODEL TL-6 PORTABLE ROLL FORMER



**Berridge
Manufacturing
Company**

LEASED TO: _____

DATE: _____ SER. NO.: _____

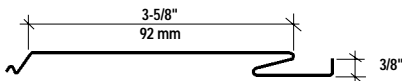
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I. GENERAL DESCRIPTION

THE BERRIDGE MODEL TL-6 PORTABLE ROLL FORMER is a precision-manufactured machine designed to provide high quality "Jobsite" production capability for installers of the BERRIDGE THIN-LINE panel (Fig. 1).

Fig. 1



THE BERRIDGE MODEL TL-6 PORTABLE ROLL FORMER is mounted on a heavy-duty four wheel cart and is completely self-contained, including uncoiler, mechanical shear and counter gauge for measuring panel length.

CASTER BRAKES & LOCKING MECHANISM:

For safety reasons, it is recommended that the foot brakes on each caster be placed in the locked position whenever the roll former is not being moved. Also, note the two front casters have a locking mechanism to keep them from swiveling. This is useful when pulling the cart onto the Berridge Trailer.

MODEL TL-6 COIL USAGE:

Coil material used with the Berridge Model TL-6 Portable Roll Former must comply with the following parameters:

- Coil Width 5.75 inches (nom. 6")
- Maximum Weight 480 Lbs.
- Material: Prefinished galvanized or Galvalume

NOTE: Do not run unpainted coil on the TL-6 Portable Roll Former; Unpainted coil may cause flake build-up on rolls. Because the TL-6 is a precision machine, designed to fabricate only Berridge-developed products, only Berridge Coil may be used in these roll-formers. Other coil material may vary in thickness, hardness, and surface treatment which could damage the components of the TL-6 Roll-Former. Also, defective coil material will result in a defective product which could damage the reputation of the high quality Berridge products. Therefore, only Berridge coil is allowed to be used in any Berridge Portable Roll-Former. If it is discovered that any other material has been used in a Berridge Portable Roll-Former, Berridge Manufacturing Company has the right to recall the machine and completely disassemble and inspect it . A service charge will be assessed.

TRANSPORTING THE TL-6:

Never transport the machine without a piece of coil remaining in contact with all rolls. This keeps the rolls from moving while in transit and becoming scarred or damaged. Do not transport the roll former with a coil loaded on the uncoiler unless the uncoiler is blocked to support the weight of the coil .

ELECTRICAL POWER REQUIREMENTS:

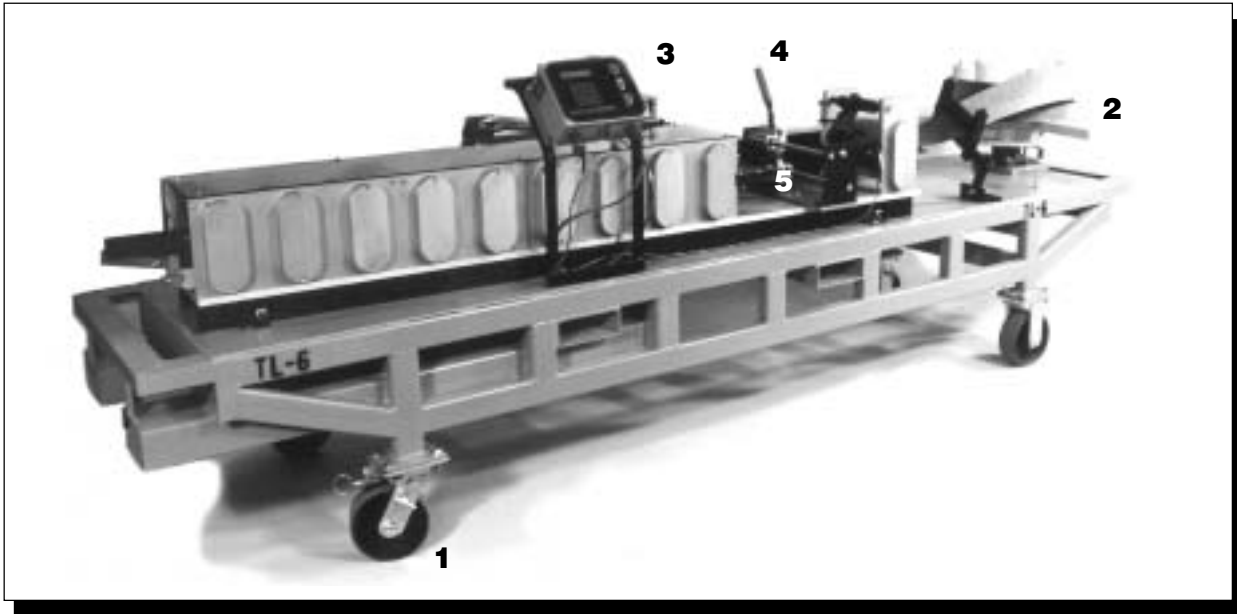
The Berridge Model TL-6 Portable Roll Former requires standard U.S. electrical current of 110 to 120 volts AC 60 cycles. Connect to a grounded supply receptacle with at least 20 amp current capacity. If extension cords are required, use the following recommended sizes:

Length	Wire Gauge
0-50 FT	10
50-100 FT	8
100+ FT	6 (150 FT MAX.)

NOTE: The use of portable electric generators to power the Model TL-6 is not recommended, as this practice will lead to damage to the electric motor.

II. EQUIPMENT NOMENCLATURE

MODEL TL-6 PORTABLE ROLL-FORMER



FEATURES:

1. CASTERS
2. UNCOILER
3. BATCH CONTROL COMPUTER
4. MECHANICAL SLITTER SHEAR
5. SWIVEL SHEAR FOR BEVEL-CUT PANELS

ROLL FORMER SPECIFICATIONS

WIDTH: 2'-10"
LENGTH: 12' - 6"
HEIGHT: 46"
WEIGHT: 2200 LBS (2300 LBS W/METAL COVER)
SPEED: 45' PER MINUTE
MOTOR: 2 H.P. 110V. AC SINGLE-PHASE CONTROL

III. OPERATING INSTRUCTIONS

STEP ONE - LOADING COIL

- A. Lock all four casters.
- B. Rotate the eccentric tubes (Detail B-2) on the uncoiler by loosening the nuts on top of tubes (Detail B-1). Then rotate tubes inward to accept the coil.
- C. Load the coil with painted side facing toward operator side of rollformer, with leading edge toward the machine.
- D. Unlock arm of the coil lifter apparatus (Detail C-1), fold legs inward (Detail C-2) and place inside the coil (Detail C-3). The coil lifter legs should now be locked in place and the coil should be fully seated on the pads of the coil lifter legs.
- E. Using a forklift or other suitable hoist with a minimum load capacity of 2000 pounds, pick up the coil by means of a chain (sized to accommodate load) attached to the top of the coil lifter. Keep to one side of coil and avoid standing underneath it during the loading operation. Next, lower the coil onto the uncoiler, and keep it centered on the uncoiler with the leading end positioned clockwise, ready to feed into the machine.

STEP TWO - FEEDING COIL INTO THE ROLLFORMER:

- A. The TL-6 rollformer forms the panel horizontally instead of on edge like other Berridge models, requiring the coil to twist between the uncoiler and the entry end of the rollformer. The coil strip must be fed between the rolls on the angled support roller in front of the uncoiler. When running large coils, pay careful attention to the location of the coil strip feeding from the uncoiler. Do not allow the strip to drop down too low and bind on the uncoiler bars. This condition is minimized as the coil diameter decreases.
- B. The coil brake on the machine consists of a spring pin with a pull ring located on the entry end of the feed-in station before the shear. The pin engages a gear to lock the rolls on the station and prevent the coil from traveling. To engage the brake, rotate the pin 90 degrees allowing the end of the pin to engage the gear teeth.



Fig. 1

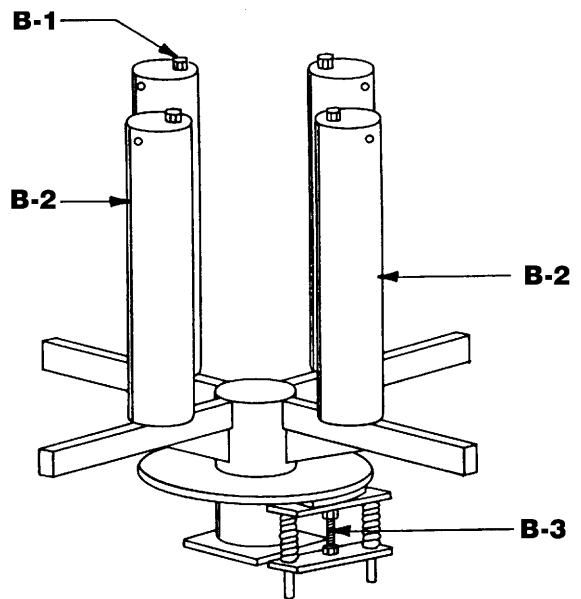


Fig. 2

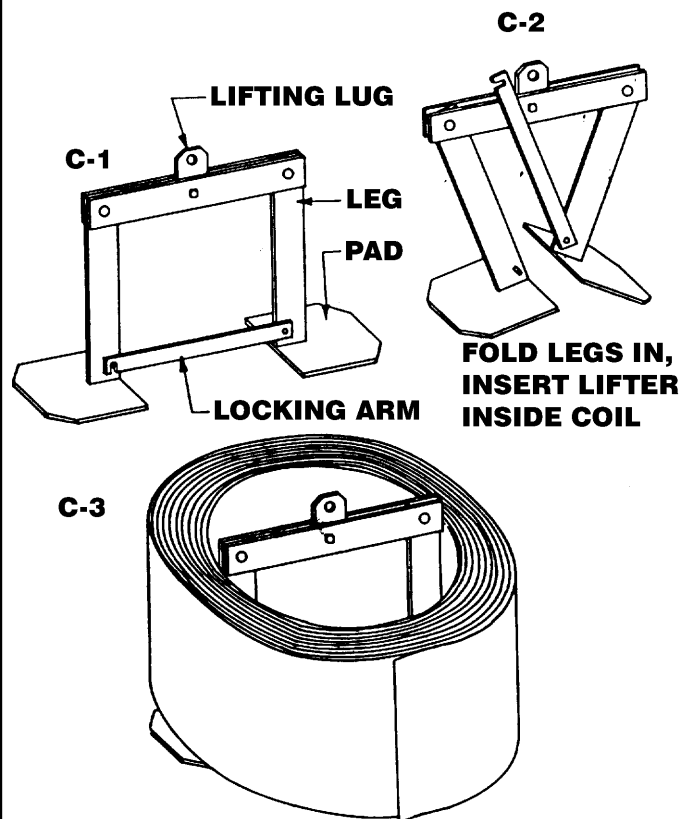


Fig. 3

Clockwise from Upper Left:
Fig. 1: Do not allow the coil to dip too low and bind on uncoiler bars. Fig. 2: Coil feed operation. Fig. 3: Hand Shear operation of the TL-6



B-1 LOCKING NUTS
B-2 ECCENTRIC TUBES
B-3 BRAKE ADJUSTMENT BOLT



III. OPERATING INSTRUCTIONS

STEP THREE - RUNNING PANELS

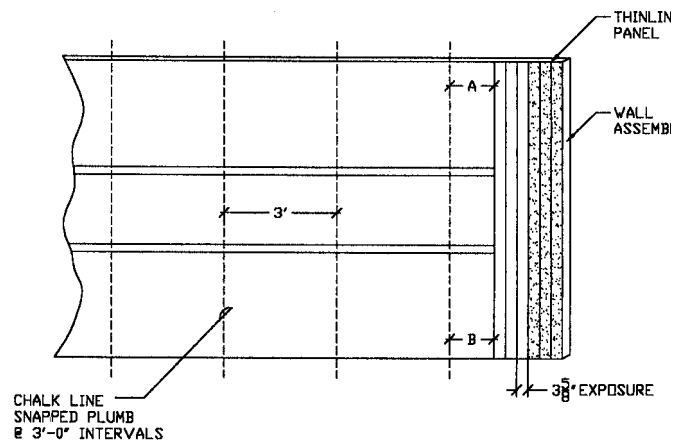
- A. Pay very careful attention to the handling of the panels as they exit the rollformer. Due to the narrow profile of the Thin-Line Panel, it will bend and deflect more easily than other Berridge panels. Ensure that the panels are held in line with the rollformer as they exit. Do not allow them to be pulled to the left or right. Also, the panel must be held on a level plane with the rollformer to avoid bending.
- B. The rollformer is outfitted with a swivel shear (fig. 1) for making diagonal cuts. This shear will enable you to run panels with diagonal cuts at the same angle at both ends of the panel. The shear is locked in place with two wingnuts that tighten against the base plate of the rollformer. Both wingnuts must be tightened to hold the shear firmly in place. Before beginning production, run a test panel and verify the angle of the cut is correct.



Fig. 1: The rollformer is outfitted with a swivel shear for making diagonal cuts.

IV INSTALLATION OF THIN-LINE PANELS

- A. As with any architectural product, proper installation techniques are essential to assure a pleasing satisfactory appearance. At about 12 inches from each end of the wall, strike a plumb line. Also strike plumb lines for use as guides at 3 ft. intervals along the wall. Begin installation at one end of the wall. As you proceed with panel installation, take measurements at the top and bottom of the panel to the nearest plumb line. Ensure that the distances are equal. If the distances are not equal, butt the panel tight at the narrow dimension, while at the wider dimension allow a hairline gap. This will ensure that your panels remain plumb as you proceed along the wall.



NOTE: CONTINUOUSLY VERIFY THAT "A" IS THE SAME AS "B" DURING INSTALLATION

- B. We suggest the following procedure: If the female leg is on the left side of the panel, install the next panel while applying tight pressure at the top of the panel. However at the bottom of the panel allow a hairline gap during installation. This procedure will minimize the need for adjustments as you proceed down the wall. Use the chalk line guides to make adjustments as necessary.

V. MAINTENANCE INSTRUCTIONS

THE BERRIDGE MODEL TL-6 PORTABLE ROLL FORMER requires very little maintenance. To insure the highest quality product and maximum machine life, the following routine preventative maintenance is required. Keep the machine **DRY, CLEAN & DIRT-FREE**; this is a precision piece of equipment. Keep a **MAINTENANCE LOG**.

- A. Remove Lexan panel from top. Clean the **ROLLS** with a quality grease-cutting cleaner. Dampen a rag with the cleaner and wipe dies. Do not spray cleaner directly on dies. Do not spray the cleaner on the Lexan panels.
- B. Clean the **LEXAN TOP PANEL** with glass cleaner (Windex or equiv.) and the **ALUMINUM FRAME** with liquid household cleaner. This will remove lubricant and dirt from the aluminum frame.
- C. The **SHEAR, UNCOILER** and **CASTER** may be lubricated with a good grease. Lubricate the upper and lower bearing on the Uncoiler. Do not apply grease to the drive gears on No. 1 Station as any dirt, paper etc. on the coil will collect on the grease.
- D. The **DRIVE CHAINS** may be lubricated with the Teflon lubricant such as ZEP 45.
- E. **MAIN DRIVE GEAR BOX:** The Grove Flexaline Gear Box uses 600W Super oil by Mobil.
- F. The **TABLE** can be cleaned with any liquid household cleaner. Touch-up as needed with Glidden "Bolt Green" paint.
- G. Lubricate the **SLIDES & SHEAR** once every 3 months with ZEP 45 or equivalent.
- H. Check tightness of all **MOUNTING BOLTS & SCREWS** regularly, especially after each time the machine has been in transit.

NOTE TO LESSEES:

The Berridge Model TL-6 Roll Former Machine is shipped in good working condition and must be returned in the same condition. The cost of any required repairs for damage or deterioration caused by misuse or negligence will be charged to lessee.

VI. SAFETY

It is important to abide by normal safety rules when operating the **BERRIDGE MODEL TL-6 PORTABLE ROLL FORMER**. While Berridge recommends the following minimum safety practices, the company accepts no responsibility for personal injury or property damage incurred while operating the machine.

- A. Make sure electrical outlet is grounded.
- B. Do not operate machine in rain or stand in water while operating .
- C. Make sure electrical cord is free of cuts and exposed wire.
- D. Keep hands and clothing out of the rolls and the shear blade.
- E. Keep wheels locked on the machine except when necessary to physically move it.
- F. Do not stand under coil when loading or unloading machine.
- G. Do not operate machine with plexiglass panel removed.



**PORTABLE ROLLFORMER
RETURN INFORMATION**

DATE RETURNED _____

MODEL # _____

SERIAL # _____

COIL HOOK CRATE TARP

MISCELLANEOUS (LIST) _____

COMMENTS _____

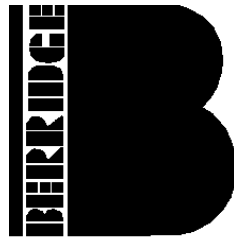
REPAIRS: _____

LABOR COST: _____

PARTS COST: _____

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