



**Before Operating Your Tools,
Please Read This Instruction Carefully**



Gear Drive Ring Roller

**ITEM NO.61-251-126
MODEL NO . #GRR1**

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Specifications

Ring Size Range:	Unlimited
Round Steel Capacity:	1/4"
Flat Steel Capacity:	1"×3/6"
Handle:	13-1/2"
Weight:	13-1/4 lbs.

⚠ Safety Warnings & Cautions

WARNING:

When using electric tools, machines or equipment, basic safety precautions should always be followed to reduce the risk of fire, electric shock, and personal injury.

- 1. KEEP WORK AREA CLEAN.**
Cluttered areas invite injuries.
- 2. CONSIDER WORK AREA CONDITIONS.**
Don't use in damp, wet, or poorly lit locations. Don't expose to rain. Keep work area well lit.
- 3. KEEP CHILDREN AWAY.**
All children should be kept away from the work area. Don't let them handle machine.
- 4. STORE IDLE EQUIPMENT.** When not in use, tools should be locked up in a dry location to inhibit rust. If possible, store in an area out of children.
- 5. DON'T FORCE THE MACHINE OR TOOL.**
It will do the job better and more safely at the rate for which it was intended.
- 6. USE THE RIGHT TOOL.**
Don't force a small tool or attachment to do the work of a larger industrial tool. Don't use a tool for a purpose for which it was not intended.
- 7. DRESS PROPERLY.**
Don't wear loose clothing or jewelry. They can be caught in moving parts. Protective gloves and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair, preventing it from getting caught in machinery.
- 8. USE EYE AND EAR PROTECTION.**
Use a full face mask if the work you're doing produces metal filings, dust or wood chips. Goggles are acceptable in other situations. Wear a clean dust mask if the work creates a lot of fine or coarse dust. When operating for extended periods of time, use approved ear protection. Safety goggles and ear protectors are available from distributor.
- 9. SECURE WORK.**
Use clamps or a vise to hold the work if possible. It's safer than using your hands and it frees both hands to operate the tool.
- 10. DON'T OVERREACH.**
Keep proper footing and balance at all times.
- 11. MAINTAIN TOOLS WITH CARE.**
Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Keep handles dry, clean, and free from oil and grease.
- 12. STAY ALERT.**
Watch what you are doing. Use common sense. Don't operate any tool when you are tired.

13. Check Damaged Parts.

Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and other conditions that may affect its operation. Any part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in the instruction manual.

14. Replacement Parts And Accessories.

When servicing, use only identical replacement parts. Only use accessories intended for use with this tool. Approved accessories are available from distributor.

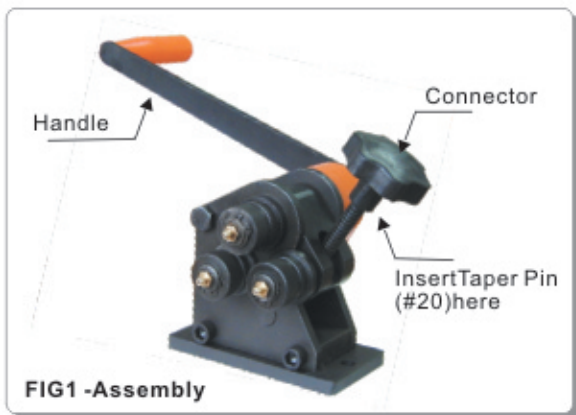
15. Do Not Operate Tool If Under The Influence Of Alcohol Or Drugs.

Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate machine.

UNPACKING

No.	Item Description	Qty.
NA	Planetary Ring Roller Assembly	1
15	Handle	1
19	Connector	1
20	8×28 Taper Pin	1

ASSEMBLY



Step 1: Slide the CONNECTOR(#19) onto the DRIVE SHAFT II (#17). Make sure the holes line up. See Fig 1

Step 2: Slide the HANDLE(#15) into the holes of the CONNECTOR and DRIVE SHAFT II.

Step 3: Attach the CONNECTOR to the DRIVE SHAFT II using the TAPER PIN(#20).

MOUNTING



Step 1: Set unit on the workbench at the desired location.

Step 2: Make sure that you can operate the handle comfortably.

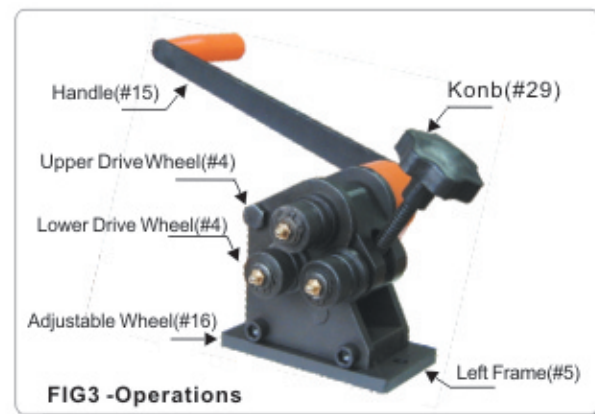
Step 3: Mark the workbench through the two holes in the BASE(#25) of the unit.

Step 4: Remove the unit

Step 5: Drill holes through the workbench at the marker locations

Step 6: Mount the unit using two bolts, lockwashers, washers, and nuts (in that order). Sold separately (See Figure 2).

Operations



Step 1: Determine the size ring you wish to obtain.

Step 2: Move the ADJUSTABLE WHEEL(#16) up or down (as desired) by turning the KNOB(#29), See Figure 3.

Step 3: To obtain 1? rings, the ADJUSTABLE WHEEL must be in its upper most position.

Step 4: To obtain 2? rings, the ADJUSTABLE WHEEL must be in the middle position.

- Step 5: To obtain larger rings the ADJUSTABLE WHEEL must be in the lowest position.
- Step 6: Insert the stock between the upper DRIVE WHEEL(#4) and both the ADJUSTABLE WHEEL and lower DRIVE WHEEL.
- Step 7: Turn the Knob clockwise to clamp the stock between the WHEELS.
- Step 8: Rotate the HANDLE(#15) counterclockwise to process the ring.
- Step 9: To remove completed rings, turn the KNOB counterclockwise to loosen the clamping action.

MAINTENANCE



- Step 1: After using, clean using a non-toxic solvent.
- Step 2: The three lubrication points are the DRIVE SHAFT I (#9), DRIVE SHAFT II (#17) and the ADJUSTABLE SHAFT (#18). Grease using the ZERK FITTINGS (#1).
- Step 3: Store in a dry area. out of reach of children. (See Figure 4)

PARTS LIST

PART#	DESCRIPTION	QTY
1	M 8× 1 Zerk Fitting	3
2	# 10 C-Ring	5
2A	# 22 C-Ring	1
3	M10×60 Hex Bolt	1
4	Drive Wheel	2
5	Left Frame	1
6	Copper Busning	2
7	Stang	1
8	Busing	1
9	Drive Shaft I	1
10	4×25 Key	4
11	Riant Frame	1
12	Gear	2
13	Cover	1
14	M6×45 Hex Kev Screw	1

PART#	DESCRIPTION	QTY
15	Handle	1
16	Adiustable Wheel	1
17	Drive Shaft II	1
18	Adiustable Shaft	1
19	Connector	1
20	8×28 Taber Pin	1
21	M10×60 Hex Kev Screw	2
22	Shaft(w/hoie)	1
23	M10×16 Hex Kev Screw	2
24	3×12 Pin	1
25	Base	1
26	Mounting Plate	1
27	Lead Scrow	1
28	M6×6 Locking Screw	1
29	Knob	1

PARTS DRAWING

