



**ROLL FORMER CORP.**

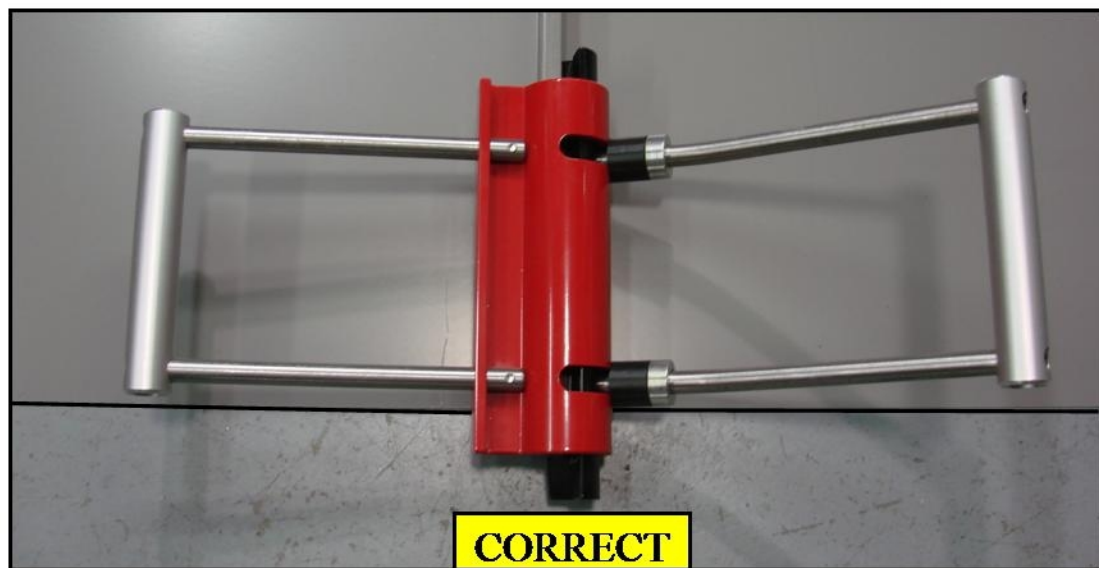
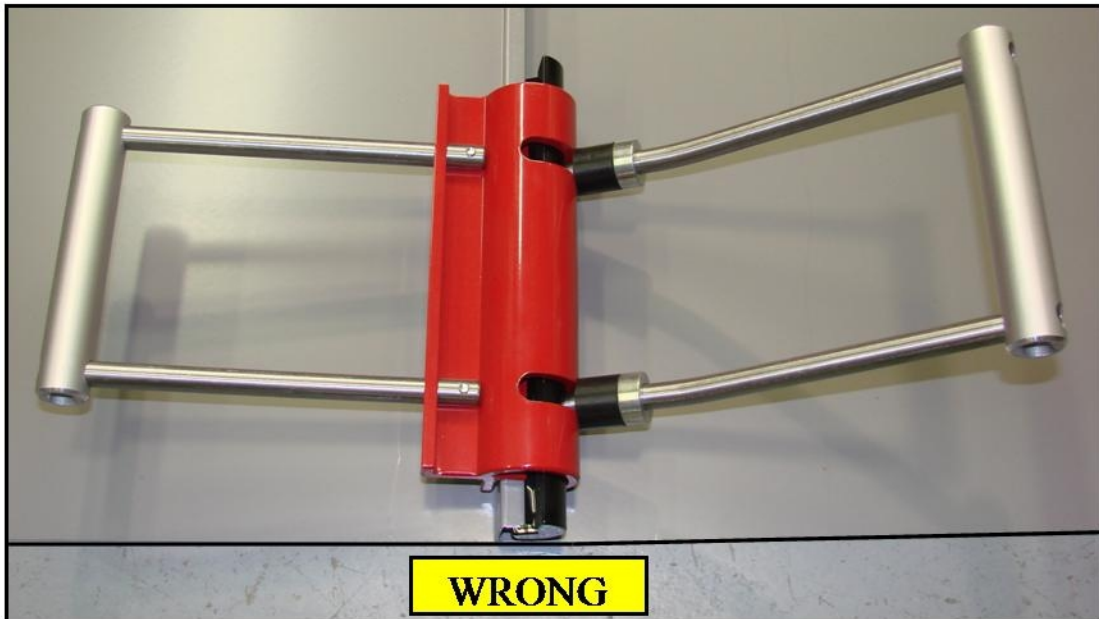
**SSX SEAMER**

**OWNER'S MANUAL**

**ROLL FORMER CORP.  
140 Independence Lane – Chalfont, PA 18914  
215-997-2511 - FAX: 215-997-5544**

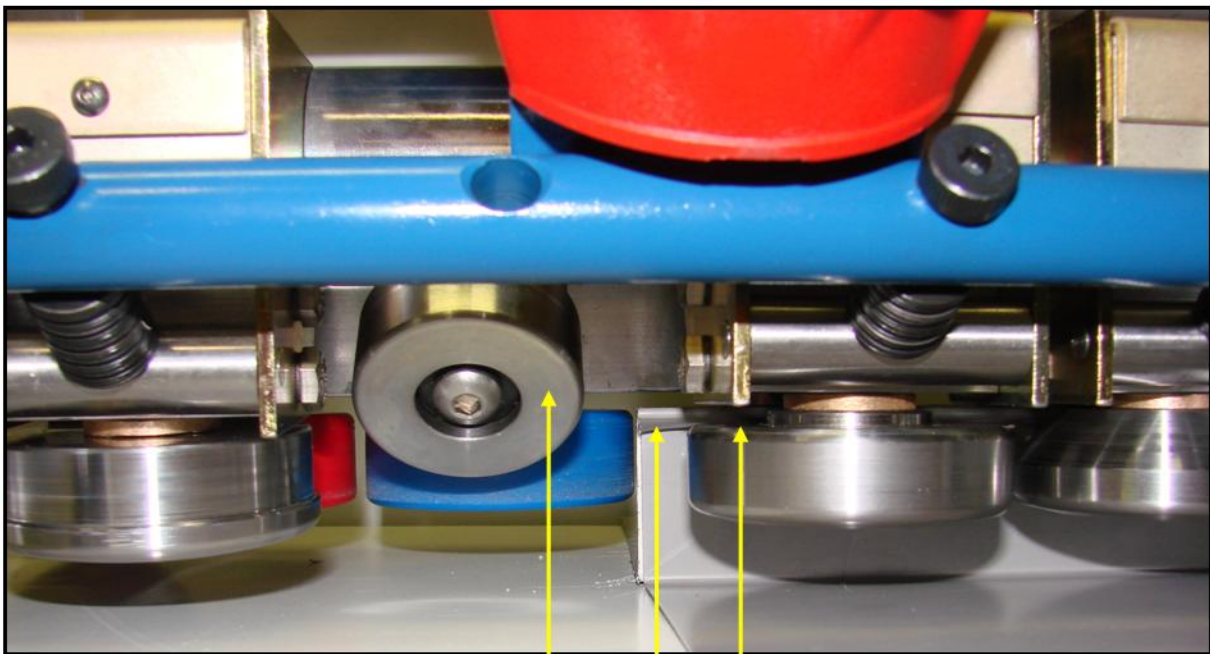
## Starting a panel with a hand tool

When making the first crimp, at the edge of the panel with the 90° hand tool, you must start towards the middle of the tool. If you have the panel edge at the end of the tool, the relief in the tool die will not form the metal correctly. Then when you place the power seamer on the panel, it will not turn the seam properly.



## Starting a panel

Direction of travel



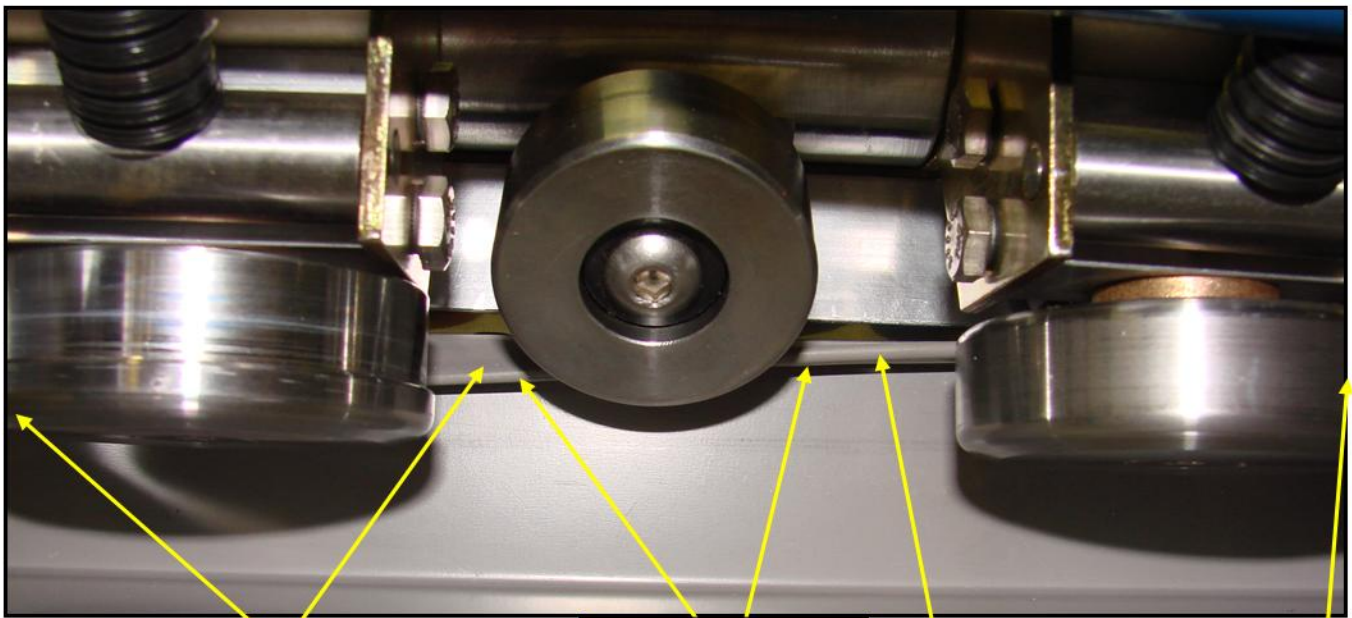
Stage # 2 is under 90°  
seam made with hand tool

No radius from 90° hand tool  
on end of panel

End of panel does not  
contact angle roll

**Starting in the middle of a panel**

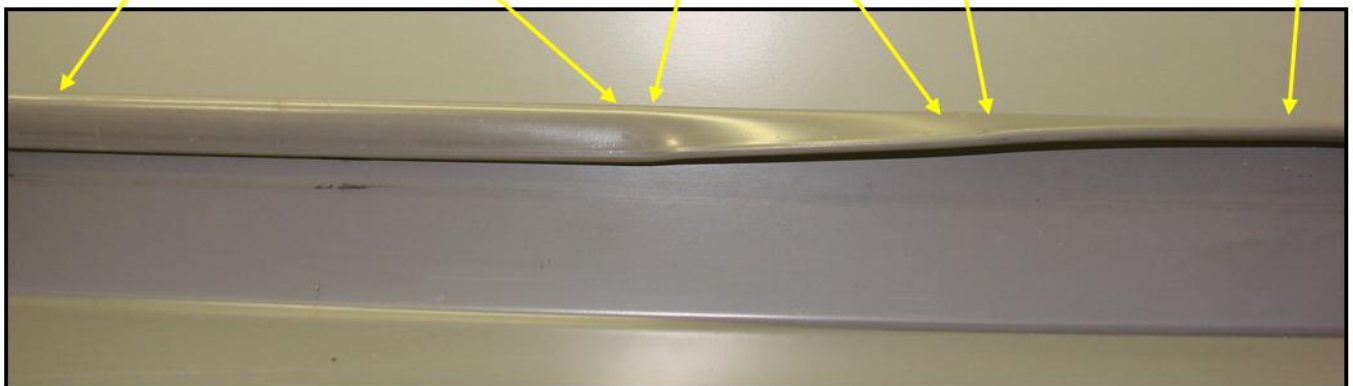
**Direction of travel** →



**Form this area  
with 90° hand tool,  
then use 180° hand tool**

**Transition area  
From 90° to 180°**

**Form this area  
with 90° hand tool**



# OPERATION

## STARTING A SEAM

1. Place switch in off position.
2. Place seamer with FIRST STAGE ONLY over seam.
3. Push lock handle down. (Tool must be in line with Micro-switch seated on top seam).
4. Now use JOG-SWITCH to get the entire tool onto the seam.
5. Turn switch ON. (Tool will now run by itself).
6. Before seamer reaches end of seam, turn OFF and finish seam by pressing JOG-SWITCH.

## JOG AND OVER-RIDE SWITCH

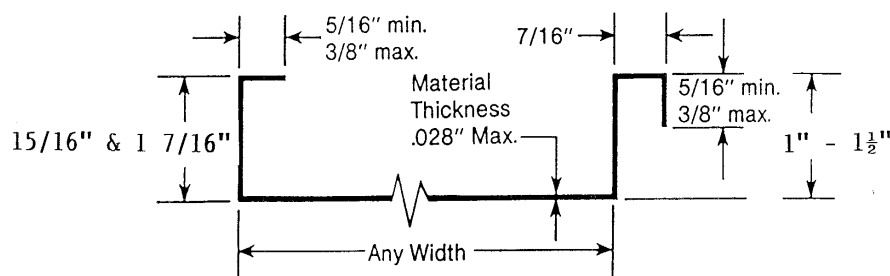
This switch will turn on the motor at any time without the micro-switch being depressed. It can also be used to operate the seamer for the full length of a seam.

## MICRO-SWITCH INFORMATION

1. This is a safety feature to prevent the tool from falling off a roof while operating unattended.
2. The micro-switch will also sense any "ride-up" of the seamer, sometimes caused by improperly formed pans or improperly laid down pans.
3. If a "ride-up" occurs, the micro-switch will cut the power to the tool so no damage will be done to the seam and material.
4. The seamer can be taken off the seam at any time during seaming by simply turning the switch to OFF and pulling the locking handle up. It can also be put back at the same position where it was taken off and started up again.

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**To assure the working of Model SSX Seamer, the pan must be manufactured to the dimensions shown in this sketch.**

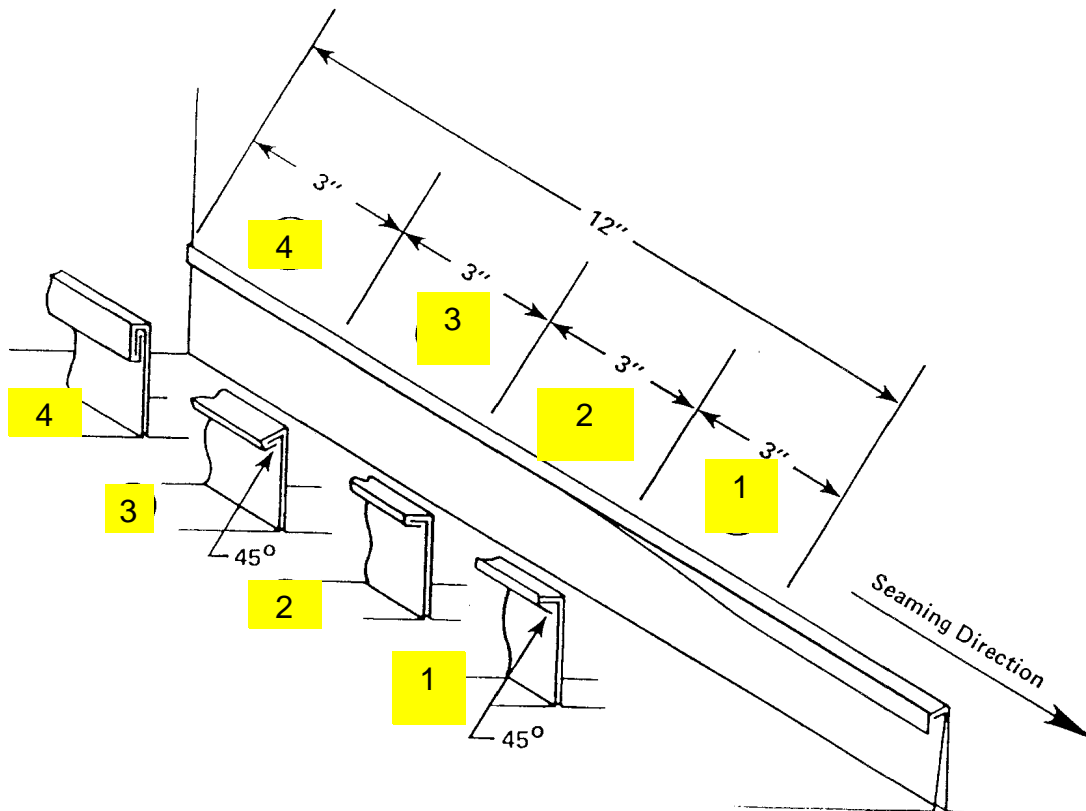


Cleat Thickness: .015 Inches Max.

To take advantage of the self-starting feature on your seamer the pan must be placed so that the open end of seam is on your right. Start your seam by placing the first stage of the seamer over seam. Lock seamer and start.

If the job does not permit you to place the pan in the proper direction prepare the first 12" of the seam with your skill and hand tools as shown in the sketch. Place seamer over prepared seam, lock seamer and start.

**\* It is important to note that if you remove the seamer from the panel before finishing you must lock the seamer back on the panel in the same positions of Stage 1, 2, 3, 4 as shown in sketch below.**



# SSX Seamer

## Wheel Adjustment

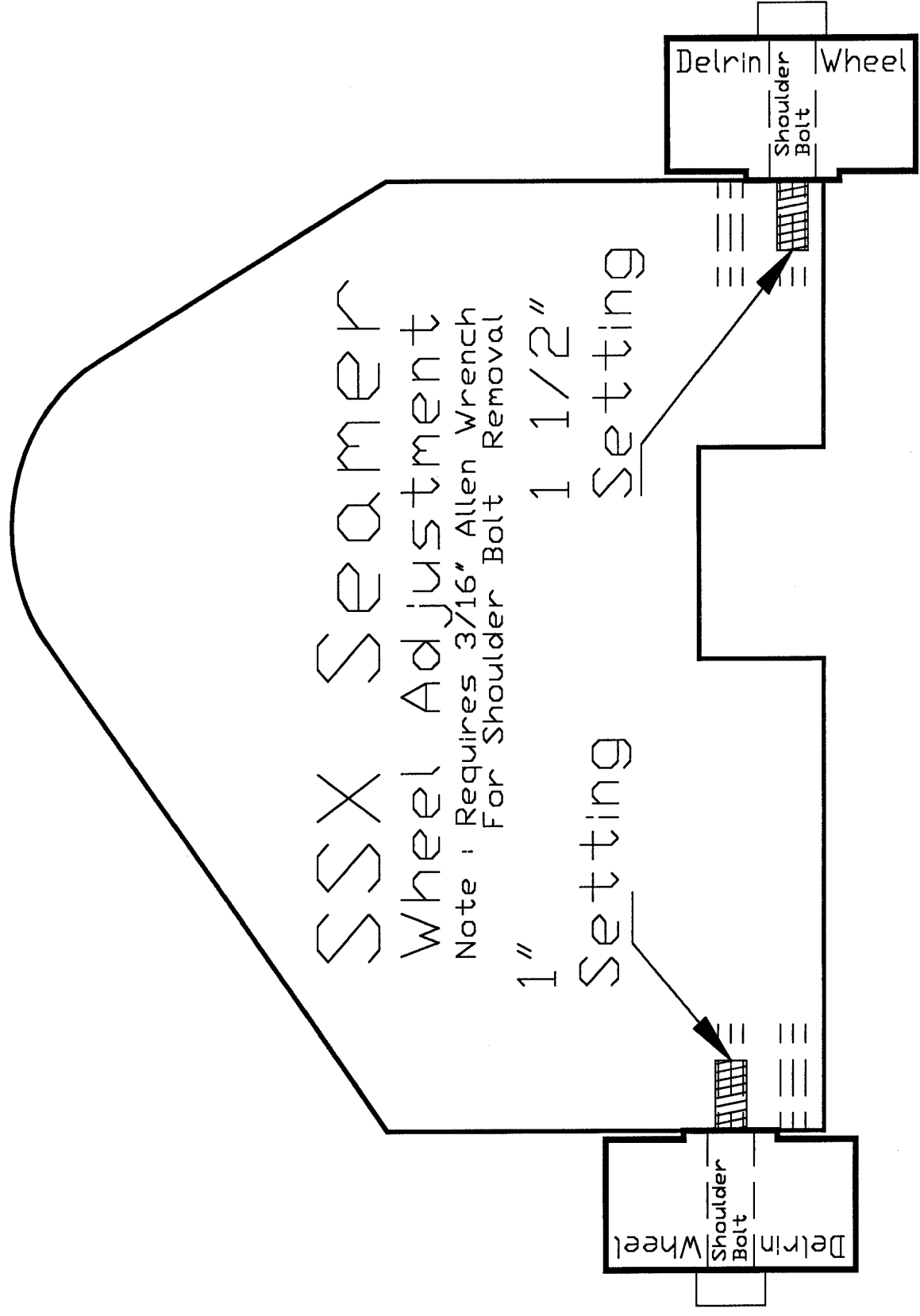
Note : Requires 3/16" Allen Wrench  
For Shoulder Bolt Removal

1"

Setting

1 1/2"

Setting



## **SPECIFICATIONS**

Seaming speed	30 ft. per min.*
Volts	110 - 125V
Amps	7.0
Weight	38 lbs.
*(no load speed)	

## **BRUSHES AND COMMUTATOR**

Failure of the motor to start or to operate efficiently can usually be attributed to worn or damaged brushes, brushes sticking in the holders and failing to make proper contact with the commutator, or the commutator being dirty and rough. Frequent inspection of the brushes and commutator is recommended. Replace the brushes when worn down to 1/4". Always replace both brushes at the same time.

## **LUBRICATION**

The inner drive mechanism of the SSX seamer is lubricated for life.

## **PLUGS AND EXTENSION CORDS**

The tool should be grounded while in use to protect the operator from electric shock. The tool is equipped with an approved three-prong grounding-type plug to fit the proper grounding-type receptacle.

Use only three-wire extension cords which have three-prong grounding type plugs and three-pole receptacles which accept the tools' plug.

As the distance of the supply outlet increases, heavier gauge extensions are required. The use of extension cords of inadequate size wire causes a serious drop in voltage, loss of power and possible motor damage.

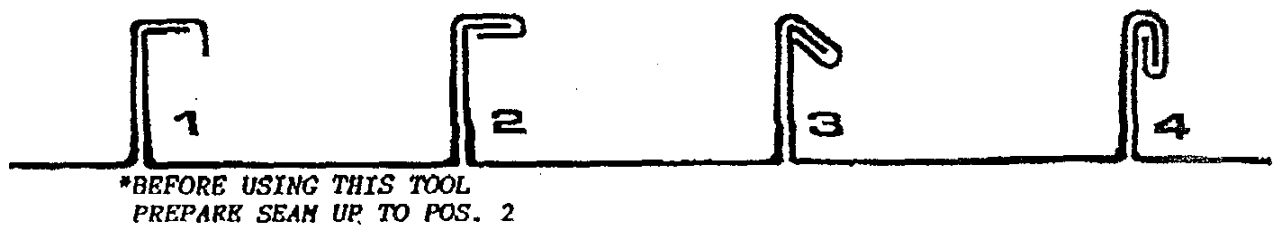
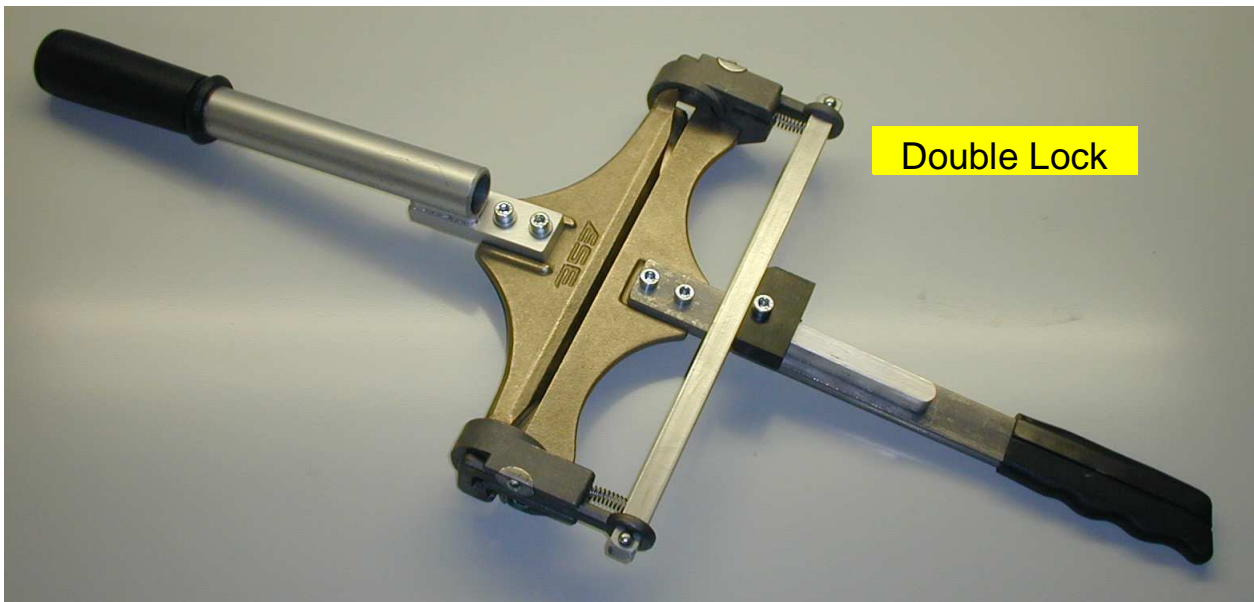
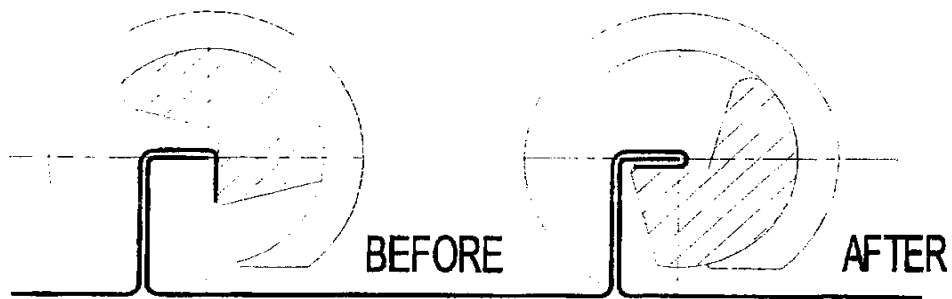
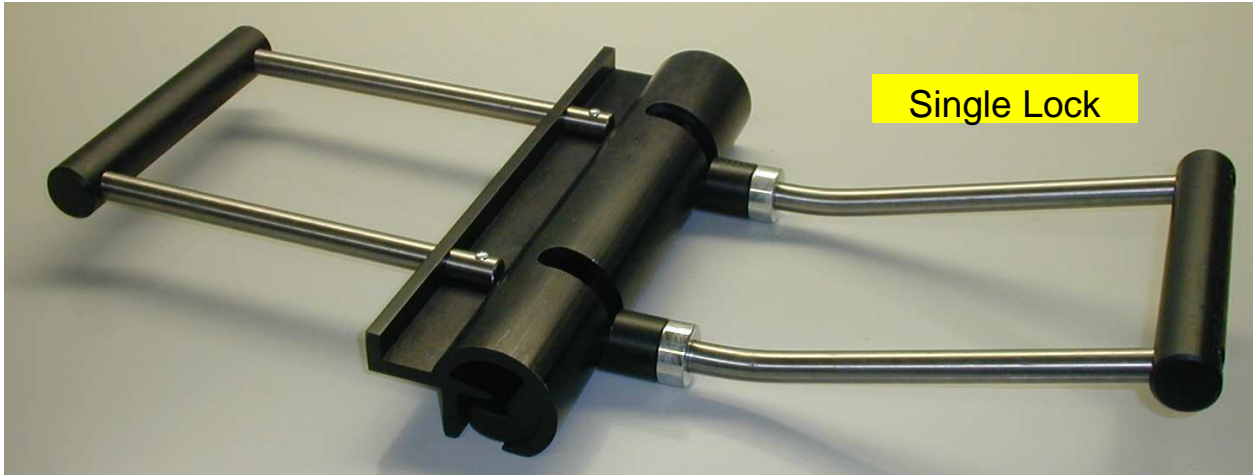
Extension Cable Length	Wire Size
25 ft.	18
50 ft.	16
75 ft.	14
150 ft	12
200 ft.	10

## **STANDARD EQUIPMENT WARRANTY**

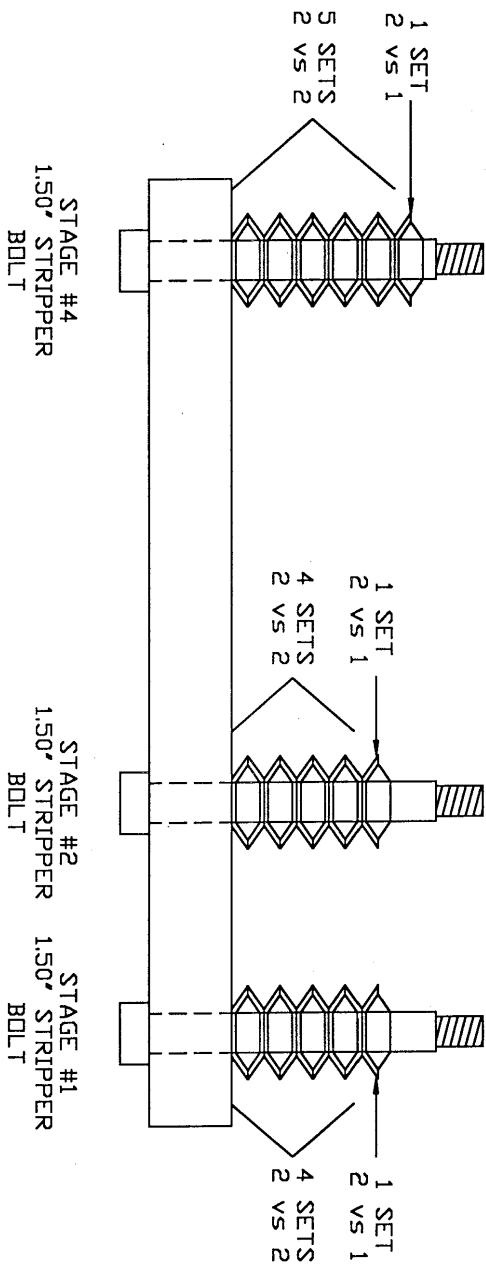
Roll Former Corporation warrants to the original purchaser that the equipment is free from defects in material and workmanship in normal use and service. Normal use and service does not extend to defects from mishandling, tampering or modifying the equipment.




## Hand Tools for 1-1½" Standing Seam



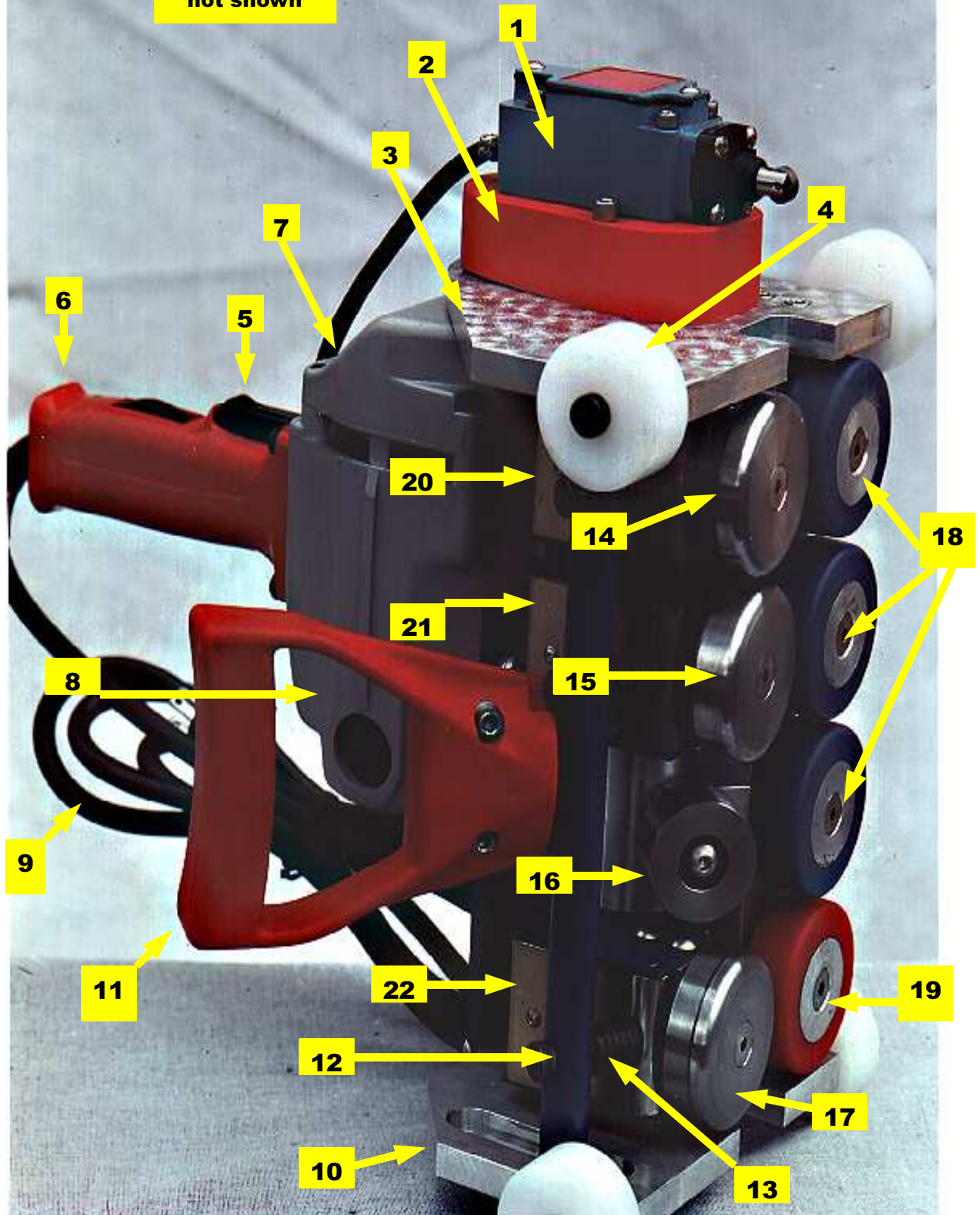
- NOTES:
1. TO TIGHTEN SEAM ADD (1) SET OF 1 vs 1 TO STAGE 4.



 <b>Roll Former Corporation</b> 2425 MARYLAND ROAD, WILLOW GROVE, PA 19090	
DRAWN BY: BROHAUER DATE: 10/28/87 APPROVAL: MATERIAL: QUANTITY: -	TOLERANCES UNLESS OTHER: FINE SPECIFIED: X = +/- XX = +/- XXX = +/- XXXX = +/- ANG = +/- MACHINE: SSX SEAMER SIZE: A SCALE: NONE SHEET: 1 OF 1
PART NAME: SPRING DISK ASSEMBLY PART NUMBER: -	

<b>SSX Seamer - Service Parts Breakdown</b>			
Item No.	Description	Quantity	Notes
1	Switch, Micro	(1x)	
2	Cover, Chain	(1x)	
3	Plate, Front	(1x)	
4	Wheel, Balance	(4x)	
5	Switch, Trigger	(1x)	
6	Handle, Switch, Trigger	(1x)	
7	Motor	(1x)	
8	Brushes, Motor	(2x)	
9	Cord, Power	(1x)	
10	Plate, Back	(1x)	
11	Handle, Spade	(1x)	
12	Shaft, Locking	(1x)	
13	Assembly, Spring Disk		See Detail
14	Stage #1 Forming Roll	(1x)	
15	Stage #2 Forming Roll	(1x)	
16	Stage #3 Forming Roll	(1x)	
17	Stage #4 Forming Roll	(1x)	
18	Stage #1,2 & 3 Friction Roll	(3x)	
19	Stage #4 Friction Roll	(1x)	
20	Stage #1 Movable Wing	(1x)	
21	Stage #2 Movable Wing	(1x)	
22	Stage #4 Movable Wing	(1x)	
23	Sprocket w/K'way, Drive, Bottom	(1x)	Not Shown
24	Sprocket (Threaded), Drive, Top	(1x)	Not Shown
25	Chain, Drive	(1x)	Not Shown
26	Shaft, Drive (With [4x] Worms)	(1x)	Not Shown
27	Spacer, Shaft, Drive, Front	(1x)	Not Shown
28	Spacer, Shaft, Drive, Rear	(1x)	Not Shown
29	Gears, Worm, Bronze	(7x)	Not Shown
30	Washers, Hardened, 0.063	(7x)	Not Shown
31	Bearings, 0.50 I.D. X 1.125 O.D.	(2x)	Not Shown
32	Washers, Thrust	(2x)	Not Shown
33	Bearing, Thrust	(1x)	Not Shown
34	Caps, End, Roll Shaft, Forming & Friction	(7x)	Not Shown
35	Bearings, Ball, Shaft	(2x)	Not Shown

23, 24, 25 are  
not shown



## 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.

## STANDARD EQUIPMENT WARRANTY

Roll Former Corporation warrants to the original purchaser that the equipment is free from defects in material and workmanship in normal use and service. Normal use and service does not extend to defects from mishandling, tampering or modifying the equipment.

The term of this warranty is for a period of ***ninety (90) days for the Seamer and three hundred and sixty five (365) days/one year (1) for all other Roll Forming Equipment from the date of the receipt of the equipment to the original purchaser.*** Roll Former Corporation shall repair or replace the defective parts at their place of business without charge to the original purchaser of the equipment.

The equipment subject to this warranty must first be returned to Roll Former Corporation with freight charges prepaid, which after examination by Roll Former Corporation shall disclose to its satisfaction to have been defective. Roll Former Corporation shall correct the defect and ship the prepaid equipment to the location of the purchaser's facility within the continental United States.

The foregoing warranties are in lieu of all other warranties expressed or implied, and of all obligation or liabilities on the part of Roll Former Corporation for breach of warranty.

Roll Former Corporation's sole liability for any breach of warranty shall be limited to the repair or replacement of any defective parts in the accordance with the above.

Roll Former Corporation's warranty does not extend to equipment that has been used under a lease or rental agreement from the original purchaser.

## CUSTOM EQUIPMENT - WARRANTY AND LIABILITY

Roll Former Corporation's liability for custom equipment prior to acceptance, is the amount of deposit from the customer. Roll Former warrants, after acceptance, **all custom equipment for a period of three hundred and sixty five (365) days/one year (1) from the date of the receipt of the equipment** to the original purchaser that the equipment is free from defects in material and workmanship in normal use and service.

The equipment subject to this warranty must first be returned to Roll Former Corporation with freight charges prepaid, which after examination by Roll Former Corporation shall disclose to its satisfaction to have been defective. Roll Former Corporation shall correct the defect and ship the prepaid equipment to the location of the purchaser's facility within the continental United States.

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Roll Former Corporation's sole liability for any breach of warranty shall be limited to the repair or replacement of any defective parts in the accordance with the above.

Warranty will not be available if any of the following occurs:

1. Mishandling - tampering or modifying equipment.
2. Leasing or renting equipment.